


Updated: 30/07/2020	TECHNICAL DATA SHEET	
Ref. : Flux	<u>40S2S</u>	
Created: 08/03/2001	<u>No-Clean Soldering Flux</u>	



GENERAL CHARACTERISTICS:

- **MBO 40S2S** is specifically manufactured to leave no remaining residue after soldering to eliminate the need for circuit cleaning and effectively saving the relative costs.
- Dirt accumulation in machines and on circuit boards carriages is drastically reduced.
- Soldering efficiency is equal to resinous flux, type RMA.
- Halide free, it leaves no corrosive elements after processing.

<u>PHYSIOCHEMICAL CHARACTERISTICS:</u>	<u>ADDITIONAL INFORMATION:</u>
Solution : Alcoholised Colour : Colourless Density at 20°C : 0.809 +/- 0.004 Dry extract : < 2.5 % Chlorine rate : Halide free Flash point : 13°C Acid value : 17 +/- 0.6 mg/ml Corrosiveness : None Insulation resistance : > 100 GΩ Efficiency (SAR) : < 30° SAR – grade III J-STD 004 classification : ORL0	Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in France). A quality Certificate can be obtained on Request 

INSTRUCTION OF USE :

MBO 40S2S flux can be used with all fluxing systems – spray, foam, sprinkle, dipping, etc. in all types of automatic machines (single or double wave).

Carry out a regular check of the density or acidity index and maintain the level by adding **DILUANT D40S**. Nominal density is 0.805 to 0.813 @ 20°C.

The circuit topside drying temperature after fluxing should be 90 to 130°C.

The alloy bath temperature should be around 235°C for leaded alloys and 260°C for lead free

Conveyor speed should be between 0.8 and 2 meters per minute, depend on the type of circuit. Contact time between circuit and solder wave should not exceed 3 seconds.

MISCELLANEOUS:

Health and Safety : As with all soldering fluxes, **MBO 40S2S** must be used in a well ventilated area away from any source of flame or ignition (COSH sheet available).

Packaging : Throwaway plastic containers of 5, 10 and 20 litres.

Storage : In original hermetically sealed containers, stored at an ideal temperature near 20°C for 12 months maximum.

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