

EO-F-002 (EO-FOAM-FLUX)

Cat.- no. 6461 (MULTI-FLUX)

Flux for wave and selective soldering processes with halide-free activators.

ISO 9454: 2231 (2.2.3.A)

DIN-EN 61190-1-1 (according to J-STD-004) ORL0

WEEE /RoHS-compliant



EO-F-002 was developed for wave, selective, dip and hand soldering processes as well as cable assembly. The application can be carried out by all usual application methods (including foam fluxes). The solids content is 2.7%.

In practice, it has been shown that, when used properly, the washing of the circuit boards soldered with this flux can largely be dispensed with. Needle adapters IC testing is usually unaffected and easily done.

Technical specifications:

| | |
|-----------------------------------|---|
| Appearance: | Colorless-light yellow, clear liquid |
| Solids content: | 2.6 - 2.8% |
| Density at 20 ° C: | 0.84 - 0.86 g / ml |
| Activity (Acid value SZ): | 21-24 mg KOH / g |
| Activators: | (di-) carboxylic acids - resin complex |
| Solvent: | Formulation of alcohols and ester compounds |
| Flash point: | 12 ° cc |
| Storage conditions (recommended): | Store in a cool and dry place, fire protection u. Ex-protective regulations must be observed. |
| Working temperature: | At room temperature (usually 20-25 ° C) |

Additional information on the ingredients (hazardous substances), safe handling, storage, transport and disposal can be found in the current safety data sheet (SDS, SDS, MSDS).

Recommendations for the processing of this flux:

This flux is very versatile. Both hand, wave and selective soldering as well as cable assembly / strand tinning show good results. For this product as well, the quantities of flux used should be as low as possible and as much as necessary.

Spray fluxing: When dosing, the amount of flux initially to 15 - 30 ml / min. Adjust the uniform flux distribution on the printed circuit board (if necessary test with thermal paper) and then correct to the optimum amount.

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The above described attributes are average values. They are meant solely for your information and are no specifications as such. These instructions of use are without obligation and do not exempt our customers from their own trials of suitability for their own purposes.



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Preheating: For "simple" PCBs, a preheat temperature of 80 - 110 ° C, recommended for "more complex" boards from 100 - 130 ° C on the top side of the PCB. The use can be made both in leaded and lead-free solder systems.

Foam fluxing (foam flux application): The compressor output should be even, so that a stable and fine-pored foam crown is achieved. When compressed air supply from the network, the interposition of a water and Ölabscheiders and at least one pressure reducer is required. Optimal is an air pressure in the range of 0.6 - 0.8 bar. Fine-pored foam stones or pipes (10-20 µm) facilitate foam flow. The nozzle slot should not be more than 15 mm. Side-mounted, perforated support plates promote the stability of the foam. After the foam has been flown, it is recommended to blow off with air to evenly distribute the flux and retain excess amounts.

Density correction: The Flux Thinner "K-113", cat.-no. 1003, available.

Storage:

The shelf life when properly stored between 15 and 25 ° C is 12 months.

Standard packing units (domestic):

Canisters (jerry cans 3H1) with 5, 10 and 20 liters
- other containers available on request

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