**PRODUCT DATA SHEET**

**TACFlux® 089HF**

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**Introduction**

**TACFlux® 089HF** is a no-clean flux formulated for SnAgCu and SnAg solders (also compatible with Sn/Pb solder). **TACFlux® 089HF** provides excellent wetting in air or nitrogen atmospheres. The flux and flux residue is halogen-free.

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**Properties**

<table>
<thead>
<tr>
<th>Test</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>J-STD-004 (IPC-TM-650)</td>
<td>ROL0</td>
</tr>
<tr>
<td>Flux Type Classification</td>
<td>ROL0</td>
</tr>
<tr>
<td>Flux-Induced Corrosion (Copper Mirror)</td>
<td>Type L</td>
</tr>
<tr>
<td>Presence of Halide:</td>
<td>Pass</td>
</tr>
<tr>
<td>Silver Chromate Fluoride Spot Test</td>
<td>Pass</td>
</tr>
<tr>
<td>CI Equivalent</td>
<td>~35%</td>
</tr>
<tr>
<td>Post-Reflow Flux Residue (ICA Test)</td>
<td>~35%</td>
</tr>
<tr>
<td>SIR</td>
<td>Pass</td>
</tr>
<tr>
<td>Bellcore Electrochemical Migration</td>
<td>Pass</td>
</tr>
<tr>
<td>Viscosity (C &amp; P)</td>
<td>10kcps (Cone &amp; Plate viscosity @ 5 minutes)</td>
</tr>
<tr>
<td>Tack</td>
<td>120 grams</td>
</tr>
</tbody>
</table>

**Additional Test Results**

- **Appearance**: Light Yellow–Amber
- **Maximum Reflow Temperature**: 260°C
- **Reflow Atmosphere**: Nitrogen or Air
- **Shelf Life**: 1 year
- **Storage Condition**: Stored @ 0–30°C (tip down for syringe/cartridge)

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**Cleaning**

**TACFlux® 089HF** is designed for no-clean applications. If necessary, the flux can be removed by using a commercially available flux cleaner.

**Reflow**

Peak reflow temperature should be <260°C in an air or nitrogen atmosphere.

**Storage**

**TACFlux® 089HF** syringes and cartridges should be stored tip down at 0–30°C. If refrigerated, **TACFlux® 089HF** should be thawed for 4 hours at room temperature before using.

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**Technical Support**

Indium Corporation’s internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Material Science as it applies to the electronics and semiconductor sectors, Technical Support Engineers provide expert advice in solder preforms, wire, ribbon, and paste. Indium Corporation’s Technical Support Engineers provide rapid response to all technical inquiries.

**Safety Data Sheets**

The SDS for this product can be found online at [http://www.indium.com/sds](http://www.indium.com/sds)

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**From One Engineer To Another**

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