

## Product Data Sheet

# Wave Solder Flux 1085

## Water-Soluble

### Features

- Low solids
- High activity level
- Cleans to low Ionic levels

### Introduction

**WAVE SOLDER FLUX 1085** is a water-soluble flux specifically developed for soldering surface-mount, mixed-technology and through-hole electronic assemblies.

**1085** is biodegradable and cleans readily in water to low ionic levels, while leaving a surface which has a high surface insulation resistance (SIR).

### Process Recommendations

With reduced solids, **1085** is especially adaptable to spray application but can also be applied by foam. If foam fluxing, for best results, use the following guidelines:

- Keep foam head, pot level, or wave height consistent when making appropriate adjustments. Replace after every 40 hours of use.
- The specific gravity should be maintained with Indium 16-1085 thinner. Control the flux to +/- 0.01 of the nominal specific gravity to provide consistent soldering performance for open atmosphere fluxing systems.
- 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 16-1085 Thinner when flux is changed, or as needed.
- The residues are easily removed by water utilizing an in-line or batch type cleaning process. Saponifiers can be added to the wash but are not necessary. A final rinse in deionized water will leave the assembly with low ionic levels. Flux residues readily rinse away with 120-140°F water.

### Physical Properties

Test	Result	
	1085 Flux	16-1085 Thinner
Color:	Pale	Clear
Specific Gravity:		
@25°C (77°F)	0.860	0.787
@15.5°C (60°F)	0.866	0.793
Solids Content	12.36%	0%
Flash Point (°F TCC)	68	53
J-STD-004A Flux Type	ORHO	

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 dry, well-ventilated area away from sparks, flames and direct heat.

### Packaging

- 5 gallon containers
- 55 gallon drums

### 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>

This product data sheet is provided for general information only. It is not intended, and shall not be construed, to warrant or guarantee the performance of the products

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