

Product Data Sheet

Wave Solder Flux

1075-EX 30 VOC-Free

Features

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

Introduction

1075-EX 30 is a resin/rosin-free flux specifically developed for wave soldering, surface-mount, mixed-technology and through-hole electronic assemblies.

1075-EX 30 is a water-based, non-flammable formulation, eliminating special storage requirements, and reducing VOC emissions dramatically. **1075-EX 30** is formulated to produce better solderability on difficult to solder assemblies.

Process Recommendations

1075-EX 30 is best applied by ultrasonic spray. The optimum pre-heat temperature for most circuit board assemblies is 93-115°C (200-240°F). The conveyor speed and preheat should be adjusted to ensure complete water removal before contact with the solder wave.

A thin uniform flux deposition of 500-1,000 micrograms per square inch of flux solids should be applied as a starting point.

Because **1075-EX 30** 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 30 may freeze if exposed to temperatures below 32°F. If the flux becomes frozen, bring to room temperature until thawed and agitate. The material is not affected by freezing.

Physical Properties

Test	Result
Color:	Clear
Specific Gravity:	
@25°C (77°F)	1.014
@15.5°C (60°F)	1.014
Acid Value	30.0
Solids Content	2.85
Flash Point (°F TCC)	None
J-STD-004 Flux Type	ORLO

Packaging

- 5 gallon containers
- 55 gallon drums

Safety

1075-EX 30 is 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>

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ISO 9001
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Telcordia Surface Insulation Resistance Test

Test Pattern	Boards	Initial Reading*	Final Reading*
Standard Bellcore test pattern	Control	6.08 X 10 ¹³	4.42 X 10 ¹³
	Pattern up	1.56 X 10 ¹⁴	1.75 X 10 ¹⁴
	Pattern down	7.81 X 10 ¹³	6.07 X 10 ¹³

All readings expressed in ohms

IPC Surface Insulation Resistance Test

Test Pattern	Boards	24 Hours*	96 Hours*	168 Hours*
IPC B25A test pattern 0.0157" wide lines 0.0197" spacing	Control	1.01 X 10 ¹¹	1.35 X 10 ¹⁰	2.42 X 10 ¹¹
	Pattern up	1.55 X 10 ¹¹	2.55 X 10 ¹¹	8.41 X 10 ¹⁰
	Pattern down	2.44 X 10 ⁸	4.96 X 10 ⁸	6.40 X 10 ⁸

All readings expressed in ohms

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