

## Technical Data Sheet



### NO-CLEAN FLUX

**Product Name: Surf 270F**

No-clean Flux type ORL0 for foam application

#### Description

No-Clean flux classified as type 2.2.3.A according to DIN-EN 29454-1, type ORL0 according to EN 61190-1-1 and type ORL0 according to J-STD-004. Surf 270F was developed as a complement of the Easy Flux series for the wave soldering of electronic devices. The reduced solid content in combination with especially aligned halide free activators affords an excellent wetting of the different surfaces (such as OSP, Ni/Au, HAL) also with lead-free alloys. This flux is applicable for soldering processes in foam system.

#### Application

The Surf 270F has been developed for application with foam fluxers. It can also be used with spray fluxing equipment. The preheat temperature should be at least 90°C measured on the surface of the circuit board when entering the solder wave. This temperature ensures the evaporation of the solvent and a sufficient activation of the flux.

Evaporation of solvent can change the composition. Evaporation causes an increase of the solid content and therefore the density increases.

#### Characteristics

Surf 270F offers the following advantages:

- No-clean application, electrically safe
- Low residues
- Resin-free
- Optimised solid content – fast wetting
- Perfect results with lead-free alloys
- Optimized for foam fluxing application

#### Physical Properties and Data

GENERAL PROPERTIES	LIQUID Surf 270F
<b>Colour:</b>	colourless
<b>Density (20°C):</b>	0.811 g/cm <sup>3</sup>
<b>Flash Point (closed crucible):</b>	12°C
<b>Ignition Temperature:</b>	425°C
<b>Solid Content:</b>	2.7%
<b>Acid Rating:</b>	25.0 mg KOH/g
<b>Halide Content:</b>	none
<b>Thinner</b>	VD-500

#### Shelf Life

2 years after date of delivery (provided proper storage in originally sealed container).

#### Health and Safety

Before using please read the material safety data sheet carefully and observe the safety precautions described.

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#### Notice

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Surf 270F is manufactured by STANNOL GmbH & Co. KG  
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