



# TECHNICAL DATA SHEET

CATEGORY: **ROSIN ACTIVATED CORED WIRE**  
NAME: **RA WIRE**

## FEATURES

- HIGH ACTIVITY LEVEL
- FULLY ACTIVATED FLUX
- IMPROVED WETTING PROPERTIES
- GLYCOL FREE
- GOOD THERMAL TRANSFER

\* Meets QQS-571-E Specification and Applicable IPC-J-STD-004 and -006 Requirements.

## DESCRIPTION

**AIM RA WIRE** is a fully activated, general-purpose wire solder for use in applications where mildly activated fluxes are too weak. RA cored wire is strong enough for excellent tarnish and oxide removal, and will produce bright shiny solder joints. RA wire will leave slight to moderate post process residues that may be left on non-critical applications, but should be removed from any critical applications. RA cored wire meets Mil-Spec cleanliness requirements post-cleaning.

## HANDLING

- RA cored wire has an indefinite shelf life when proper storage conditions are observed.
- Store product in a clean dry area away from moisture and sunlight. Do not freeze this product.

## APPLICATION

- Solder iron tip temperature should be between 650° and 750°F for Sn63, Sn62 and Sn60 alloys, 700° - 800°F for Sn/Ag and Sn/Ag/Cu alloys and 650° to 700°F for Sn43/Pb43/Bi14.
- Hold the solder iron at a 45° to 60° angle to the work surface.
- The solder iron should contact both the component lead and PCB pad surface.
- Solder and flux should flow onto both the lead and pad or lead and barrel to promote optimum flux activity to the joint being worked.

## CLEANING

- If post-process cleaning is desired, is easiest if performed within a two to three hour period.
- Adequate cleaning may be accomplished using a saponifier. AIMTERGE-520A is recommended.
- A temperature of 100°-150°F is sufficient for removing residues. An in-line or other pressurized spray cleaning system is suggested, but is not required.

## PACKAGING

- RA WIRE comes standard with a 3% flux core. Other flux cores %'s are available upon request.
- RA WIRE is available in Sn60, Sn62, Sn63, Sn96, CASTIN® and other custom alloys upon request.
- Standard spool sizes: ½ lb. for .010 and .015 diameters; 1 lb. for .020, .032, .040, .050, and .062 diameters. Other spool sizes and wire diameters are available upon special request.
- Packaging of ½ lb. and 1 lb. spools is standard in 12 lb. and 24 lb. cases.

## SAFETY

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