

Technical Data Sheet



WAVE FLUX

Product Name: Surf 200

Product Type: No-clean Flux type ORL0

Description

Surf 200 is 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 200 is halide free activated. The new formula of the activators guarantees an optimum wetting of the different surfaces (such as OSP, Ni/Au, HAL) used in PCB manufacturing and so avoids problems when new printed circuit boards with alternative surfaces are introduced. Also the soldering with lead-free alloys show perfect wetting results.

Typical Properties

Chemistry :	
Colour:	Colourless
Density at (20° C):	0.811 g/cm ³
Flash point (closed crucible):	12 °C
Ignition temperature:	425 °C
Solid content:	2.0 %
Acid rating:	22.0 mg KOH/g
Halide content	none
Thinner	VD500

Recommended Processing Guidelines

Application:
The Surf 200 has been developed for application with foam- and spray fluxers. The preheat temperature should be at least 110° 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. This can be checked with the Mini-Titration-Kit.

To ensure that the soldered boards pass the cleanliness test, the upper limit for flux coverage is 30ml/m² circuit.

Key Benefits

Surf 200 offers the following advantages:

- **Multi-purpose application, low residues**
- **Excellent foaming**
- **No-clean application, electrically safe**
- **Resin-free**
- **Perfect wetting results**

Residue Properties

Halide content: none

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

Technical Data Sheet



WAVE FLUX

Product Name: Surf 200

Product Type: No-clean Flux type ORL0

Safety

Because the principle solvent is isopropanol, care must be exercised due to a low flash point. Flame suppression equipment and associated precautions, as with any other IPA based flux, are mandatory.

General Notes

The recommended leading to a contact time with the molten solder of 3-5 seconds. The solder temperature can be as between 245-260 °C for SnPb alloy and 260-280 for Lead free alloy, where maximum flux efficiency is achieved.

The Surf 200 is manufactured by Stannol
Oskarstraße 3-7 • 42283 Wuppertal

Doc. release : HI-MB 21.11.2019

Cleaning

Although designed as a no clean product, if residues need to be removed they can readily be removed using standard cleaning systems and solvents.

Storage Conditions

The flux must be stored at room temperature between. The shelf life in this condition is maximum 24 months. The direct exposition to the sun light and warm source must be avoid due to the flammability danger. Ensure that the flux has reached room temperature before use.

The descriptions and engineering data shown here have been compiled by Heraeus using commonly-accepted procedures, in conjunction with modern testing equipment, and have been compiled as according to the latest factual knowledge in our possession. The information was up-to date on the date this document was printed (latest versions can always be supplied upon request). Although the data is considered accurate, we cannot guarantee accuracy, the results obtained from its use, or any patent infringement resulting from its use (unless this is contractually and explicitly agreed in writing, in advance). The data is supplied on the condition that the user shall conduct tests to determine materials suitability for a particular application.

Europe

Heraeus Italy
Via dei Chiosi 11
20873 Cavenago Brianza (MB)
Tel: +39 02 957591
E-Mail: cmd@heraeus.com
Internet: www.heraeus.com

Europe