Updated: 15/04/2020	**TECHNICAL DATA SHEET**	
Ref. : Flux	**Flow Soldering Flux Type WBF320S**	
Created: 26/03/2007	**Low Volatile Organic Compounds (VOC)**	

GENERAL CHARACTERISTICS:

In response to EEC directive 97/C/99/02 (March 1997), following international agreements for protection of the environment, M.B.O. laboratories have developed, in conjunction with major electronics manufacturers, this special *water based* flux for the electronics industry.

WBF320S Contains a very low volume of dry extract for "non-residue" classification.
WBF320S Flow soldering performance is equal to Alcohol Solvent based fluxes.

The carrier of this flux is water, offering very real benefits of economy in eliminating all hazards of handling, storage and use common with Alcohol based fluxes.

This flux is especially developed for compatibility with lead free alloys using.

PHYSIOCHEMICAL CHARACTERISTICS:

Solution	: Water Isopropyl Alcohol (5-20%)
Colour	: Colourless
Density at 20°C	: 0.997 ± 0.005
Acid value	: 50 to 70 mg/ml
Chloride content	: Halide free
Dry extract	: < 10 %
Corrosiveness	: None
Insulation resistance	: > 10 GΩ
Efficiency (SAR)	: < 30° SAR – grade III

ADDITIONAL INFORMATION:

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in France).

A quality Certificate can be obtained on Request

INSTRUCTION OF USE :

WBF320S flux is supplied ready for use.
WBF320S flux performs most efficiency when used in flow solder machines using spray applicators. It is dedicated to cable tinning and connection soldering.
For flux applied by spray it will be necessary to adjust the air pressure (or gas (nitrogen)), by the pump control and/or the conveyor speed to reach an optimum performance.
Circuit board preheat temperature, after fluxing, should between 90°C and 100°C on top side of the circuit and between 110°C and 120°C on the solder side (with lead free alloys, the temperature should be increased from about 10°C- 20°C).
The bath temperature containing the alloy should be near to 235°C (260°C for lead free alloys).
Although residues are minimal, where further cleaning is essential, they remain totally water soluble.

MISCELLANEOUS:

Packaging : Throwaway plastic containers of 5, 10 and 20 litres.

Storage : In original hermetically sealed containers, stored at an ideal temperature near 20°C for 12 months maximum.

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