PRODUCT DATA SHEET

1075-EX 30 VOC-Free

Wave Solder Flux

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.

Features

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

Process Recommendations

1075-EX 30 is best applied by ultrasonic spray. The optimum preheat 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 0°C (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) @ 15.5°C (60°F)	 1.014 1.014
Acid Value	30.0
Solids Content	2.85
Flash Point (°F TCC)	None
J-STD-004 Flux Type	ORL0
Shelf Life	18 months

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

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.

Safety Data Sheets

Please refer to the SDS document within the product shipment, or contact our local team to receive a copy.

From One Engineer To Another®

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Telcordia Surface Insulation Resistance Test

Test Pattern	Boards	Initial Reading*	Final Reading*
Standard Bellcore	Control	6.08×10^{13}	4.42×10^{13}
	Pattern up	1.56×10^{14}	1.75×10^{14}
	Pattern down	7.81×10^{13}	6.07×10^{13}

**All readings expressed in Ohms.*

IPC Surface Insulation Resistance Test

Test Pattern	Boards	24 Hours*	96 Hours*	168 Hours*
IPC B25A	Control	1.01×10^{11}	1.35×10^{10}	2.42×10^{11}
0.0157" Wide Lines	Pattern up	1.55×10^{11}	2.55×10^{11}	8.41×10^{10}
0.0197" Spacing	Pattern down	2.44×10^{8}	4.96×10^{8}	6.40×10^{8}

**All readings expressed in Ohms.*

All of Indium Corporation's solder paste and preform manufacturing facilities are IATF 16949:2016 certified.
Indium Corporation is an ISO 9001:2015 registered company.

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