**PRODUCT DATA SHEET**

**1081-T**

*Wave Solder Flux*

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**Introduction**

**1081-T Wave Solder Flux** is a water-wash organic solder flux suitable for all conventional tin-lead alloys. **1081-T** exhibits excellent solderability with low ionic residues after aqueous cleaning.

**Features**

- Excellent solderability
- Wide process window
- Cleans to low ionic level

**Process Recommendations**

**1081-T** was developed for use in various electronic soldering applications where high halide-containing organic fluxes are too corrosive and rosin-based fluxes are too inactive.

The flux residue readily rinses away with warm water 49–60°C (120–140°F).

With reduced solids, **1081-T** is especially adaptable to spray application, but can also be applied by foam. If foam-fluxing, use the following guidelines for best results:

- Keep foam head, pot level, or wave height consistent through appropriate adjustments. Replace after every 40 hours of operation.
- Adjust the specific gravity to the nominal level of ±0.01 with Indium Corporation’s 16-1081-T Thinner.
- Add fresh flux to maintain the appropriate level.
- Clean fluxing equipment regularly to remove debris, trapped oil, or water. When foam-fluxing, clean foaming stone in Indium Corporation’s 16-1081-T Thinner whenever the flux is changed, or as needed.

**Safety Precautions**

All fluxes and thinners with low flash points should be handled with caution. Store in a dry, well-ventilated area away from sparks, flames, and direct heat.

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**Physical Properties**

<table>
<thead>
<tr>
<th>Test</th>
<th>1081-T</th>
<th>16-1081-T</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Light amber</td>
<td>Clear</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td></td>
<td></td>
</tr>
<tr>
<td>@ 25°C (77°F)</td>
<td>0.908</td>
<td>0.804</td>
</tr>
<tr>
<td>@ 15.5°C (60°F)</td>
<td>0.913</td>
<td>0.809</td>
</tr>
<tr>
<td>Flash Point (°F TCC)</td>
<td>68</td>
<td>55</td>
</tr>
<tr>
<td>Solids Content</td>
<td>12.57%</td>
<td>0%</td>
</tr>
<tr>
<td>J-STD-004 Flux Type</td>
<td>ORHO</td>
<td>N/A</td>
</tr>
</tbody>
</table>

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

**Thinning**

Dilution is seldom required. If thinning is needed, it is suggested you use Indium Corporation’s 16-1081-T Thinner.

**Packaging**

- 5 gallon containers
- 55 gallon drums

**Safety**

Flammable liquids should always be stored in a dry, well-ventilated environment away from open flames, sparks, or direct heat.

**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**

The SDS for this product can be found online at http://www.indium.com/sds

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**From One Engineer To Another**

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