

Product Data Sheet

Wave Solder Flux 1081-T

Features

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

Introduction

Wave Solder Flux 1081-T 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.

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 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 forty (40) hours of operation.
- Adjust the specific gravity to the nominal level of ±0.01 with Indium 16-1081T 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 1681-T Thinner whenever the flux is changed, or as needed.

Physical Properties

Test	Result	
	1081-T	16-1081T
Color	Light Amber	Clear
Specific Gravity @25°C (77°F) @15.5°C (60°F)	0.908 0.913	0.804 0.809
Flash Point (°F TCC)	68	55
Solids Content	12.57%	0%
J-STD-004 Flux Type	ORHO	N/A

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

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.

Thinning

Dilution is seldom required. If thinning is needed, it is suggested you use Indium 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.

Material Safety Data Sheets

The MSDS for this product can be found online at <http://www.indium.com/msds>

Form No. 97902 R2

www.indium.com

askus@indium.com

ASIA: Singapore, Cheongju: +65 6268 8678
 CHINA: Suzhou, Shenzhen, Liuzhou: +86 (0)512 628 34900
 EUROPE: Milton Keynes, Torino: +44 (0) 1908 580400
 USA: Utica, Clinton, Chicago: +1 315 853 4900



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