

Reference Bulletin

Filling a wave solder machine with Lead-Free solder

This document refers to the procedure that should be used when refilling a wave solder machine that has previously been filled with a Lead (Pb) containing alloy with Lead-Free alloy.

- 1 Remove the pumps, wave guides and flow ducts from the solder bath.
- 2 Drain the Sn/Pb material from the solder bath.
- 3 Clean the solder bath, removing all of the visible deposits of Sn/Pb alloy. Suitable respiratory protective equipment, safety glasses/visor and gloves must be worn.
- 4 Clean the pumps, wave guides, flow ducts - using the same procedure as above.
- 5 Load the wave pot with pure Tin (Available in chunks and bar).
- 6 Re-assemble the pumps, wave guides and flow ducts.
- 7 Take pot temperature to 260 Celcius and switch on the chip and main waves, allow the metal to circulate for 30 minutes this will remove any remaining Lead contamination from the pot.
- 8 Drain the Tin wash from the wave pot.
- 9 Load the Lead Free solder in the same way as above and take a sample of the pot to establish a baseline composition.

The pure Tin material used for the pot wash and a solder pot analysis service is available from Cookson Electronics Assembly Materials. Please contact your local office for details.

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