

CHEMTRONICS® Technical Data Sheet

CircuitWorks® Lead-Free Flux

PRODUCT DESCRIPTION

CircuitWorks® Lead-Free Flux is designed specifically for all lead-free soldering. The convenient quart size containers offers a more convenient package small OEM's and board shops. The Lead-Free Flux quickly applies a noncorrosive, halide-free, No Clean flux which meets Bellcore TR-NWT-000078 and passes IPC SF-818 for surface insulation resistance. Instant wetting action provides thorough deoxidation of metallic surfaces providing the best possible surfaces for lead-free soldering.

- Flux is noncorrosive and halide-free
- Can be used for soldering with lead-free or Tin/Lead solders
- Excellent material compatibility
- Fast drying
- RoHS compliant
- High thermal stability

TYPICAL APPLICATIONS

CircuitWorks® Lead-Free Flux can be used in all soldering applications including:

- Printed Circuit Boards
- Chip Carriers
- Surface Mount Device Pads
- Switches and Sockets

TYPICAL PRODUCT DATA AND PHYSICAL PROPERTIES

Solids Content, wt/wt	12.0
Flux Type	No Clean Flux ROLO
Flash Point (TCC)	63 °F (17 °C)
Vapor Density (air=1)	> 1
Appearance	Clear Liquid
Acid Number (mg KOH/g)	27.0
Odor	Alcohol
Shelflife	2 years

COMPATIBILITY

CircuitWorks® Lead-Free Flux is generally compatible with most materials used in the electronics industry. As with any fluxing agent, material compatibility should be determined on a non-critical area prior to use.

Performance	
Test	Results
Silver Chromate Method IPC-TM 650 Test Method 2.3.33	PASS
Copper Corrosion Test IPC-TM 650 Test Method 2.6.15	PASS
Copper Mirror Test IPC-TM 650 Test Method 2.3.32	No Evidence of Corrosion
J-STD-004 Surface Insulation Resistance Testing IPC-TM 650 Test Method 2.6.3.3	PASS

USAGE INSTRUCTIONS

For industrial use only.

Read MSDS carefully prior to use.

Can be sprayed or hand applied to the surface being soldered. After soldering, wipe area around solder joint using a ControlWipe™ to remove unreacted flux.

No Clean flux residues are designed to be left on the board, however, they can be easily removed with Chemtronics Flux-Off® Lead-Free Flux Remover (ES897B or ES1697) or CircuitWorks® Lead-Free Flux Remover Pen (CW9400).

AVAILABILITY

CW3220 32 ounces (1 quart)

Also available:

CircuitWorks® Lead-Free Flux Dispensing Pen
CW8400 9 gm (0.32 oz)

CircuitWorks® No Clean Flux Dispensing Pen
CW8100 9 gm (0.32 oz)

CircuitWorks® Rosin Flux Dispensing Pen
CW8200 9 gm (0.32 oz)

DISTRIBUTED BY:

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