

# JIS

## JAPANESE INDUSTRIAL STANDARD

### Methods for Sampling of Precious Brazing Filler Metals

#### JIS Z 3900-1974

(Reaffirmed 1987)

Translation without guarantee  
In the event of any doubt arising, the original  
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Translated

by

Japanese Standards Association

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1. Scope

This Japanese Industrial Standard specifies the methods of sampling and preparation of test samples for chemical analysis of such brazing filler metals as of gold, silver, phosphor-copper and palladium.

2. Sampling Method of Test Sample

2.1 The test sample shall be taken at the time of melting and casting of metals in a manufacturer's factory, and one test sample shall be taken from each molten metal. In the case where sampling from the product is carried out by the orderer or user, it shall always be conducted in the presence of the manufacturer, and the procedure thereon shall be determined by agreement.

2.2 The sampling method of test samples shall be in accordance with one of the following taking into account the content rate of precious metal elements or the like.

- (1) Dipper sampling and boring method (a part of silver, phosphor-copper and palladium brazing filler metals)
- (2) Dipper sampling and shot method (a part of silver brazing filler metal which contains high silver content ratio, excluding the metal which contains tin)
- (3) Dipper sampling and wrought method (a part of gold and palladium brazing filler metals)

3. Sample Preparation Method3.1 Dipper Sampling and Boring Method

- (1) Dipper Sampling Method As to melting and casting of various kinds of brazing filler metals, take out the crucible which contains molten metal, after removing carefully the slog and the like, agitate sufficiently with a preheated stirring rod, and pour the metal into each mould.

In this process, protrude quickly a small crucible being preheated at the same temperature as that of the molten metal, at an approximately intermittent point of flow of molten metal, dip out sample metal, pour into the mould<sup>(1)</sup> for test sample to make a test sample ingot, and return the residual molten metal to the original crucible.

Note <sup>(1)</sup> The mould for test sample shall, as a rule, be as follows:

Unit: mm

| Type | Internal dimension |        |       |
|------|--------------------|--------|-------|
|      | Width              | Length | Depth |
| A    | 20                 | 20     | 20    |
| B    | 15                 | 40     | 17    |

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Applicable Standard:

JIS A 8801-Testing Method of Vibrating Rollers

Reference Standard:

JIS M 8104-Method for Sampling of Crude Bullion