

INTERNATIONAL STANDARD

NORME INTERNATIONALE

**Environmental testing –
Part 2-20: Tests – Tests Ta and Tb: Test methods for solderability and
resistance to soldering heat of devices with leads**

**Essais d'environnement –
Partie 2-20: Essais – Essais Ta et Tb. Méthodes d'essai de la brasabilité
et de la résistance à la chaleur de brasure des dispositifs à broches**



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CONTENTS

FOREWORD	4
1 Scope	6
2 Normative references	6
3 Terms and definitions	6
4 Test Ta: Solderability of wire and tag terminations	8
4.1 Objective and general description of the test	8
4.1.1 Test methods	8
4.1.2 Specimen preparation	8
4.1.3 Initial measurements	9
4.1.4 Preconditioning	9
4.2 Method 1: Solder bath	10
4.2.1 General	10
4.2.2 Description of the solder bath	10
4.2.3 Flux	10
4.2.4 Procedure	10
4.2.5 Test conditions	11
4.2.6 Final measurements and requirements	11
4.3 Method 2: Soldering iron at 350 °C	11
4.3.1 General	11
4.3.2 Description of soldering irons	11
4.3.3 Solder and flux	12
4.3.4 Procedure	12
4.3.5 Final measurements and requirements	13
4.4 Information to be given in the relevant specification	13
5 Test Tb: Resistance to soldering heat	14
5.1 Objective and general description of the test	14
5.1.1 Test methods	14
5.1.2 Initial measurements	14
5.2 Method 1: Solder bath	14
5.2.1 Description of the solder bath	14
5.2.2 Flux	14
5.2.3 Procedure	14
5.2.4 Test conditions	15
5.2.5 De-wetting	15
5.3 Method 2: Soldering iron	16
5.3.1 Description of soldering iron	16
5.3.2 Solder and flux	16
5.3.3 Procedure	16
5.4 Recovery	16
5.5 Final measurements and requirements	16
5.6 De-wetting (if required)	16
5.7 Information to be given in the relevant specification	17
Annex A (informative) Example of apparatus for steam conditioning process	18
Annex B (normative) Specification for flux constituents	19
B.1 Colophony	19
B.2 2-propanol (isopropyl alcohol)	19

B.3 Ethyl alcohol	19
B.4 Flux composition.....	19
Bibliography.....	21
Figure 1 – Diagram of contact angle	7
Figure 2 – Position of soldering iron.....	12
Figure A.1 – Example of apparatus	18
Table 1 – Solderability, solder bath method: Test severities (duration and temperature)	11
Table 2 – Resistance to soldering heat, solder bath method: Test severities (duration and temperature)	15
Table B.1 – Colophony based flux compositions	20

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

ENVIRONMENTAL TESTING –

**Part 2-20: Tests –
Tests Ta and Tb: Test methods for solderability
and resistance to soldering heat of devices with leads**

FOREWORD

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IEC 60068-2-20 has been prepared by IEC technical committee 91: Electronics assembly technology. This is an International Standard.

This sixth edition cancels and replaces the fifth edition published in 2008. This sixth edition constitutes a technical revision.

This edition includes the following significant technical changes with respect to the previous edition:

- a) update of and clarification of pre-conditioning (former "aging") and its relation to natural aging.

The text of this International Standard is based on the following documents:

Draft	Report on voting
91/1701/FDIS	91/1711/RVD

Full information on the voting for its approval can be found in the report on voting indicated in the above table.

The language used for the development of this International Standard is English.

This document was drafted in accordance with ISO/IEC Directives, Part 2, and developed in accordance with ISO/IEC Directives, Part 1 and ISO/IEC Directives, IEC Supplement, available at www.iec.ch/members_experts/refdocs. The main document types developed by IEC are described in greater detail at www.iec.ch/standardsdev/publications.

A list of all the parts in the IEC 60068 series, under the general title *Environmental testing*, can be found on the IEC website.

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ENVIRONMENTAL TESTING –

Part 2-20: Tests – Tests Ta and Tb: Test methods for solderability and resistance to soldering heat of devices with leads

1 Scope

This part of IEC 60068 outlines Tests Ta and Tb, applicable to devices with leads and leads themselves. Soldering tests for surface mounting devices (SMD) are described in IEC 60068-2-58.

This document provides procedures for determining the solderability and resistance to soldering heat of devices in applications using solder alloys, which are eutectic or near eutectic tin lead (Pb), or lead-free alloys.

The procedures in this document include the solder bath method and soldering iron method.

The objective of this document is to ensure that component lead or termination solderability meets the applicable solder joint requirements of IEC 61191-3 and IEC 61191-4. In addition, test methods are provided to ensure that the component body can be resistant to the heat load to which it is exposed during soldering.

NOTE Information about wetting time and wetting force can be obtained by test methods using a wetting balance. IEC 60068-2-69 (solder bath and solder globule method) can be consulted.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60068-1, *Environmental testing – Part 1: General and guidance*

IEC 60068-2-2, *Environmental testing – Part 2-2: Tests – Test B: Dry heat*

IEC 60068-2-6, *Environmental testing – Part 2: Test methods – Test Cx: Damp heat, steady state (unsaturated pressurized vapour)*

IEC 60068-2-78, *Environmental testing – Part 2-78: Tests – Test Cab: Damp heat, steady state*

IEC 61191-3, *Printed board assemblies – Part 3: Sectional specification – Requirements for through-hole mount soldered assemblies*

IEC 61191-4, *Printed board assemblies – Part 4: Sectional specification – Requirements for terminal soldered assemblies*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.