



## MEC HASL FLUX W-2365 XP

LEAD-FREE COMPATIBLE, WATER SOLUBLE FLUX FOR VERTICAL  
HOT AIR LEVELLING SYSTEMS

### DESCRIPTION

MEC HASL FLUX W-2365 is a lead-free compatible water soluble type flux, specially designed for use in hot air levelling operation of boards for Surface Mount Technology application.

MEC HASL FLUX W-2365 tolerates water drag-in when drying of the panels after pre-cleaning and prior to fluxing is not very thorough.

### FEATURES

1. Excellent fluxing action produces bright, level and highly solderable surface.
2. The flux residues after soldering are completely water soluble and readily removed by water wash.
3. Very low fume, very low carbonised residue.
4. Almost no solder splashing.
5. No problem of solder balls and solder bridges.

### PHYSICAL PROPERTIES

Form	: Viscous liquid
Viscosity (cps 20°C)	: 250 +/- 50
pH (1% aqueous sol. 20°C)	: > 2
Appearance	: Amber clear liquid
Specific gravity (20°C)	: 1.10 +/- 0.01

### OPERATING CONDITIONS

#### General machine settings:

- |                     |   |
|---------------------|---|
| - Dwell time flux   | : 1 - 4 sec (dip)                       |
| - Dwell time solder | : 2 - 5 sec                             |
| - Air temperature   | : consult machine supplier              |
| - Flux              | : use full strength at room temperature |

### PRECLEANING

The copper surface must be well cleaned prior to the levelling action. Therefore we recommend to use MEC Brite CA series / MEC Etch Bond CZ series or MAC series, as soft etch to prepare the copper surface.

These microetchants will remove oxides and other residues and leave an ideal copper surface for proper levelling.

The microetchants are completely water soluble.

## POST CLEANING

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

Usage of soft nylon brushes also assist in better post cleaning.

## STORAGE AND HANDLING

1. When exposed to the sunlight, the liquid colour will change from pink to dark purple, which give no effects on their efficiency.
2. Solder pots should be cleaned periodically to remove flux residues.
3. When not in use, keep containers closed tightly.
4. Though not flammable, keep away from open flames or sparks.

## SAFETY PRECAUTIONS

1. Adequate ventilation should be provided in the working area.
2. When handling the flux wear glasses or chemical goggles and gloves for protection of eyes and skin.
3. Wash hands after handling.
4. Do not leak when transferring contents.
5. When not in use, keep containers closed tightly, and store in cold, dark and well ventilated area.
6. Since the flux contains some combustible materials, precaution against fire should be taken, specially for carbonized flux and waste flux.
7. In case of leakage, add sand or watered cloths, clear up an place in a container. Eliminate sources of ignition from the area.
8. To dispose the spent flux, rely on a disposal subcontractor or incinerate it.
9. Be careful with mixing with oxidizing agent or basic substance causes exothermic reaction.

## FIRST AID

- |               |   |
|---------------|---|
| 1. Skin       | Flush immediately with water. Obtain medical aid if irritation remains.       |
| 2. Eyes       | Flush immediately with water for over 15 min. and quickly obtain medical aid. |
| 3. Inhalation | Move to fresh air, keep warm and quiet. Obtain medical aid as required.       |
| 4. Ingestion  | Drink water, rinse mouth thoroughly and obtain medical aid.                   |

## PACKAGING

Available in 25L and 200L polyethylene drums.

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