

Technical Data Sheet



NO-CLEAN FLUX

Product Name: Surf 270
No-clean Flux type ORL0

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 270 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 like selective-soldering and dip-soldering.

Application

The Surf 270 has been developed for application with spray fluxers. The applicability for foam fluxers is limited. 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 EF270 offers the following advantages:

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

Physical Properties and Data

GENERAL PROPERTIES	LIQUID Surf 270
Colour:	colourless
Density (20°C):	0.807 g/cm ³
Flash Point (closed crucible):	12°C
Ignition Temperature:	425°C
Solid Content:	2.7%
Acid Rating:	24.0 mg KOH/g
Halide Content:	none
Thinner	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 270 is manufactured by STANNOL GmbH & Co. KG
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