



SPECIFICATION

NAME : ALMIT GUMMIX-19 Sn60 P-2.5% Flux Cored Solder Wire

Lot No.	Marketing Name
	ALMIT GUMMIX-19 Sn60 Flux Content 2.5% Dia (mm): 0.65 0.8 1.0 1.2 1.6 2.0

NIHON ALMIT Co. Ltd.

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1. **Product Name:** Almit Gummix-19 Sn60 P-2.5%

2. **Scope:** This specification is specified for Almit flux cored solder wire.

Almit GUMMIX-19 Sn60 P-2.5%

Delivered by Nihon Almit Co, Ltd to Messrs. _____

3. **Chemical Composition: (wt. %) :**

Composition	Sn	Pb	Sb	Cu	Bi	Zn	Fe	Al	As	Cd
Standards	59.0/61.0	Bal	≤ 0.12	≤ 0.05	≤ 0.1	≤ 0.002	≤ 0.02	≤ 0.002	≤ 0.02	≤ 0.003

4. **Physical Properties :**

Solidus Degs C	Liquidus Degs C	Specific Gravity
183	190	8.5

5. **Characteristics:**

Items	Characteristics	Test Methods
Flux Content (%)	2.5 ± 0.5	JIS-Z-3197:1999
Chloride & Bromide	0	by Ionchromat-analyser
Insulation Resistance (Ω)	> 1 x 10 ⁸	JIS-Z-3197:1999 85°C/85% RH, 168hr
Spreadability (%)	> 80	JIS-Z-3197:1999
Cu Mirror Test	Pass	JIS-Z-3197:1999
Dryness	Chalk powder should be easily removed from each test piece	JIS-Z-3197:1999
Solution Resistance (Ω cm)	N/A	JIS-Z-3197:1999
Flux Type	M1	J-STD-0004

6. **Dimension: Mass & allowances are as follows.**

Diameter in mm						Weight of one roll (Kg. Nett)	
0.65	0.8	1	1.2	1.6	2	0.8	1
± 0.05						+ 0.01 - 0	

Note: 0.65 Dia Contains 0.8 Kg Rest 1.0 Kg.

7. **Construction of one Lot:**

A lot contains 500 Kgs which is the amount of a single melting.

8. Quality & Inspection:

Test No.	Test Items	Estimation Results
1	Crack	Usable State
2	Smear	Usable State
3	Luster	Usable State
4	Size (mm)	0.65, 0.8, 1.0, 1.2, 1.6, 2.0. +/- 0.05
5	Weight (Kg.Nett)	0.8, 1.0, + 0.01 - 0
6	Sn (%)	59~61
7	Pb and Impurities	Rest
8	Flux Content (%)	2.5 ± 0.5
9	Chloride content in flux	Zero (by Ionchromat Analyser)
10	Solution Resistance (Ω cm)	-
11	Insulating Resistance (Ω)	> 1 x 10 ⁸
12	Spreadability	> 80

9. Test Method: The tests are carried out in accordance with Specification JIS-Z-3197. (Test Method of Rosin Flux for Soldering)

10. Packaging:

Individual Package		Outer Package	
Unit	Packing	Unit	Packing
0.8, 1.0 Kg	Plastic Bag	8, 10 Kg	Cardboard

11. Identification:

Roll		Cardboard	
Name	Almit GUMMIX-19	Name	Almit GUMMIX-19
Weight	(Ex. Nett 1 Kg)	Weight (Nett)	(Ex. Nett 10 Kg)
Lot No.	(Ex. 92.1.10)	Lot No.	(Ex. 92.1.10)
Sn Content	Sn60	Sn Content	Sn60
Flux Content (2.5)	2.5	Flux Content (%)	2.5
Size	mm Dia	Size	mm Dia
Maker	Nihon Almit Co.Ltd.	Maker	Nihon Almit Co.Ltd.

12. Maker Address:

Nihon Almit Co. Ltd.
Miyata Bldg. 6F, 1 - 38, Yoyogi, Shibuya-ku, Tokyo, 151, JAPAN.

13. Changes to this specification must be approved by:-

Signed _____ Date _____

14. This product is manufactured from guaranteed materials according to the " LAW ON INSPECTION AND MANUFACTURING OF CHEMICAL SUBSTANCES"

End