PRODUCT DATA SHEET

1072 VOC-Free (Contains Rosin)

Wave Solder Flux

Introduction

1072 Wave Solder Flux is a halide-free, VOC-free, rosin flux specifically developed for wave soldering, surface mount, mixed technology and through-hole electronic assemblies. This unique formulation is a new advancement in flux chemistry, combining the benefits of rosin with the environmentally friendliness of a water-based product.

1072 Wave Solder Flux is a water-based, nonflammable formulation, eliminating special storage requirements and dramatically reducing VOC emissions. **1072 Wave Solder Flux** has excellent solderability on difficult-to-solder assemblies, and a wide process window.

Features

- Excellent surface wetting
- Eliminates cleaning
- Excellent solderability
- VOC-free formulation
- Contains rosin

Physical Properties

Test	Result
Color	Amber
Specific Gravity @25°C (77°F) @15.5°C (60°F)	 1.017 1.017
Acid Value	25
Solids Content	5.0
Flash Point	None
Shelf Life	3 years
Storage Requirements	5–32°C

All information is for reference only.
Not to be used as incoming product specifications.

IPC Surface Insulation Resistance

Test Pattern	Board	24 Hours	96 Hours	168 Hours
IPC B24	Control	7.67×10^9	5.20×10^9	4.36×10^9
	Pattern Up	6.99×10^9	7.07×10^9	5.78×10^9
	Pattern Down	1.66×10^9	2.87×10^9	3.45×10^9

All readings expressed in Ohms.

Packaging

- 5 gallon containers
- 55 gallon drums

Safety

1072 Wave Solder Flux is a nonflammable material. Standard handling precautions should be observed when handling this material.

Technical Support

Indium Corporation's internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Materials 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.

Safety Data Sheets

Please refer to the SDS document within the product shipment, or contact our local team to receive a copy.

From One Engineer To Another®

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Process Recommendations

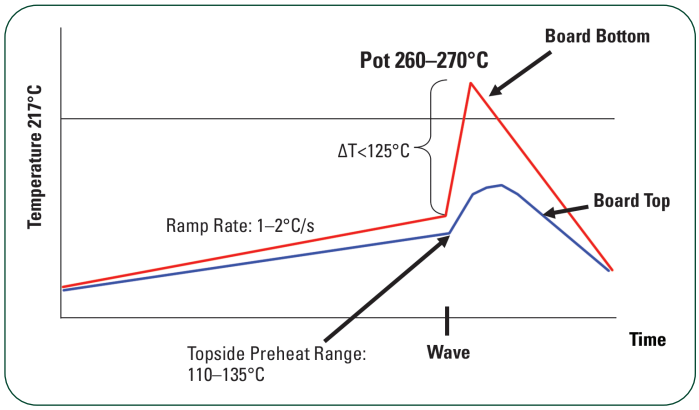
1072 Wave Solder Flux can be applied by spray or wave. Topside board temperatures for most circuit board assemblies can range from 110–135°C (230–275°F) depending on equipment, board size, board complexity, and conveyor speed (typically 4–6 feet/minute). Preheat should be adjusted to ensure complete water removal before contact with the solder wave.

Because **1072 Wave Solder Flux** is water-based, it does not require frequent acid value monitoring. If thinning is required, the addition of 16-1072 Thinner should be used.

1072 Wave Solder Flux may freeze if exposed to temperatures below 0°C (32°F). If the flux becomes frozen, bring to room temperature until thawed and agitate. The material is not affected by freezing.

Deposition Rate (micrograms/in^2)	1,500–2,650
Topside Preheat (°C)	110–135
Bottomside Preheat (°C)	+0–25
Preheat Time(s)	75–150
Alloy	Pb-free
Contact Time(s)	4–5
Solder Pot Temperature (°C)	260–270

Typical Profile for Pb-Free Wave Soldering



All of Indium Corporation's solder paste and preform manufacturing facilities are IATF 16949:2016 certified.
Indium Corporation is an ISO 9001:2015 registered company.

Contact our engineers: **askus@indium.com**
Learn more: **www.indium.com**

ASIA +65 6268 8678 • CHINA +86 (0) 512 628 34900 • EUROPE +44 (0) 1908 580400 • USA +1 315 853 4900