

## ROSIN Based ROL1/ROM1 Fluxes

### General Description

Ready-to-use, halide-activated, rosin-based fluxes for general use in the electrical and electronic industry, for applications where halide-free fluxes classified as 1131 DIN EN ISO 9454-1 do not provide sufficient flux activity. The fluxes are available with various solid content configurations. The fluxes provide for excellent uniform wetting also on slightly oxidized surfaces. The flux residues dry cure fast and are not tacky. They can easily and completely be removed with commercially available cleaners and solvents (on the basis of ethanol or 2-propanol). The fluxes do not contain any insoluble precipitations and remain clear also during longer storage periods.

### Classification

The Fluxes are classified as 1123 per DIN EN ISO 9454-1 or ROM1 and ROL1 per DIN EN 91190-1-1, resp.

### Technical Specification

Flux Type	850	878 M	878 V	880
Solid content [%]	40	17	8.5	48
Thinner		200		
Acid Number [mgKOH/gFlux]	62	56	24	86
Chloride content [%]	0.65	0.61	0.15	1.3
Gravity [g/cm <sup>3</sup> ] (20 °C)	0.891	0.828	0.804	0.898
Flash point [°C]	16.5	13	13	16.5
Class	1123 / ROM1	1123 / ROM1	1123 / ROL1	1123 / ROM1
Appearance	Uniformly clear, yellowish-brown			
Use	For soldering processes with high temperatures and long soldering times, esp. double wave.	For general applications in electrical and electronic industry.		For soldering processes with high temperatures and long soldering times, esp. double wave.

### Application

The fluxes can be applied by foaming, spraying, brushing or dipping.

### Process Control

No particular control is required in case of closed fluxing systems. In case of open systems it is important to control the solid content in order to achieve consistently good soldering results. Chemical titration is the most reliable method. Automatic density control is sufficient for the fluxes with high solid content.

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### Cleaning

The flux residues can easily and completely be removed with commercially available cleaners and solvents (on the basis of ethanol or 2-propanol).

### General Safety Precautions

The fluxes should be used according to industrial standards of practice. For safety advice please refer to the relevant material safety data sheets.

### Packing Sizes

The above-listed fluxes – as well as the respective thinners – are available in 10 L and 20 L containers.

### Storage

These solvent-based fluxes are flammable. Store away from sources of ignition. Observe a temperature range of 5 – 25 °C.

### Shelf Life

Under adequate conditions these fluxes can be stored in original unopened containers for a minimum of 12 months.

The information contained herein is based on technical data that we believe to be reliable and is intended for use by persons having technical skill, at their own risk. Users of our products should make their own tests to determine the suitability of each product for their particular process. TAMURA ELSOLD will assume no liability for results obtained or damages incurred through the application of the data presented.