
**Connectors for electronic equipment - Tests and measurement - Part 12-7:
Soldering tests - Test 12g: Solderability, wetting balance method (IEC 60512-12-7:2001)**

Connectors for electronic equipment - Tests and measurements -- Part 12-7: Soldering tests - Test 12g: Solderability, wetting balance method

Steckverbinder für elektronische Einrichtungen - Mess- und Prüfverfahren -- Teil 12-7: Prüfungen der Lötbarkeit - Prüfung 12g: Lötbarkeit, Lötwaage-Verfahren

Connecteurs pour équipements électroniques - Essais et mesures -- Partie 12-7: Essais de soudure - Essai 12g: Soudabilité, méthode de la balance de mouillage

Ta slovenski standard je istoveten z: EN 60512-12-7:2001

ICS:

31.220.10 Xcã ã Ácã } ã Æ [] ^ ç !ã Plug-and-socket devices.
Connectors

SIST EN 60512-12-7:2002**en**

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EUROPEAN STANDARD

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English version

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This European Standard was approved by CENELEC on 2001-05-01. CENELEC members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CENELEC member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CENELEC member into its own language and notified to the Central Secretariat has the same status as the official versions.

CENELEC members are the national electrotechnical committees of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CENELEC

European Committee for Electrotechnical Standardization
Comité Européen de Normalisation Electrotechnique
Europäisches Komitee für Elektrotechnische Normung

Central Secretariat: rue de Stassart 35, B - 1050 Brussels

Foreword

The text of document 48B/975/FDIS, future edition 1 of IEC 60512-12-7, prepared by SC 48B, Connectors, of IEC TC 48, Electromechanical components and mechanical structures for electronic equipment, was submitted to the IEC-CENELEC parallel vote and was approved by CENELEC as EN 60512-12-7 on 2001-05-01.

The following dates were fixed:

- latest date by which the EN has to be implemented at national level by publication of an identical national standard or by endorsement (dop) 2002-02-01
- latest date by which the national standards conflicting with the EN have to be withdrawn (dow) 2004-05-01

Annexes designated "normative" are part of the body of the standard.
In this standard, annex ZA is normative.
Annex ZA has been added by CENELEC.

Endorsement notice

The text of the International Standard IEC 60512-12-7:2001 was approved by CENELEC as a European Standard without any modification.

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CONNECTORS FOR ELECTRONIC EQUIPMENT – TESTS AND MEASUREMENTS –

Part 12-7: Soldering tests – Test 12g: Solderability, wetting balance method

1 Scope and object

This part of IEC 60512, when required by the detail specification, is to be used for testing connectors within the scope of IEC technical committee 48. This test may also be used for similar components when specified in a detail specification.

The object of this test is to define a standard test method to assess the solderability of the terminations of a component designed for use with printed boards or for other applications using similar soldering techniques.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of IEC 60512. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of IEC 60512 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of IEC and ISO maintain registers of currently valid International Standards.

IEC 60068-2-20:1979, *Environmental testing - Part 2-20: Tests - Test T: Soldering*

IEC 60068-2-54:1985, *Environmental testing - Part 2-54: Tests - Test Ta: Soldering – Solderability testing by the wetting balance method*

3 Preparation of the specimen

The specimen shall consist of a single termination of a component. Unless otherwise specified in the detail specification, the terminations may not be cleaned or degreased prior to the application of the solderability test.

Care should be taken not to touch or otherwise contaminate the terminations to be tested.

4 Procedure

The test shall be carried out in accordance with test Ta of IEC 60068-2-54.

4.1 Accelerated ageing

If accelerated ageing prior to testing solderability is to be applied, one of the ageing procedures detailed in 4.5 of IEC 60068-2-20 shall be prescribed in the detail specification.

4.2 Flux

Non-activated flux as specified in Appendix C of IEC 60068-2-20 shall be used.

Activation with diethylammonium is not permitted.

5 Final measurement

Recording of the force-time curve.

6 Requirements

The acceptable values of the different parameters prescribed in the detail specification shall be fulfilled.

7 Details to be specified

When this test is required by the detail specification, the following details shall be specified:

- a) preparation of the specimen, if deviating from clause 3;
- b) accelerated ageing method, according to 4.1;
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- c) immersion depth;
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- d) duration of immersion;
- e) number of specimens to be tested;
- f) minimum wetting force;
- g) time interval for the minimum wetting force;
- h) further parameters from the force-time curve and their acceptable values, if required;
- i) any deviation from the standard test method.

Annex ZA (normative)

Normative references to international publications with their corresponding European publications

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

NOTE When an international publication has been modified by common modifications, indicated by (mod), the relevant EN/HD applies.

| <u>Publication</u> | <u>Year</u> | <u>Title</u> | <u>EN/HD</u> | <u>Year</u> |
|--------------------|-------------|--|------------------------------|-------------|
| IEC 60068-2-20 | 1979 | Basic environmental testing procedures Part 2: Tests - Test T: Soldering | HD 323.2.20 S3 ¹⁾ | 1988 |
| IEC 60068-2-54 | 1985 | Part 2: Tests - Test TA: Soldering - Solderability testing by the wetting balance method | HD 323.2.54 S1 | 1987 |

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¹⁾ HD 323.2.20 S3 includes A2:1987 to IEC 60068-2-20.