PRODUCT DATA SHEET
615 IR Fusing Fluid

Introduction
615 IR Fusing Fluid is an organic, biodegradable liquid formulation developed for use in reflow of solder-plated printed circuit boards by infrared fusing equipment. 615 IR Fusing Fluid adequately reduces the tarnish and prevents oxidation of newly created solder while it is in the molten state. The fused, dense solder surface preserves the solderability of the PCB.

Process Recommendations
615 IR Fusing Fluid is designed for fusing printed wiring boards and can be used with any infrared fusing machine. Automatic application by roller coat applicators is recommended to assure uniform board coverage.

Physical Properties

<table>
<thead>
<tr>
<th>Test</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Clear Liquid</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td></td>
</tr>
<tr>
<td>@ 77°F (25°C)</td>
<td>0.928</td>
</tr>
<tr>
<td>@ 60°F (15.5°C)</td>
<td>0.932</td>
</tr>
<tr>
<td>Flash Point (°F TCC)</td>
<td>54</td>
</tr>
<tr>
<td>Acid Value</td>
<td>92.2</td>
</tr>
</tbody>
</table>

All information is for reference only. Not to be used as incoming product specifications.

Thinning
Thinning of 615 IR Fusing Fluid is not recommended.

Residue Removal
The residue of 615 IR Fusing Fluid is completely soluble in water and easily removed from board surfaces by hand or automatic scrubber. Because the fumes are acidic, 615 IR Fusing Fluid should be used in well-ventilated areas.

Packaging
615 IR Fusing Fluid is available in the following size containers:

- 1 gallon containers
- 5 gallon containers
- 15 gallon containers
- 55 gallon drums

Technical Support
Indium Corporation sets the industry standard in providing rapid response, onsite technical support for our customers worldwide. Indium Corporation’s team of Technical Support Engineers can provide expertise in all aspects of materials science.

Safety Data Sheets
The SDS for this product can be found online at http://www.indium.com/sds

From One Engineer To Another

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