

## ELSOLD Flux 880

### General Description

Ready-to-use special flux with a high solid content for high-temperature soldering processes and/or long solder process times. Particularly suitable for double wave soldering on which SMD and MELF components are processed. Special formulations guarantee that sufficient flux is available also when the boards pass the second solder wave. ELSOLD Flux 880 produces good soldering results. A small amount of a highly efficient halide-bearing activator is added to high-quality modified natural rosin.

### Classification

ELSOLD Flux 880 is classified per DIN EN ISO 29454-1 as 1123, ROM1 according to DIN EN 61190-1-1 and J-STD-004 (and formerly also F-SW26 according to DIN 8511 and RA according to QQ-S-571).

### Technical Specification

	880
Appearance	Uniform clear, yellow-brownish liquid
Density [g/cm <sup>3</sup> ] (20 °C)	0.898
Acid Number [mgKOH/gFlux]	85 ± 5
Chloride content [%]	1.3
Solid content [%]	45
Flash point [°C]	16.5
Boiling point of solvent [°C]	78

If needed isopropanol (water-free) should be used as thinner to remain the characteristic properties.

### Application

ELSOLD Flux 880 can be applied by foam fluxing, dipping, spraying, brushing, etc. The product has excellent capillary properties and shows a good, uniform wetting behaviour even on lightly oxidised surfaces. The flux residues are quickly solidified and not tacky. They can be easily and completely removed by using commercial-grade solvents (on ethanol, 2-propanol base).

### Process Control

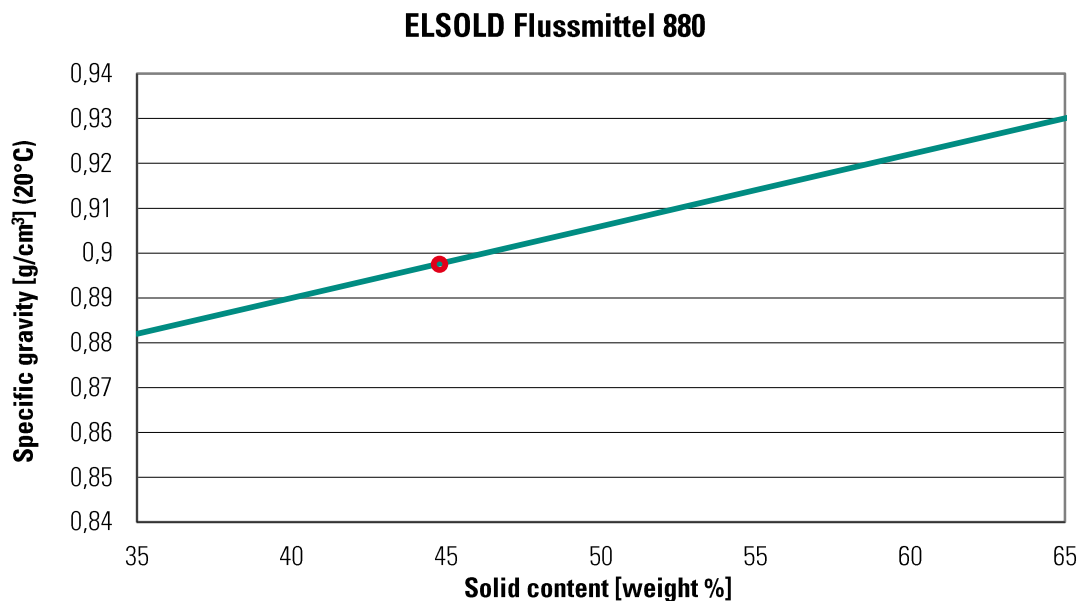
Due to the evaporation of the solvent the flux gets more concentrated during the use. Evaporation losses need to be compensated by replenishing the indicated solvent in order to maintain the desired viscosity.

The flux concentration can be controlled by adjusting the specific gravity according to the below diagram. The specific gravity can be checked by using a commercially available densitometer or pycnometer.

# Technical Product Information

## ELSOLD Flux 880

Specific gravity plotted against concentration of ELSOLD Flux 880 with solvent 2-Propanol:



### Cleaning

If needed residuals can be easily removed by use of alcohols or commercially available cleaners.

### General Safety Precautions

Flux 880 should be used according to industrial standards of practice. For safety advice please refer to the material safety data sheet.

### Packing Sizes

ELSOLD Flux 880 is available in containers of 5 L, 10 L and 20 L.

### Storage

ELSOLD Flux 880 is flammable and therefore needs to be stored away from possible sources of ignition.

### Shelf Life

Under adequate conditions ELSOLD Flux 880 can be stored in original unopened containers for a minimum of 12 months.

The information contained herein is based on technical data that we believe to be reliable and is intended for use by persons having technical skill, at their own risk. Users of our products should make their own tests to determine the suitability of each product for their particular process. TAMURA ELSOLD will assume no liability for results obtained or damages incurred through the application of the data presented.