



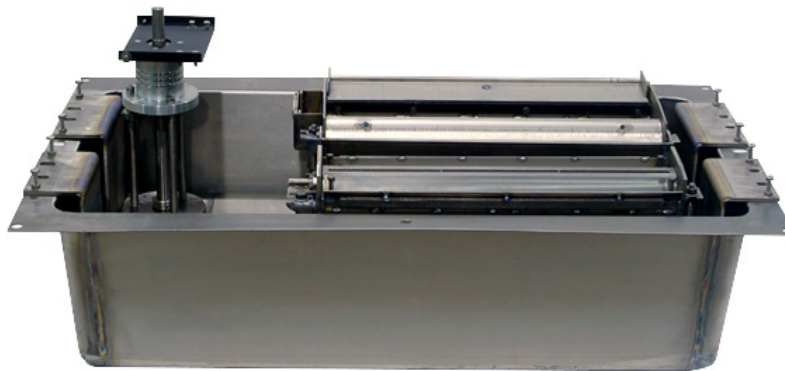
**SPECNOR TECNIC**  
SERVING THE ELECTRONICS MANUFACTURING INDUSTRY

## LEAD-FREE RETROFIT KIT

### WAVE SOLDERING KIT

The Lead-Free Retrofit Kit is a cost effective solution to upgrade an existing wave soldering machine for lead-free operation without the cost of purchasing a new machine or replacing the entire solder pot.

Made of all titanium construction, it is highly resistant to the corrosive effects of lead-free solders and affords significantly improved longevity compared to surface coated alternatives. Winner of the coveted 2005 SMT Vision Award, the innovative Lead-Free Retrofit Kit is compatible with all major brands of wave soldering machines and can be easily installed with minimum downtime.



### FEATURES

- Eliminates iron and copper dissolution associated with uncoated stainless steel or cast iron solder pots
- Offers consistent performance and eliminates periodic replacement of wear parts such as impellers, flow ducts and solder nozzles
- Impervious to de-dross scratching that can damage surface coated metal parts
- Fully optimized solder flow for lead-free operation and compatible with all lead-free and tin-lead solder alloys
- Can be installed in all popular models of wave solder machines and field retrofitted without exchanging the solder pot
- Competitively priced compared to surface coated alternatives



## SPECIFICATIONS

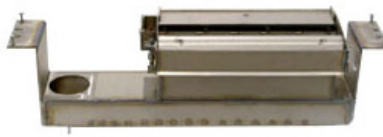
### SOLDER POT LINER

Full titanium construction  
Easily inserted into existing pot



### LAMINAR WAVE ASSEMBLY

Full titanium construction  
Laminar wave nozzle



### CHIP WAVE ASSEMBLY

Full titanium construction  
Chip wave nozzle



## COMPATIBILITY

The Retro-Fit kit is compatible with all lead-free solder alloys

### CHARACTERISTICS OF LEAD-FREE ALLOYS

SOLDER ALLOY	MELTING POINT	SOLDER POT TEMP.	DENSITY
SnCu	227°C	270-280°C	7.29
SnAg	221°C	265-275°C	7.44
SnAgCu	217°C	260-270°C	7.38
SnAgCuSb	217°C	260°C	7.24
SnPb	183°C	250°C	8.80

## LONGEVITY

The Titanium Retro-Fit kit is long lasting and very resistant

### SUMMARY OF BASE METALS

MATERIAL	ADVANTAGES	DISADVANTAGES	LONGEVITY*
Titanium	Excellent resistance to effects of tin	Can be expensive to fabricate	10 years
304 stainless steel	Inexpensive	No corrosion resistance	1 month
316 stainless steel	Inexpensive	No corrosion resistance	3-6 months
Surface coated stainless steel	Good resistance to effects of tin	Will degrade if scratched	6-12 months
Surface coated cast iron	Inexpensive	Will degrade if scratched	1-2 years

\* Under sustained production conditions with SAC 305 lead-free solder alloy

## INCLUDED IN RETROFIT KIT

- Titanium solder pot liner
- Titanium impellers
- Titanium solder pump assemblies
- Titanium solder nozzles
- Titanium flow ducts
- Temperature switches
- Solder level sensors

\*All other parts in contact with molten solder are made of titanium

\*All specifications are subject to change without notice.

## CONTACT US

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