


Updated: 01/03/2010 N°01	SPECIFICATION <u>Soldering Flux Type H35M</u> <u>Organic hydrosoluble</u>	
Ref. : Flux		
Created date: 20/08/01		

1 – GENERAL CHARACTERISTICS :

- 1.1 De-oxidising flux used for soldering printed circuits.
- 1.2 Non rosin, organic flux, soluble in water.
- 1.3 Meets standards NFC 90550, DIN 8511 –8516 and others.

ADDITIONAL INFORMATION:

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in Europe).

2 – PHYSIOCHEMICAL CHARACTERISTICS :

- 2.1 Solution : Alcoholised
- 2.2 Colour : Colourless
- 2.3 Density at 20°C : 0.970
- 2.4 Acid number (IA) : 112 ± 4 mg/g
- 2.5 Chloride content : < 0.05 %
- 2.6 Density adjustment : D305 Dilutant
- 2.7 Perfect cleaning by water

3– INSTRUCTION OF USE :

- 3.1 For use in automatic flow machines, being applied by the air foam process. Pre-heating temperature should be between 80°C and 90°C, and the alloy bath temperature between 235°C and 250°C. Density must be regularly controlled. D 305 Dilutant must be used to adjust density.
- 3.2 Cleaning can be carried out in water, without saponifier, in a closed loop system incorporating an ion exchange column.
- 3.3 In case of an opened cleaning system, comply with the regulations in force.

4 – MISCELLANEOUS :

Health and Safety : As with all soldering fluxes, **MBO H35M** must be used in a well ventilated area away from any source of flame or ignition.

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.