

Product Data Sheet

Wave Solder Flux 1081 Water-Soluble

Features

- Excellent solderability
- Wide process window
- Cleans to low ionic levels

Introduction

Wave Solder Flux 1081 is a water wash organic flux suitable for all conventional tin/lead alloys. **1081** exhibits excellent solderability with low ionic residues after aqueous cleaning.

Process Recommendations

1081 was developed for use in various electronic soldering applications where high halide-containing organic fluxes are too corrosive and rosin-based fluxes are too inactive.

The flux residues readily rinse away with warm water 120-140°F.

Wave Solder Flux 1081 is best applied by foam fluxing equipment. The best results can be obtained by following these guidelines:

1. Keep foam head, wave height, or pot level consistent through appropriate adjustments. Replace after 40 hours of operation.
2. Adjust specific gravity to the nominal level, +/-0.01, with #16-1081 Thinner.
3. Add fresh flux to maintain the appropriate flux level.
4. Clean fluxing equipment regularly to remove debris, trapped oil, or water. When foam fluxing, clean foaming stone with #16-1081 Thinner whenever the flux is changed, or as needed.

Physical Properties

Test	Result	
	#1081	#16-1081
Color:	Light amber	Clear
Specific Gravity:		
@77°F (25°C)	0.957	0.806
@60°F (15.5°C)	0.963	0.812
Solids Content	28.44	0
Flash Point	65°F TCC	65°F TCC
J-STD-004 Flux Type	ORHO	NA

Packaging

- 5 gallon containers
- 55 gallon drums

Safety

All fluxes with low flash points should be handled with caution. Store in a dry, well ventilated area away from sparks, flames, and direct heat. Consult the Material Safety Data Sheet for full details.

Material Safety Data Sheet

The MSDS for this product can be found online at <http://www.indium.com/techlibrary/msds.php>

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