

Product Data Sheet

Wave Solder Flux 1075-EX VOC-Free

Features

- VOC-Free formulation
- Excellent surface wetting
- Eliminates cleaning
- Increased activity

Introduction

1075-EX VOC-Free is a resin/rosin-free flux specifically developed for wave soldering surface-mount, mixed-technology and through-hole electronic assemblies.

1075-EX VOC-Free is a water-based, non-flammable formulation, which eliminates special storage requirements and reduces VOC emissions dramatically.

Process Recommendations

1075-EX VOC-Free should be applied by ultrasonic spray for best results. The optimum pre-heat temperature for most circuit board assemblies is 200-240° F (93-115°C). Flux deposition rate of 500-1,000 micrograms per square inch of flux solids (77.5-155 micrograms/cm²) should be applied as starting point. The conveyor speed and preheat should be adjusted to ensure complete water removal before contact with the solder wave.

Because **1075-EX VOC-Free** is water-based, it does not require frequent acid value monitoring. If thinning is required, the addition of deionized water is all that is necessary.

1075-EX VOC-Free may freeze if exposed to temperatures below 32°F. If the flux becomes frozen, bring to room temperature and agitate. The material is not affected by freezing.

Physical Properties

Test	Result
Color:	Clear
Specific Gravity:	
@25°C (77°F)	1.011
@15.5°C (60°F)	1.011
Acid Value	20.0
Solids Content	2.40
Flash Point (°F TCC)	None
J-STD-004 Flux Type	ORLO

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

Packaging

- 5 gallon containers
- 55 gallon drums

Safety

1075-EX VOC-Free is a non-flammable material. Standard 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>

Bellcore Surface Insulation Resistance Test

Test Pattern	Boards	Initial Reading*	Final Reading*
IPC B25A	Control	1.58 X 10 ¹³	1.37 X 10 ¹³
	Pattern up	3.74 X 10 ¹⁰	1.36 X 10 ¹¹
	Pattern down	2.11 X 10 ¹⁰	1.99 X 10 ¹¹

All readings expressed in ohms

IPC Surface Insulation Resistance Test

Test Pattern	Boards	24 Hours*	96 Hours*	168 Hours*
IPC B25A	Control	1.01 X 10 ¹¹	3.05 X 10 ¹⁰	3.12 X 10 ¹¹
	Pattern up	2.69 X 10 ¹⁰	4.73 X 10 ⁹	7.57 X 10 ⁹
	Pattern down	2.26 X 10 ¹⁰	4.10 X 10 ⁹	6.98 X 10 ¹⁰

All readings expressed in ohms

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S O L D E R

INDIUM CORPORATION OF AMERICA®

www.indium.com
askus@indium.com
PRC +86 (0)512 628 34900
SINGAPORE +65 6 268 8678
UK +44 (0) 1908 580400
USA +1 315 853 4900



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