

### ■ General Description

ELFLUX 1004 NC is a solvent-based, halide-free, organic no-clean flux for use in automatic wave soldering. ELFLUX 1004 NC is low in solids and is free from rosin. The flux leaves practically no residues and cleaning is in general not necessary.

The residues on the board are not tacky. Electronic in-circuit-testing is possible without causing any problems. High surface insulation resistance values can be achieved by virtue of the low solid content of ELFLUX 1004 NC

### ■ Areas of Use

General surface-mount technology.

### ■ Classification

ELFLUX 1004 NC is classified as ORLO per DIN EN 61190-1-1 and per IPC ANSI/J-STD-004

### ■ Technical Specification

	ELFLUX 1004 NC	Thinner 200
Appearance	Clear, transparent liquid	Clear, transparent liquid
Smell	Mild, alcoholic	Mild, alcoholic
Density [g/cm <sup>3</sup> ] (20°C)	0.790 ± 0.003	0.785 ± 0.003
Solids content [%] (per IPC-TM-650 2.3.34)	2.0	none
VOC content [%]	> 90, Solvent-based	100, Solvent-based
Acid number [mg KOH/g Flux]	16 ± 1	< 1
Halides [%]	None	None
Flash point [°C]	12	12
Ignition temperature [°C]	399	399
Recommended thinner	Thinner 200	

### ■ Application

ELFLUX 1004 NC can be applied by spraying

ELFLUX 1004 NC has been developed in particular for soldering under inert atmosphere. When selecting the appropriate process parameters, however, it can also be used in open systems. Please respect the guidelines of the equipment maker and the requirements of the printed circuit board when setting the process parameters.

The optimum preheating temperature for most PCBs is 120 – 140 °C as measured at the bottom side of the PCB.

### ■ Process control

When processing the flux in a spray fluxer from a closed system it is normally not required to control the density or acid number of the flux.

### ■ Packing Sizes

ELFLUX 1004 NC is available in containers of 10 L / 20 L

### ■ Cleaning

Cleaning of the boards: ELFLUX 1004 NC is a no-clean flux. Generally, cleaning is not required.

## ■ General Safety Precautions

ELFLUX 1004 NC should be used according to industrial standards of practice. For safety advice please refer to the material safety data sheet.

## ■ Storage

ELFLUX 1004 NC is flammable. Store away from sources of ignition. Storage temperature: 5-20 °C.

## ■ Shelf-Life

Under adequate conditions ELFLUX 1004 NC can be stored in original unopened containers for a minimum of 12 months.

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