


Created: 07/07/03	SPECIFICATION <u>FLUX TYPE BCX 5M</u> Resinous	
Ref.: Flux		
Revised: 09.02.15		

1 – GENERAL CHARACTERISTICS :

BCX5M liquid flux contains 5.5 % of activated rosin. It conforms with standard NFC 90550 in the RMA class (Rosin Mildly Activated). Equivalent J-Std-004 – R0L0.

2 – PHYSIOCHEMICAL CHARACTERISTICS :

- Solution : Alcoholised
- Colouration : Honey
- Density at 20°C : 0.808
- Water washing : Insoluble
- Alcohol washing : Soluble
- Flash point : 12°C (Closed cup method)
- Dry extract : 5.5 %
- Chlorine rate : < 0.05%
- Acidity : IA = 25 mg/g
- Corrosiveness : None

3- INSTRUCTION OF USE :

BCX5M liquid flux may be used as a foam flux in all types of automatic flow soldering machines. It can also be used in spray or dipping applications. Due to its unique soldering characteristics the flux reduces the formation of icicles and facilitates a good capillary rise in plated through holes.

Preheat temperature after fluxing should be between 90° and 100°C to enable good levels of flux activation.

BCX5M liquid flux residue may remain on the circuit without risk of corrosion or loss of insulation resistance. Any remaining residues may be cleaned efficiently leaving no surface film, by means of alcoholised solvent, if required.

Maintenance of the flux density is achieved by adding dilutant D305 to within the limits of S.G. 0.804 to 0.812.

4 – MISCELLANEOUS :

Health & Safety: Use in a well ventilated area, far from any sources of flame or ignition (COSH sheet available)

Packaging: 1ltr, 5ltr & 10ltr HDPE containers.

Storage: In the original hermetically sealed containers, at a recommended temperature of 20°C, for 12 months.