

STANDARD DRAWING

THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE FOR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.				USED ON ASS'Y. NO.	DATE	
TMC PART NUMBER		DIAMETER (INCHES)	TIN	MATERIAL LEAD	OTHER	MELTING RANGE SOLID (APR) LIQUID (APP)
BS100-032	0.032	59.5 -	37.6 -	0.2 - 0.9 %	360° F	375° F
BS100-062	0.062	61.5 %	40.3 %	0.2 - 0.9 %	360° F	460° F
BS100-2-032	0.032	39.5 -	57.6 -	0.2 - 0.9 %	360° F	460° F
BS100-2-062	0.062	41.5 %	60.3 %	0.2 - 0.9 %	360° F	460° F

C

SPECIFICATIONS

FORM: WIRE
 TYPE: ROSIN CORE-ACTIVATED
 CORE CONDITION: PLASTIC SIZE 2
 FLUX: ROSIN CORE PER LLL-R-626 CLASS A,
 TYPE II, GRADE WW 2.2% ± 0.4% BY WEIGHT.
 DIAMETER: SEE CHART ± 5% OR ± 0.002",
 WHICHEVER IS GREATER.
 FEDERAL SPEC: QQ-S-571, TYPE S-60WRAP2.
 RECOMMENDED USES: BS100-032, PRINTED WIRING
 BOARDS; MINIATURE CONNECTORS.
 BS100-062, GENERAL PURPOSE

C	P/N CHART & SPECS. REVISED	4-18-66	16103	VHO	JCB	REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
B	P/N CHART APP. SPECS REVISED	12-7-64	13060	AP	JCB			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
A	REF TO ALPHA METALS, INC. & MODEL DELETED	7-9-63	9504	JAY	JCB				
	RE-DRAWN No REV	10/20/62	*	RH	JCB			SOLDER, SOFT	
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	MATERIAL	WIRE, LEAD-TIN ALLOY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES									
DECIMALS: X ± .05, XX ± .01, XXX ± .005									
TOLERANCES: FRACTIONS ± 1/64 ANGLES ± 0° 30'									
CODE S401-216									
						TYPE & TEMPER HEAT TREAT. SPEC.		FINISH & SPEC. NO.	
						DRAWN		ELEC. DES. APP. MECH. DES. APP.	
						CHECKED		FINAL APPROVAL	
						RH		BS 100	

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IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

	USED ON			
MODEL	PROJECT NO.	ASSY. NO.	DATE	

TMC PART NO.	BS-101-1	BS-101-2	BS-101-3	BS-101-4			
Trade Name.	Silbond	Siltite	Silco	Silflux			
Melt Temp.	1121° F	1250° F	1335° F	Flux			
Flow Temp.	1146° F	1370° F	1390° F	-			
Composition.	45% Ag 15% Cu 16% Zn 24% Cd	45% Ag 30% Cu 25% Zn	70% Ag 20% Cu 10% Zn				

REQ. ITEM	PART NO.	DESCRIPTION		SYMBOL					
		STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK					
		MATERIAL	WEIGHT PER PC.	SOLDER, SILVER					
ISSUE ITEM	CHANGED FROM	TYPE & TEMPER	DRAWN	ELEC. DES. APP.	MECH. DES. APP.				
A	2	ADDED CODE NO. S401-218	7-10-63	9503	11.				
-A	1	DELETED UNITED WIRECO. REF	4/8/54	1	FAIR				
		TOLERANCES	SCALE S401-218						
ALL OTHERS	DEC. DIM. ±	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.		CHECKED	FINAL APPROVAL				
	FRAC. DIM. ±			FAIR	BS-101				
	ANGULAR DIM. ±			ELEC. DES. APP.	MECH. DES. APP.				
				DRAWN	WOT				
				HEAT TREAT. SPEC.	FINISH & SPEC. NO.				
				FINISH & SPEC. NO.	A				

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CONTENT : 60% TIN, 40% LEAD
 FLUX : NONE
 SEAM : 1/16"

BS-102

USED ON

MODEL	PROJECT NO.	ASSY. NO.	DATE
KS-85-X	J-227		8-20-53

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
	STOCK SIZE	SOLDER, SOFT	
	MATERIAL	W/O RESIN CORE	
	WEIGHT PER PC.		
	TYPE & TEMPER		
	DRAFTS CHECKER	ELEC. DES. APP.	MECH. DES. APP.
	HEAT TREAT. SPEC.	CHECKED	FINAL APPROVAL
	FINISH & SPEC. NO.		BS-102

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
A 1	CONTENT WAS 60% TIRP, 40% LEAD	5-3-63	6939	SPH	WFB
TOLERANCES					
SCALE					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
ALL OTHERS	DEC. DIM. ±	FRAC. DIM. ±	ANGULAR DIM. ±		

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TRADE NAME: HANDY FLUX

MELT. TEMP: 800°F

FLOW TEMP: 1100°-1600°F

SPECIFICATION: USN51F4A, AAC 1131GA,
USA. 4-1121

BS-103

USED ON

MODEL PROJECT NO. ASSY. NO. DATE

KS-85-X J-227 8-20-53

REF: HANDY & HARMON CO.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
STOCK SIZE		FLUX, SILVER SOLDER	
MATERIAL	WEIGHT PER PC.		
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			
ISSUE ITEM	CHANGED FROM	DATE	CN. NO. DRAFTS CHECKER ENG. APP.
TOLERANCES			
SCALE			
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.			
DEC. DIM. ±			
FRAC. DIM. ±			
ANGULAR DIM. ±			
ALL OTHERS			
			FINAL APPROVAL
			BS-103

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NUMBER: EUTEC-TIN WELD NO. 1
 COMPOSITION: Sn50 (PER QQ-S-571)
 FORM: PASTE
 TYPE: COMBINED WITH FLUX
 MELTING RANGE: 360 TO 420°F
 FOR USE WITH: ALL METALS EXCEPT ALUMINUM & MAGNESIUM
 STANDARD PACKAGE: CAN

BS-104 A

USED ON

MODEL

PROJECT NO.

ASSY. NO.

DATE

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		SOLDER, PASTE	
		STOCK SIZE	
		MATERIAL	
		WEIGHT PER PC.	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	
		DRAWN	
		ELEC. DES. APP.	
		MECH. DES. APP.	
		CHECKED	
		FINAL APPROVAL	

A 2	5401-268 ADD. SPECS. ADD	8464	12031	JTB	R	X
ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
			SCALE S401-268			
TOLERANCES						
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.						
DEC. DIM. ±						
FRAC. DIM. ±						
ANGULAR DIM. ±						

