

## **Instructions for use**

### **SUR - TIN**

#### **electroless surface tinning**

##### **Mixing:**

For security reasons, please do not vary the following mixing procedure:

- 1.) Take a jug of at least 3 l capacity and
- 2.) fill in 2 liters of warm water (best: 50 degrees centigrade)
- 3.) Mix Sur-Tin part 1 into that water. (Be careful: part 1 is acid and aggressive)
- 4.) Keep on stirring and fill in Part 2 till Part 2 is solved
- 5.) Fill in part 3 and keep on stirring till everything is solved

##### **Storage:**

The ready to use liquid may be stored for several months in a closed bottle at a temperature not below 20 degrees centigrade. But do not forget to mark the bottle carefully

##### **Usage:**

- 6.) Stir the liquid carefully before usage
- 7.) remove all oxides, grease + colour coatings that remain on the copper surface with chemicals or steel wool)
- 8.) Rinse sufficient with water and dry (rub) carefully with paper tissue
- 9.) Dip the board in SUR-Tin for 2-3 minutes. After that, you will have achieved approx. 5 µm tin on the copper surface. Longer tinning procedure has no influence on the tin thickness
- 10) Finally, clean the tinned surface carefully with fresh, warm water
- 11) Solderability is best immediately after tinning
- 12) If the tinned surface is oxidised after a few days, repeat step 7-9 if necessary for soldering.

These instructions are based on laboratory test. Technical alterations are subject to change without notice.