

## PRODUCT DATA SHEET

# TACFlux<sup>®</sup> WS-759-16-2 for Rework

### Introduction

**WS-759-16-2** is a halogen-free water-soluble flux designed for use in rework. **WS-759-16-2** has an activator system powerful enough to promote wetting on the most demanding substrate metallizations. **WS-759-16-2** is cleanable with just DI water only.

### Features

- Halogen-free (compliant with IEC61249-2-21)
- Flux rheology applicable for a variety of rework applications
- Suitable for Pb-free applications
- Excellent solderability on a wide range of surfaces
- Cleanable with DI water only

### Properties

Property	Value	Test Method
Flux Type Classification:	ORH0	J-STD-004
Typical Viscosity:	31kcps	C&P (5rpm @25°C/5 min)
SIR (Ohms, after cleaning):	Pass (>10 <sup>8</sup> after 7 days @85°C & 85% RH)	J-STD-004 (IPC-TM-650: 2.6.33 IPC-B-24)
Typical Acid Number:	37mg KOH/g	Titration
Typical Tack Strength:	330g	J-STD-005 (IPC-TM-650:2.4.44)
Shelf Life:	6 months at 0–30°C	Viscosity change / microscope examination

### Application

The amount of **WS-759-16-2** flux deposited on the substrate can be optimized by changing equipment parameters. The flux rheology can be optimized for desired application by shearing to achieve the desired viscosity.

### Cleaning

**WS-759-16-2** residue can be cleaned with DI water or water with an added cleaner. Ideal conditions for spray-cleaning: RT or higher for >2 minutes at >60psi.

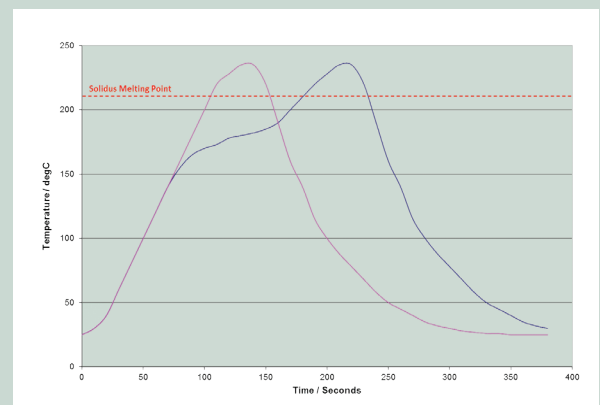
### Packaging

**WS-759-16-2** is available in 100g jars, 150g cartridges, and 10-30g syringes.

### Reflow (if needed)

#### Recommended Profile:

Reflow Profiles: SAC305



A short preheat (150°-160°C) for less than 45 seconds may be used to reduce voiding. The profile should ideally be a linear ramp at 1-2°C/second up to 20-30°C above solidus temperature, with a rapid cool down afterwards, and a minimum time above liquidus of 20 seconds.

### Storage

For maximum shelf life, **WS-759-16-2** cartridges should be stored tip down at 0–30°C. After removing from cold storage, **WS-759-16-2** should be allowed to stand for at least 4 hours at room temperature before using.

### Technical Support

Indium Corporation sets the industry standard in providing rapid response, on-site technical support for our customers worldwide. Indium Corporation's team of Technical Support Engineers can provide expertise in all aspects of materials science and semiconductor packaging process applications.

### Safety Data Sheets

The SDS for this product can be requested by contacting our technical support team.

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. All Indium Corporation's products and solutions are designed to be commercially available unless specifically stated otherwise.

Contact our engineers today: [askus@indium.com](mailto:askus@indium.com)

Learn more: [www.indium.com](http://www.indium.com)

Form No. 99436 (A4) R0

©2017 Indium Corporation

ISO 9001  
REGISTERED



ASIA +65 6268 8678 • CHINA +86 (0) 512 628 34900 • EUROPE +44 (0) 1908 580400 • USA +1 315 853 4900