

EM2116-L

WATER SOLUBLE FLUX

DESCRIPTION

EM2116-L is a water-soluble flux designed to improve productivity. **EM2116-L** has no offensive odor and does not fume excessively during wave soldering. The post-soldering residue is minimal and very soluble in water. This formulation does not generate excessive foaming problems during post-washing operation, commonly encountered with others commercially available flux.

APPLICATION

EM2116-L is effective in soldering bare-copper, HALS, nickel-plated, gold plated and solder-plated boards and component's base surface. The flux can be applied by foaming, dipping and waving method. No saponifiers, neutralizers or detergents are necessary to be added in the post-wash compartment to aid removal of flux residue. The wash and rinse water is biodegradable. It is recommended to remove the post residue with the shorter delay time possible to achieve higher reliability and lowest possible ionic contamination level. For higher cleanliness contamination value, it is recommended to use DI water at the final water-rinse. Recommended topside preheat temperature is 120-130 °C.

PHYSICAL PROPERTIES AND RELIABILITY DATA

PHYSICAL PROPERTIES AND RELIABILITY DATA	SPECIFICATION	TEST METHOD	RESULT (TYPICAL)
Flux Type	-	-	Water Soluble
Class Type	Refer to J-STD-004	-	ORH1
Color / Appearance	-	-	Yellowish to amber Liquid
Odor	-	-	Alcohol
Flash Point (T.O.C.)	-	-	18 °C
Specific Gravity@25°C	-	-	0.875 ± 0.005
Solid Content	-	J-STD-004, IPC-TM-650, Method 2.3.34	16.0 ± 2.0 %
Halide Content (%) (Chloride and Bromide)	Max 2.3%	JIS Z 3197, Method 8.1.4.2.1	~2.0 %
pH (5% solution)	-	-	6.2-7.2
Corrosion Test	Major corrosion acceptable	J-STD-004, IPC-TM-650, Method 2.6.15	High
SIR, IPC (Typical) 85°C / 85% RH After 168 hours	Min 1 x 10 ⁸ Ω	J-STD-004, IPC-TM-650, Method 2.6.3.3	≥ 1 X 10 ¹⁰ Ω After cleaning

The information and statements herein are believed to be reliable but are not to be construed as a warranty or representation for which we assure legal responsibility. Users should undertake sufficient verification and testing to determine the suitability for their own particular purpose of any information or products referred to herein. No warranty of fitness for a particular purpose is made. Properties are typical and not to be used as specifications.

THINNING

EM2116-L does exhibit some evaporation under normal operating conditions and in order to restore it to its original specific gravity, thinner should be used.

PACKING

Available in 25 litres carboy or 200 litres drum.

STORAGE

EM2116-L flux is alcohol-based and is flammable. Store away from sources of ignition.

HEALTH AND SAFETY

Refer to the MSDS for guidance on safety and health issues.

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