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JOINT INDUSTRY STANDARD

Solderability Tests for Printed Boards

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Solderability Tests for Printed Boards

Developed by the Printed Circuit Board Solderability Specifications Task Group (5-23a) of the Assembly and Joining Committee (5-20) of IPC

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Table of Contents

1 GENERAL ... 1
1.1 Scope ... 1
1.2 Purpose ... 1
1.3 Objective ... 1
1.3.1 Definition of Requirements ... 1
1.3.2 Document Hierarchy ... 1
1.4 Classification ... 1
1.5 Test Method Classification ... 2
1.5.1 Visual Acceptance Criteria Tests ... 2
1.5.2 Force Measurement Criteria Tests ... 2
1.6 Test Method Selection ... 2
1.6.1 New Surface Finishes Not Covered in 6010 or by 4500 Series Documents ... 2
1.7 Test Specimen Requirements ... 2
1.8 Coating Durability – SnPb Containing (HASL and Plated and Reflowed SnPb) Surface Finishes ... 3
1.9 Coating Durability – Non-SnPb Surface Finishes ... 4

2 APPLICABLE DOCUMENTS ... 5
2.1 Industry ... 5
2.1.1 IPC ... 5
2.2 Joint Industry Standards ... 5

3 REQUIREMENTS ... 5
3.1 Terms and Definitions ... 5
3.1.1 Contact Angle, Soldering* ... 5
3.1.2 Dewetting* ... 5
3.1.3 Dissolution of Component Metallization (Leaching)* ... 5
3.1.4 Equilibrium Wetting ... 5
3.1.5 Nonwetting, Solder* ... 5
3.1.6 Pinhole* ... 5
3.1.7 Solderability* ... 5
3.1.8 Solder Connection Pinhole* ... 5
3.1.9 Wetting, Solder* ... 5
3.2 Materials ... 6
3.2.1 Solder ... 6
3.2.2 Flux ... 6
3.2.3 Flux Removal ... 6
3.3 Equipment ... 6
3.3.1 Pre-Conditioning Equipment ... 6
3.3.2 Solder Pot/Bath ... 6
3.3.3 Optical Inspection Equipment ... 7
3.3.4 Dipping Equipment ... 7
3.3.5 Timing Equipment ... 7
3.4 Preparation for Testing ... 7
3.4.1 Test Specimen Preparation and Conditioning for Test ... 7
3.4.2 Pretest Conditioning ... 7
3.4.3 Steam Preconditioning Apparatus ... 7
3.4.4 Steam Conditioning ... 8
3.4.5 Baking ... 8
3.5 Solder Bath Requirements ... 8
3.5.1 Solder Temperatures ... 8
3.5.2 Solder Contamination Control ... 8

4 TEST PROCEDURES ... 9
4.1 Test Procedure Limitations ... 9
4.1.1 Application of Flux ... 9
4.2 Tests with Established Accept/Reject Criteria ... 9
4.2.1 Edge Dip Test ... 9
4.2.2 Wave Solder Test: ... 12
4.2.3 Surface Mount Simulation Test ... 13
4.3 Tests with Force Measurement Criteria ... 15
4.3.1 Wetting Balance Test ... 15
4.4 6010 Solder Float Test ... 18
4.4.1 Solder Float Test Tin/Lead Solder ... 18
4.4.2 Apparatus ... 18
4.4.3 Evaluation ... 19

5 EVALUATION AIDS ... 20
5.1 Evaluation Aids – Surface ... 20
5.2 Evaluation Aids – For Class 3 PTHs ... 21

6 NOTES ... 22
6.1 Correction for Buoyancy ... 22
6.2 Preheat ... 22
6.3 Prebaking ... 22
6.4 Safety Note ... 22
6.5 Use of Nonactivated Flux ... 22
6.6 Solder Contact ... 22

APPENDIX A Calculation of Maximum Theoretical Force for a Rectangular Cross-Section ... 23

APPENDIX B Calculation of Area under the Wetting Curve ... 25

APPENDIX C Informative Annex ... 26

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APPENDIX D Test Protocol for Wetting Balance Gauge Repeatability and Reproducibility (G R&R) Using Copper Foil Coupons 28

APPENDIX E J-STD-002/J-STD-003 Activated Solderability Test Flux Rationale Committee Letter 30

Figures

Figure 3-1 Contact Angle 5
Figure 3-2 Example Reticle 7
Figure 4-1 Edge Dip Solderability Test 10
Figure 4-2 Legacy S-Coupon Test Specimen for PTHs 10
Figure 4-3 New S-Coupon Layout (mm [in]) 11
Figure 4-4 Suggested Test Specimen for Surface Mount Features 12
Figure 4-5 Effectiveness of Solder Wetting of Plated-Through Holes – Class 3 below 3.0 mm 13
Figure 4-6 Examples of Solder Wetting of PTHs – Class 3 below 3.0 mm 14
Figure 4-7 Arrangement for the Test Apparatus (Solder Bath Wetting Balance Method) 15
Figure 4-8 Arrangement for the Test Apparatus (Solder Globule Wetting Balance Method) 15
Figure 4-9 Suggested Wetting Balance and Soldering Immersion Test Specimens 16
Figure 4-10 Wetting Balance Test Soldering Immersion at 90° for Double Sided Finishes 16
Figure 4-11 Wetting Balance Test Soldering Immersion at 20 to 40° for Single Sided Coupons/ Samples Removed from Printed Boards 16
Figure 4-12 Set A Wetting Curve 18
Figure 4-13 Set B Wetting Curve 18
Figure 5-1 I Sn Surface Finish Showing Uniform Wetting 20
Figure 5-2 I Sn Surface Finish Showing Chronic Dewetting 20
Figure 5-3 ENIG Exhibiting Nonwetting 20
Figure 5-4 ENIG Exhibiting Nonwetting 20
Figure 5-5 ENIG Exhibiting Dewetting 21
Figure 5-6 ENIG Exhibiting Dewetting 21
Figure 5-7 HASL Surface Finish after Wetting Balance Testing, showing Excellent Wetting and Positive Advancement of Solder 21

Tables

Table 1-1 Solderability Test Method Selection 3
Table 1-2 Final Finish Conditioning/ Stress Testing for Category 3 Coating Durability[a] 4
Table 3-1 Flux Composition 6
Table 3-2 Steam Temperature Requirements 7
Table 3-3 Maximum Limits of Solder Bath Contaminant 9
Table 4-1 Stencil Thickness Requirements 14
Table 4-2 Reflow Parameter Requirements – SnPb 14
Table 4-3 Lead-Free Reflow Parameter Requirements 15
Table 4-4 Pass/Fail Criteria for Specific Surface Finishes Using Eutectic SnPb 17
Table 4-5 Pass/Fail Criteria for Specific Surface Finishes Using SAC305 Solder 17
Table 4-6 Wetting Balance Parameter and Suggested Criteria 18
Table E-1 Flux Compositions 30

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Solderability Tests for Printed Boards

1 GENERAL

1.1 Scope This standard prescribes test methods, defect definitions, and illustrations for assessing the solderability of printed wiring board surface conductors, attachment lands, and plated-through holes (PTHs). This standard is intended for use by both user and supplier.

This standard is not intended to verify the potential of successful processing at assembly or to evaluate design impact on wettability. This standard describes procedures or methods to determine the acceptable wettability of a surface finish. Wettability can be affected by handling, finish application, and environmental conditions.

1.2 Purpose This standard describes solderability determinations that are made to verify that the printed board fabrication processes and subsequent storage have had no adverse effect on the solderability of those portions of the printed board intended to be soldered. Reference coupons or representative portions of a printed board may be used. Solderability is determined by evaluation of a test specimen which has been processed as part of a panel of boards and subsequently removed for testing per the method selected.

1.3 Objective To provide solderability test methods to determine the acceptance of printed board surface conductors, attachment lands, and PTHs to wet easily with solder, and to withstand the rigors of the printed board assembly processes.

1.3.1 Definition of Requirements The word ''**shall**'' is used in the text of this document wherever there is a requirement for materials, preparation, process control, or acceptance of a soldered connection or a test method. The word ''should'' reflects ''best processing techniques'' and is used to reflect general industry practices and a suggestion for guidance only.

1.3.2 Document Hierarchy In the event of conflict, the following descending order of precedence applies:

a. Procurement documentation AABUS, which should include expected shelf life requirements if stored and handled properly.
b. Master drawing or master assembly drawing reflecting the user's detailed requirements.
c. When required by the customer or per contractual agreement, this document, J-STD-003.
d. Other documents, to the extent specified by the customer.

1.4 Classification Three general classes have been established to reflect progressive increases in sophistication, functional performance requirements, and testing/inspection frequency as defined in the IPC-6010 series of documents.

The user is responsible for defining the product class. The product class should be stated in the procurement documentation package.

CLASS 1 General Electronic Products
Includes products suitable for applications where the major requirement is function of the completed assembly.

CLASS 2 Dedicated Service Electronic Products
Includes products where continued performance and extended life is required, and for which uninterrupted service is desired but not critical. Typically the end-use environment would not cause failures.

CLASS 3 High Performance Electronic Products
Includes products where continued high performance or performance-on-demand is critical, equipment downtime cannot be tolerated, end-use environment may be uncommonly harsh, and the equipment must function when required, such as life support or other critical systems.

Printed board performance classes do not dictate the surface finish durability rating that may be specified. Category 2/Category A durability is the default coating durability rating.

This standard relies on input from the 4-14 plating process subcommittee and the 4500 series of printed board surface finish documents generated in that subcommittee to determine the durability rating potential for each specified finish. This document and the appropriate 4500 series document should be considered complimentary to one another.

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