

### ■ Product Description

Ready-to-use, halide-free, rosin-based fluxes for general use in the electrical and electronic industry. The fluxes are available with various solid content configurations and are classified as 1.1.3 per DIN EN 29454-1 or ROLO per DIN EN 91190-1-1.

The fluxes can be applied by foaming, spraying, brushing or dipping.

### ■ Flux Properties

Flux Type ->	110	177	252	356
Solid Content	6,2%	45%	17%	17%
Thinner	200	202	200	200
Gravity @ 20° C [g/cm <sup>3</sup> ]	0,799	0,905	0,838	0,838
Acid Number (mg KOH / g Flux)	27 ± 2	107 ± 6	49 ± 3	53 ± 3
Flash Point	13°C	13°C	15°C	13°C
Class	1.1.3 per DIN EN 29454 – ROLO per DIN EN 61190-1-1 (J-STD-004)			
Corrosion	None (per DIN EN ISO 9455-12)			
Halides	None			
Appearance	Uniformly clear, yellowish brown			
Application	Foam flux activated without addition of halides. Low solid content for machine soldering of printed circuit boards.	Special flux with high solid content for general applications in electronics. For cases where Type 1.1.1 fluxes do no longer provide sufficient activity.	Foam flux activated without addition of halides. Medium solid content for machine soldering of printed circuit boards.	For drag, dip, and wave soldering of printed circuit boards.

The flux residues do not tend to chip off. Removing the residues is normally not required. The residues are not corrosive, are insulating, and can remain on the solder joint. If cleaning is nevertheless required the residues can be easily and completely removed with commercially available cleaners (please ask for references).

The fluxes also remain clear during longer periods of storage.

### ■ Process Control

No particular control is required in case of closed fluxing systems. In case of open systems it is important to control the solid content in order to achieve consistently good soldering results. Chemical titrations the most reliable method. Automatic density control is sufficient for the fluxes with high solid content.

### ■ Pack Sizes

The above-listed fluxes – as well as the respective thinners – are available in 10L / 20 L containers.

### ■ General Safety Information

The fluxes should be used according to industrial standards of practice. For safety advice please refer to the relevant material safety data sheets.

### ■ Storage

These solvent-based fluxes are flammable. Store away from sources of ignition. Observe a temperature range of 5 – 25 °C.

### ■ Shelf-Life

Under adequate conditions these fluxes can be stored in original unopened containers for a minimum of 12 months.

The information contained herein is based on technical data that we believe to be reliable and is intended for use by persons having technical skill, at their own risk. Users of our products should make their own tests to determine the suitability of each product for their particular process. ELSOLD will assume no liability for results obtained or damages incurred through the application of the data presented..