

## PRODUCT DATA SHEET

# 1085 Water-Soluble Wave Solder Flux

### Introduction

**1085 Wave Solder Flux** is a water-soluble flux specifically developed for soldering surface mount, mixed technology and through-hole electronic assemblies.

**1085** is biodegradable and cleans readily in water to low ionic levels, while leaving a surface which has a high surface insulation resistance (SIR).

### Features

- Low solids
- High activity level
- Cleans to low Ionic levels

### Process Recommendations

With reduced solids, **1085** is especially adaptable to spray application but can also be applied by foam. If foam fluxing, for best results, use the following guidelines:

- Keep foam head, pot level, or wave height consistent when making appropriate adjustments. Replace after every 40 hours of use.
- The specific gravity should be maintained with Indium Corporation 16-1085 Thinner. Control the flux to  $\pm 0.01$  of the nominal specific gravity to provide consistent soldering performance for open atmosphere fluxing systems.
- Add fresh flux to maintain the appropriate level.
- Clean fluxing equipment regularly to remove debris, trapped oil, or water. When foam fluxing, clean foaming stone in Indium Corporation 16-1085 Thinner when flux is changed, or as needed.
- The residues are easily removed by water utilizing an in-line or batch-type cleaning process. Saponifiers can be added to the wash, but are not necessary. A final rinse in deionized water will leave the assembly with low ionic levels. Flux residues readily rinse away with 49–60°C (120–140°F) water.

### Physical Properties

Test	Result	
	1085 Flux	16-1085 Thinner
Color	Pale	Clear
Specific Gravity @25°C (77°F) @15.5°C (60°F)	0.860 0.866	0.787 0.793
Solids Content	12.36%	0%
Flash Point (°F TCC)	68	53
J-STD-004A Flux Type	ORH0	N/A
Shelf Life	2 years	N/A

*All information is for reference only.*

*Not to be used as incoming product specifications.*

### Safety Precautions

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

### 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 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.

This product data sheet is provided for general information only. It is not intended, and shall not be construed, to warrant or guarantee the performance of the products described which are sold subject exclusively to written warranties and limitations thereon included in product packaging and invoices. All Indium Corporation's products and solutions are designed to be commercially available unless specifically stated otherwise.

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.

## From One Engineer To Another®

Contact our engineers: [askus@indium.com](mailto:askus@indium.com)

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Form No. 97756 R6

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