**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**

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

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

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**From One Engineer To Another**

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