

## VOC-FREE NO-CLEAN FLUX PEN & REFILLS



### Product Description

This new formulation is a VOC-free, No-Clean soldering flux. Our No-Clean flux promotes the rapid activity for soldering, while eliminating spattering during heating. In addition, the flux leaves a clear residue and is effective for both lead-free and lead-bearing solder alloys!

### Key Features

- **Formulated for Solder Flux Pens**
- VOC-Free, No-Clean, water-based formulation.
- For use with lead-free and lead-bearing alloys.
- Formulated to reduce spattering upon contact.
- Higher activity coupled with increased temperature tolerance. Higher activity coupled with increased temperature tolerance.
- Increased activity level to meet flow and melt-points of different Lead-Free solders.

### Availability

- **PEN-NC-VF** – 10mL Refillable Flux Pen
- **PEN-NC-VF-SET** – 10mL Flux Pen with 5 Refills
- **REFILL-VF** – 50mL Bottle for Flux Pen Refill



## PROCESS RECOMMENDATIONS

Soldering processes should include the following steps:

- Remove any oil, grease, mold release, or other contaminants from the surface to be soldered.
- Apply flux to joint by dragging, swabbing or brushing to area being soldered.
- Preheat or air-dry area to be soldered after flux has been applied to activate the flux and yield optimum soldering characteristics and reduce or eliminate spattering.
- Apply solder, dip part, or place iron to area being soldered.
- Clean flux residues from soldered area using de-ionized, distilled, RO, and in some cases tap water heated to a temperature of 60°C±5°C /140°F±10°F for best results. Room temperature water may also be used.

## PHYSICAL PROPERTIES

Specific Gravity	1.015 +/- 0.01 @ 20-25°C/68-77°F
Pounds/Gallon	8.465 +/- 0.20 @ 20-25°C/68-77°F
Acid Number	38.0 +/- 5.0
Total Solids	4.0 +/- 0.2
Halide Content	0%
Flash Point	None
Soldering Range	200 -350°C/390-660°F

**THIS PRODUCT IS RoHS COMPLIANT.**

## SAFETY AND HANDLING PRECAUTIONS

VOC-Free, No-Clean Selective Soldering Flux is a non-flammable, non-hazardous product. However, it is recommended that standard chemical safety practices be observed when handling this product. Avoid contact with eyes, skin, and mucous membranes. The use of rubber gloves, goggles and/or face shield is recommended. Use with adequate ventilation. Refer to the Material Safety Data Sheet (MSDS) for additional information. PEN-NC-VF has a two (2) year shelf life.

VOC-Free flux should be stored in plastic containers away from heat. In the event the flux is exposed to temperatures below 0°C/32°F, the flux may freeze. Freezing will not degrade this product if these steps are followed:

- Thaw flux until room temperature is reached
- Agitate flux to return to proper consistency.

