

# NC209AXT NO CLEAN CORED WIRE

#### **FEATURES**

- Olear, Hard Residues
- Halide-Free
- Cleanable with Saponifier
- REL0 per J-STD-004

#### DESCRIPTION

NC209AXT is a no-clean resin-based flux cored wire formulated to promote thermal transfer, fast wetting and low fumes. NC209AXT cored wire produces low-to-medium post-process residues that do not require cleaning. NC209AXT can be used as a drop-in for any RMA type applications.

## STANDARD AVAILABILITY

NC209AXT Cored Wire is available in Sn/Pb, Sn/Cu, SAC and SN100C<sup>®</sup> alloys. Other alloys, diameters and spool sizes may be available upon request.

Diameter	Spool Size
.010	<sup>1</sup> ⁄2 lb.
.015	<sup>1</sup> ⁄2 lb.
.020	1 lb.
.032	1 lb.
.040	1 lb.
.050	1 lb.
.062	1 lb.



#### **APPLICATION**

Best results are obtained with solder iron tip temperature between  $300^{\circ} - 400^{\circ}C$  (575° - 750°F) for leaded alloys and  $370^{\circ} - 425^{\circ}C$  (700° - 800°F) for lead-free alloys. If additional flux is required AIM NC280 flux is recommended.

## HANDLING & STORAGE

Time	Temperature
Indefinite	Proper Storage Conditions

Store cored wire in a clean, dry area away from moisture and sunlight. Do not freeze this product.

#### **CLEANING**

NC209AXT can be cleaned with saponified wash and many commercially available flux removers. Contact AIM for specific information.

#### **SAFETY**

Use with adequate ventilation and proper personal protective equipment. Refer to the accompanying Safety Data Sheet for any specific emergency information. Do not dispose of any hazardous materials in non-approved containers.

> Document Rev # NF1 Page 1 of 2

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# **TECHNICAL DATA SHEET**



# **TEST DATA SUMMARY**

Name	Test Method	Results	
IPC Flux Classification	J-STD-004		RELO
Name	Test Method	Results	Image
Copper Mirror	J-STD-004B 3.4.1.1 IPC-TM-650 2.3.32	LOW	209AXT 31185 CONTROL
Corrosion	J-STD-004B 3.4.1.2 IPC-TM-650 2.6.15	PASS	Before After
Qualitative Halides, Silver Chromate	J-STD-004B 3.5.1.1 IPC-TM-650 2.3.33	PASS	
Qualitative Halides, Fluoride Spot	J-STD-004B 3.5.1.2 IPC-TM-650 2.3.35.1	PASS	
Surface Insulation Resistance	J-STD-004B 3.4.1.4 IPC-TM-650 2.6.3.7	PASS	Time, day CW209ANT SAC305 1A CW209ANT SAC305 3A CW209ANT SAC305
Flux Solids, Nonvolatile Determination	J-STD-004B 3.4.2.1 IPC-TM-650 2.3.34	100% Typical	
Acid Value Determination	J-STD-004B 3.4.2.2 IPC-TM-650 2.3.13	141mg KOH / g Flux Typical	
Visual	J-STD-004B 3.4.2.5	Beige Solid	
Wetting	J-STD-005A 3.9 IPC-TM-650 2.4.45	PASS	

Document Rev # NF1 Page 2 of 2

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