

PRODUCT DATA SHEET

1095-NF

Water-Soluble Wave Solder Flux

Introduction

1095-NF Water-Soluble Wave Solder 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.

Features

- Low solids
- High activity level
- Cleans to low ionic levels
- Cleaning can be delayed up to 48 hours
- Works with both SnPb and Pb-free alloys

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 40 hours of operation.
- Adjust the specific gravity to the nominal level of ± 0.01 with Indium Corporation's 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 Corporation's 16-1000 Thinner whenever the flux is changed, or as needed.
- Flux residues readily rinse away with 49–60°C (120–140°F) water.

Physical Properties

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

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

Safety Precautions

All fluxes with low flash points should be handled with caution. Store in a 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 Materials 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 Sheet

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

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 described which are sold subject exclusively to written warranties and limitations thereon included in product packaging and invoices. All Indium Corporation's products and solutions are designed to be commercially available unless specifically stated otherwise.

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.

From One Engineer To Another®

Contact our engineers: askus@indium.com

Learn more: www.indium.com

ASIA +65 6268 8678 • CHINA +86 (0) 512 628 34900 • EUROPE +44 (0) 1908 580400 • USA +1 315 853 4900

Form No. 97717 (A4) R3



©2021 Indium Corporation