



MEC HASL FLUX W-2356

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

DESCRIPTION

MEC HASL FLUX W-2356 is a lead-free, water soluble, organic acid type flux specially designed for use in hot air levelling operation of boards for Surface Mount Technology application.

MEC HASL FLUX W-2356 tolerates water drag-in when drying of the panels after pre-cleaning and prior to fluxing is not very thorough.

FEATURES

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

PHYSICAL PROPERTIES

Form	: Viscous liquid
Viscosity(cps /20°C)	: 230 +/- 50
pH (1%aqueous sol.20°C)	: > 2 (1%)
Appearance	: Amber clear liquid
Specific gravity(20°C)	: 1.12 +/- 0,01
Flashpoint	: Non flammable

Board Surface Insulation Resistance (SIR)

- before humidification : $2.0 \times 10^{12} \Omega$
- after humidification : $1.3 \times 10^{11} \Omega$

- ionic residue (50°C-95%) : < 0.0006 mg/cm²

* humidification = 50°C, 95% RH, 96h

Effluent treatment COD (0.1% solution) : 1140

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-.. as soft etch to prepare the copper surface.

MEC Brite CA-.. will remove oxides and other residues and leave an ideal copper surface for proper levelling.

MEC Brite CA-.. is 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 assists in better post cleaning.

STORAGE AND HANDLING

1. Precipitations sometimes seen after prolonged storage will give no detrimental effects.
2. When exposed to the sunlight, the liquid color will change from pink to dark purple, which give no effects on their efficiency.
3. Solder pots should be cleaned periodically to remove flux residue.
4. When not in use, keep containers closed tightly.
5. 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 and mouth 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 fully be taken specially for carbonized flux and waste flux.
7. In case of leakage, add sand or watered cloths, clear up and place in a container. Eliminate sources of ignition from the area.
8. To dispose of spent flux, rely on a disposal subcontractor or incinerate it.
9. Be careful that 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 obtains 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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