



SPECIALTY CHEMICALS FOR PWB SURFACE TREATMENT

**MEC EUROPE**

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## MEC HASL FLUX W-2308

**WATER-SOLUBLE FLUX for VERTICAL HOT AIR LEVELLING SYSTEMS**

### **DESCRIPTION**

MEC HASL FLUX W-2308 is a water-soluble, organic acid type flux specially designed for use in hot air levelling operation of SMD boards application. The fluxing activity is at optimum when boards are well dried prior to fluxing.

All of our experience and expertise both in the oil and infrared solder fusing have been used to develop this unique flux.

### **FEATURES**

1. Excellent fluxing action produces bright, smooth and highly solderable surface.
2. The flux residues after soldering are completely water soluble and readily washed off with warm water without foaming.
3. Low fume, no offensive odor.
4. Very low solder splashing.
5. No problem of solder balls and solder bridge.
6. Keeps the solder pot clear during the levelling operation.

### **PHYSICAL PROPERTIES**

Form	: Viscous liquid
Viscosity(cps /20°C)	: 105 ± 30
pH (1%aqueous sol.20°C)	: 2.9 ± 0.5
Appearance	: Amber clear liquid
Specific gravity(20°C)	: 1.145
Flashpoint	: Non flammable : 275°C

Board Surface Insulation Resistance	
- immediately after rinsing	:1.0 x 10 <sup>12</sup>
- 96 hours after rinsing	:1.0 x 10 <sup>11</sup>
- ionic residue	:0.6 µg/cm <sup>2</sup>

Effluent treatment COD (0.1% solution) : 480

### **OPERATING CONDITIONS**

General machine settings :

- |                     |   |
|---------------------|---|
| - Dwell time flux   | : 1-4 sec (dip)                         |
| - Dwell time solder | : 2-5 sec                               |
| - Air temperature   | : 220°C                                 |
| - Flux              | : use full strength at room temperature |



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#### **PRECLEANING**

The copper surface must be well cleaned prior to solder levelling. Therefore we recommend to use MEC Brite CA-.. as soft etch to prepare the copper surface.

MEC Brite CA-.. will remove oxides and other residues and leave an ideal copper surface for proper levelling.

MEC Brite CA-.. is completely water soluble.

#### **POST CLEANING**

Most efficient cleaning is obtained when using rinsing water at a temperature between 25 and 40°C.

Use of soft nylon brushes also assists in better post cleaning.

#### **STORAGE AND HANDLING**

1. Copper surface should be cleaned prior to soldering.
2. Precipitations sometimes seen after prolonged storage will give no detrimental effects.
3. When exposed to the sunlight, the liquid color will change from pink to dark purple, which gives no effects on its efficiency.
4. Solder pots should be cleaned periodically to remove flux residue.
5. When not in use, keep containers closed tightly; store in cold, dark and well ventilated area.
6. Keep away from open flames or sparks. Though not flammable, they contain some combustible.

#### **SAFETY PRECAUTIONS**

1. Adequate ventilation should be provided in the working area.
2. When handling the fluxes, wear goggles and gloves for protection of eyes and hands.
3. In case of skin contact, immediately flush with running water. In case of eye contact, immediately flush water and obtain medical aids.

#### **PACKAGING**

Available in 25L and 200L polyethylene drums.

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#### **Warranty**

The information contained herein is believed to be correct, but each user is advised to ensure that the product is suitable for his own purposes before he uses it. The purchaser is solely responsible for any loss, either directly or indirectly arising from the use of this product, or information contained herein.