**PRODUCT DATA SHEET**

**615 IR Fusing Fluid**

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**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

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