

Product Data Sheet

1072 VOC-Free (Contains Rosin) Wave Solder Flux

Features

- Excellent Surface Wetting
- Eliminates Cleaning
- Excellent Solderability
- VOC-Free Formulation
- Contains Rosin

Introduction

Wave Solder Flux 1072 is a halide-free, VOC-free, rosin flux specifically developed for wave soldering, surface mount, mixed technology and through-hole electronic assemblies. This unique formulation is a new advancement in flux chemistry, combining the benefits of rosin with the environmentally friendliness of a water-based product.

Wave Solder Flux 1072 is a water-based, nonflammable formulation, eliminating special storage requirements and dramatically reducing VOC emissions. **Wave Solder Flux 1072** has excellent solderability on difficult to solder assemblies, and a wide process window.

Physical Properties

Test	Result
Color:	Amber
Specific Gravity:	
@25°C (77°F)	1.017
@15.5°C (60°F)	1.017
Acid Value	25
Solids Content	5.0
Flash Point	None

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

IPC Surface Insulation Resistance

Test Pattern	Board	24 Hours	96 Hours	168 Hours
IPC B24	Control	7.67 X 10 ⁹	5.20 X 10 ⁹	4.36 X 10 ⁹
	Pattern up	6.99 X 10 ⁹	7.07 X 10 ⁹	5.78 X 10 ⁹
	Pattern down	1.66 X 10 ⁹	2.87 X 10 ⁹	3.45 X 10 ⁹

All readings expressed in ohms

Packaging

- 5 gallon containers
- 55 gallon drums

Safety

Wave Solder Flux 1072 is a nonflammable material. Standard handling precautions should be observed when handling this material.

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 properties, alloy compatibility and selection of solder preforms, wire, ribbon and paste. Indium Corporation's Technical Support engineers provide Rapid Response to all technical inquiries.

Material Safety Data Sheet

The MSDS for this product can be found online at <http://www.indium.com/techlibrary/msds.php>

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Form No. 97856 R3

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Process Recommendations

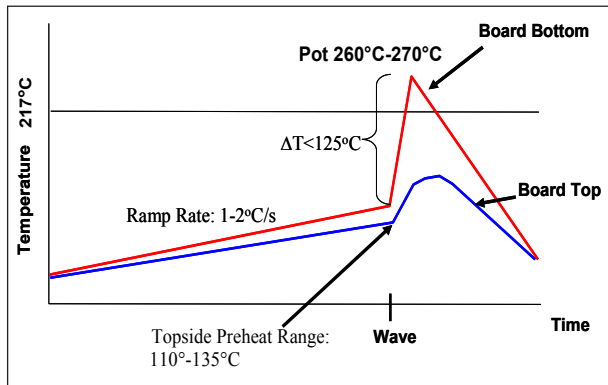
Wave Solder Flux 1072 can be applied by spray or wave. Topside board temperatures for most circuit board assemblies can range from 230-275°F (110-135°C) depending on equipment, board size, board complexity, and conveyor speed (typically 4-6 ft/min). Preheat should be adjusted to ensure complete water removal before contact with the solder wave.

Because **Wave Solder Flux 1072** is water-based, it does not require frequent acid value monitoring. If thinning is required, the addition of 16-1072 Thinner should be used.

Wave Solder Flux 1072 may freeze if exposed to temperatures below 0°C (32°F). If the flux becomes frozen, bring to room temperature until thawed and agitate. The material is not affected by freezing.

Process Recommendations	
Deposition Rate (micrograms/in ²)	1500-2650
Topside Preheat (°C)	110-135
Bottomside Preheat (°C)	+0-25
Preheat Time(s)	75-150
Alloy	Pb-free
Contact Time(s)	4-5
Solder Pot Temperature (°C)	260-270

Typical Profile for Pb-Free Wave Soldering



This product data sheet is provided for general information only. It is not intended, and shall not be construed, to warrant or guarantee the performance of the products

described which are sold subject exclusively to written warranties and limitations thereon included in product packaging and invoices.

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