



SURCLEAN
Electronic Production Materials



TECHNICAL DATA SHEET

Surclean - Brightflow SPL-15 Tin/Lead Solder Paint

PRODUCT APPLICATION

Surclean SPL-15 Solder Paint is a homogenous mixture of fine powdered Tin/Lead alloy suspended in a highly active Zinc Chloride cream base. The cream base contains suspension agents that helps to prevent the metal from settling out, and avoids excessive stirring. SPL-15 is formulated to allow rapid joining and wetting of a wide variety of solderable metals, including mild steel. It is ideal for applications where the use of Tin/Lead solder alloys is permitted, and a lower melting point is desirable. The post solder residues are easily removed with water.

CHARACTERISTICS

Convenience & simplicity - separate solder and flux is eliminated, and area of wetting is accurately controlled as paint is applied exactly where required. This also economizes the use of material.

Fast Wetting and Jointing - Highly active flux and lower melting point of Tin/Lead alloys gives rapid processing.

Suitable for Mass Production - The soldering process can be mechanised for batch or series production. The process can be de-skilled as the flux to solder metal ratio is pre-mixed.

APPLICATION METHODS

Surclean SPL-15 is painted onto the metal covering any joints and over the area required to be tinned. Heat is applied until the paint becomes molten. The melting point of SPL-15 depends on which Tin/Lead alloy is selected. Sn/Pb 60/40, Sn/Pb 50/50, and Sn/Pb 40/60 Tin/lead alloys are stocked as standard products. The processing temperature should be typically 40 - 70 degrees C. above the alloy melting point. SPL-15 provides a bright and readily solderable surface for subsequent soldering assembly operations. SPL-15 should be applied by brush or swab to a cold workpiece surface. It should be stirred before use to ensure complete dispersion of the metal alloy in the base. Residues are corrosive if left, and must be removed with water, or a 1% HCL acid solution followed by a final rinse, preferably with warm water.

PACKAGING AVAILABILITY

SPL-15 is packaged into plastic screw top containers. Standard pack sizes are 250 gm, 500 gm, 1kg, 2kgs and 5 kgs. Larger pack sizes are available subject to availability.

PHYSICAL & CHEMICAL PROPERTIES

Appearance: Viscous cream gel. Colour: White - opaque. PH Value: 1 (Acidic)
Odour: None. Water solubility: 100%
Alloy melting points: Sn/Pb 60/40 - 188 deg. C Sn/Pb 50/50 - 211 deg. C Sn/Pb 40/40 - 235 deg. C

HEALTH & SAFETY

Surclean SPL-15 should be treated as a corrosive material. Take precautions to minimize risk of Splashing or spillage. SPL-15 contains Lead. Use suitable eye and skin personal protection equipment. Read the application notes in this technical data sheet, and refer to the safety data sheet for the product.