

# ALPHA<sup>®</sup> EXACTALLOY<sup>®</sup> PREFORMS

## Lead-free Low Temperature Collar/Sleeve

### DESCRIPTION

ALPHA Lead-Free, Low Temperature Collar/Sleeves provide a unique ability to deliver a precise amount of solder volume which ensures the construction of a solder joint with a high degree of consistency from interconnection to interconnection. The lead-free, low temperature sleeve provides an alternative to the traditional 50Sn/30Pb/18Cd or other low temperature lead-bearing alloys. It features 42Sn/58Bi alloy, a true eutectic alloy that makes visual indication of the solder operation more precise.

The preform collar is delivered with an external flux coating. The DRF1-L0 flux coating is Alpha's most resilient flux coating. The durable flux coating reduces customer line maintenance and provides the most consistent flux coating from preform to preform. With precise control over the solder and flux volume, an extremely repeatable and reliable solder joint is formed.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

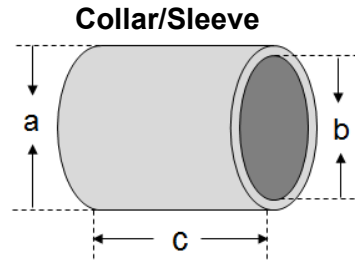
### FEATURES AND BENEFITS

#### Features

- Low-temperature eutectic alloy (138 °C) for better visual indication of the solder joint
- Wide range of sizes (outer diameter, inner diameter, and length)
- Durable external flux coating

#### Benefits

- Precise flux activity level and flux volume appropriate for surfaces to be soldered
- Durable flux coating significantly reduces customer line maintenance caused by excessive flaking
- Ability to solder temperature-sensitive components

**PRODUCT INFORMATION**


Tolerances: OD =  $\pm 0.10\text{mm}$  ( $\pm 0.004''$ ); ID =  $\pm 0.25\text{mm}$  ( $\pm 0.010''$ ); Length =  $\pm 0.25\text{mm}$  ( $\pm 0.010''$ )

A = Outside Diameter	B = Inside Diameter	C = Length
Min. = 2.70mm (0.106")	Min. = 1.78mm (0.071")	Min. = 2.00mm (0.079")
Max. = 12.00mm (0.472")	Max. = 11.00mm (0.433")	Max. = 9.00mm (0.354")

Sizes vary based upon aspect ratios of height, outside diameter, and wall thickness. The wall thickness starts at 5% of the height with a minimum of 0.25mm (0.010")

**APPLICATION GUIDELINES**

ALPHA Exactalloy Preform Collar/Sleeves are used for connector and cable assembly. Solder collars are commonly integrated with heat shrink tubing to provide a sealed solder connection between two cables in a wire harness. Solder sleeves are also often used to terminate a coaxial cable conductor at a connector pin to provide a more reliable assembly. Precise solder volume control allows for a very repeatable solder joint.

The preforms are provided with an external flux coating. The flux activity level is ROL0 and was specifically designed for wire/cable assemblies.

**TECHNICAL DATA**

Standard	Alloy Designation		Melting Temperature Ranges (°C)
J-STD-006B	Low-Temp	58Sn42Bi	138

Standard	Flux Type	Flux Classification
J-STD-004	DRF1-L0	ROL0

**RECYCLING SERVICES**

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



**SAFETY & WARNING**

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at [MacdermidAlpha.com/assembly-solutions/knowledge-base](http://MacdermidAlpha.com/assembly-solutions/knowledge-base).**

**STORAGE**

Collars are packaged in segmented trays to prevent damage caused by normal shipping and handling processes.

The shelf life of the product varies by alloy. Consult the Alpha Assembly Storage Recommendations for Solder Preforms technical bulletin for more information on storage and shelf life recommendations.

**CONTACT INFORMATION**

**To confirm this document is the most recent version, please contact  
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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