

Product Data Sheet

Wave Solder Flux 1095-NF Water-Soluble

Features

- Low solids
- High activity level
- Cleans to low ionic levels
- Cleaning can be delayed up to 48 hours

Introduction

1095-NF water-soluble flux is a neutral pH formulation with a high level of activity for wave soldering through-hole, mixed-technology and surface-mount assemblies.

1095-NF is biodegradable and cleans readily in water to low ionic levels while leaving a surface which has a high surface insulation resistance (SIR).

1095-NF residue can remain on the assembly up to 48 hours without affecting the cosmetic appearance of the board.

Process Recommendations

With reduced solids, **1095-NF** 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 16-1000 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 16-1000 Thinner whenever the flux is changed, or as needed.
- Flux residues readily rinse away with 120-140°F water.

Physical Properties

Test	Result	
	1095-NF	16-1000
Color:	Clear to light yellow	Clear
Specific Gravity:		
@25°C (77°F)	0.838	0.783
@15.5°C (60°F)	0.844	0.799
Solids Content	19.5%	0%
Flash Point	54°F	54°F
J-STD-004A Flux Type	ORH1	N/A

Safety Precautions

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

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