

Product Data Sheet

# Wave Solder Flux 1081-T

## Features

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

## Introduction

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

## Process Recommendations

**1081-T** 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 residue readily rinses away with warm water 120-140°F.

With reduced solids, **1081-T** is especially adaptable to spray application, but can also be applied by foam. If foam fluxing use the following guidelines for best results.

- Keep foam head, pot level, or wave height consistent through appropriate adjustments. Replace after every forty (40) hours of operation.
- Adjust the specific gravity to the nominal level of ±0.01 with Indium 16-1081T Thinner.
- Add fresh flux to maintain the appropriate level.
- Clean fluxing equipment regularly to remove debris, trapped oil or water. When foam-fluxing, clean foam-ing stone in Indium 1681-T Thinner whenever the flux is changes, or as needed.

## Physical Properties

Test	Result	
	1081-T	16-1081T
Color:	Light Amber	Clear
Specific Gravity:		
	@25°C (77°F)	0.908
@15.5°C (60°F)	0.913	0.809
Flash Point (°F TCC)	68	55
Solids Content	12.57%	0%
J-STD-004 Flux Type	ORHO	NA

## Safety Precautions

All fluxes and thinners with low flash points should be handled with caution; store in a dry, well-ventilated area away from sparks, flames and direct heat.

## Thinning

Dilution is seldom required. If thinning is needed, it is suggested you use Indium 16-1081-T Thinner

## Packaging

- 5 gallon containers
- 55 gallon drums

## Technical Support

Indium Corporation's internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Material Science as it applies to the electronics and semiconductor sectors, Technical Support Engineers provide expert advice in solder properties, alloy compatibility and selection of solder preforms, wire, ribbon and paste. Indium Corporation's Technical Support engineers provide Rapid Response to all technical inquiries.

## 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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