

STANDARDS	EN ISO 3677/1995.....	B-Cu36AgZnSn 630/730
	Abrégé	AG 106
	DIN 8513	L-Ag 34 Sn
	ISO 17672 : 2016	Ag 134

MANUFACTURING SPECIFICATIONS COMPARED TO STANDARD / ISO

Standard values	ISO 17672 : 2016 - Tolerances							STANDARDS
	Ag	Cu	Zn	Sn	Si	Ni	Cd	Code
Composition %	33,0<>35,00	35,0<>37,0	25,5<>29,5	2,0<>3,0	0,05<>0,25			Ag 134Si
Dimensions	Diameter : Extrusion +/- 0,3 mm Drawing +/- 3 % – Length +/- 5 mm							

Indicative values of the manufacturing specification / Alliages Industries

Specification Values 534SnECF	ALLIAGES INDUSTRIES - Tolerances							Spec AI
	Ag	Cu	Zn	Sn	Si	Ni	Cd	Code
Composition %	33,0<>35,00	35,0<>37,0	25,5<>29,5	2,0<>3,0	0,05<>0,25			534SnECF
Dimensions	Diameter : Extrusion +/- 0,2 mm Drawing +/- 3 % – Length +/- 5 mm – Coating : 0,15 mm							

Standard chemically tested in the laboratory in accordance with the ISO 17672 standard.
Excluding dimensional tolerances for products not covered by the standard.

PHYSICAL PROPERTIES Rm MPa /mm² 20°C 460
 A % 20°C 25
 Melting interval 630 - 730 °C
 Density..... 8,7

Silicon stabilized alloy, no bubbling. Without Degassing

Manufacturing method Direct extrusion, alloy and flux coating.

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 TDS TO DOWNLOAD ON THE [TDS section](#)

COATING QUALITIES : CF / ECONOMIC AND BORIC ACID FREE RATIO 70/30
SF / STANDARD AND BORIC ACID FREE RATIO 76/24
RF / STANDARD AND BORIC ACID FREE RATIO 85/15
MF / MINI-FLUX AND BORIC ACID FREE RATIO 90/10
XF / EXTRA-FINE FLUX AND BORIC ACID FREE RATIO 95/05

CB / ECONOMIC AND WITH BORIC ACID
SB / STANDARD AND WITH BORIC ACID
MB / MINI-FLUX AND WITH BORIC ACID
XB / EXTRA-FINE FLUX WITH BORIC ACID

CLEANING

The potassium salts contained in the SF, RF, MF, XF coating (Boric acid free) are 99.99% dissolved by washing in a very hot alkaline solution used in baths (regularly drained). Dilute abundantly with water. Collect liquids with an absorbent material. It is possible to neutralize these salts with a solution of sodium carbonate diluted 1/5. In this case, do not close hermetically during the operation.

In the event of insufficient removal, these salts remain on the parts, causing whitish stains.

These salts are stable, so there is no hydrolysis and no risk of galvanic corrosion by formation of an electric current

NB: For a lower presence of residues, change to a thinner coating reference such as XF

REGLEMENTATION	CLP (1272/2008)	: <u>Compliant</u>
	Reach	: <u>Compliant</u>
	RoHS/CERoHS	: <u>Compliant</u>
	DESP	: <u>Compliant</u>
	GHS (2007-2011)	: <u>Compliant</u>
	ErP-2009	: <u>Compliant</u>
	Todd Frank	: Complies with this date. (see top of page)