



### ■ Product Description

ELSOLD Colored Tacky Fluxes are suitable for various applications in electronic manufacturing. The tacky fluxes combine the advantages of SMT adhesives and solder fluxes. Due to the good tackiness of the flux the components are kept in position until the solder process actually takes place. The fluxes are best used with existing solder deposits, however, additional solder, e.g. in the form of wire, may be added. The fluxes can be applied by dispensing, screen or stencil printing. All ELSOLD fluxes show excellent tackiness, very good wetting behaviour, wide process windows and are highly compatible with most printed circuit board finishes.

To fulfil the requirements of improved controllability, as in automatic optical inspections, Colored Tacky Fluxes contain neon colouring agents. Different types and concentrations were tested to develop a formulation, which enables an optimal visibility of the applied flux as well as a good inspection of the residues after soldering.

Typical areas of use are

- Rework and touch-up
- BGA assembly with solder balls
- Soldering of Flip Chip components

Different types of tacky fluxes are available to cover a multitude of possible applications.

### ■ Flux Types

ELSOLD Tacky Flux	Flux Type	Class per J-STD-004	Application
AP-10	No clean	ROL1	SnPb and high-lead solders (> 90% lead)
AP-20	No clean	REL0	High reliability. Especially suitable for lead-free solders
AP-40	No clean	REL0	High Reliability, as well as for leaded and lead-free alloys
SM-388	No clean	REL0	Higher activation. Suitable for SnPb and lead-free solders
WS 4200	Water soluble	ORM1	Can be washed off with water

### ■ Flux Colors



*ELSOLD  
Colored Tacky Fluxes  
are available in neon  
yellow and neon pink*

### ■ Application

Tacky fluxes are highly suitable for rework. The fluxes can be sparingly applied from the dispenser syringes. In case of stencil or screen printing, large-area deposits can be covered with flux in one printing operation. Manual application of the tacky fluxes is also possible in less demanding cases.

### ■ Cleaning

Cleaning of the tools can be done using isopropyl alcohol or in automatic cleaning equipment for stencils and misprinted boards. Flux residues can be removed with commercially available flux cleaning agents.

### ■ Packing

Syringes: 10 cc (10 g) and 30 cc (30 g)  
 Cartridges: 6 oz (150 g)  
 Jars: 90g and 180 g

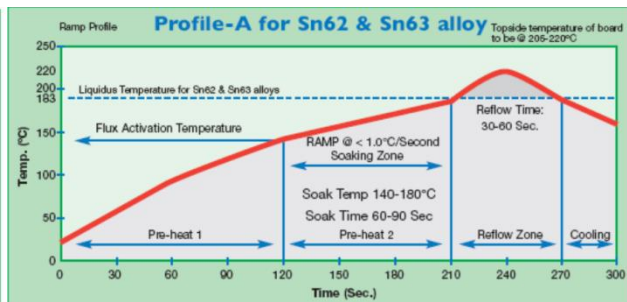
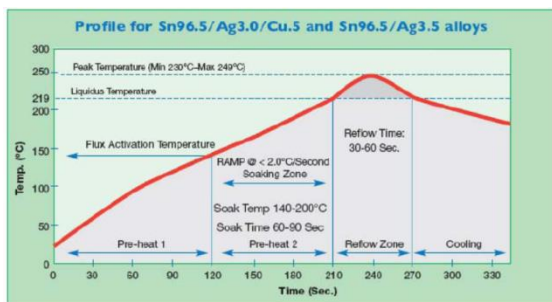
### ■ Storage and Shelf Life

Jars: 12 months in original unopened condition and if stored between 6 and 16° C  
 Cartridge: Maximum 12 months under continuous refrigeration between 6 and 16°C

Store syringes and cartridges vertical with dispensing tip down. Before opening the packing containers, the material should be allowed to reach room temperature. Never freeze tacky fluxes.

### ■ Reflow Profiles

The reflow profiles shown below can be used as starting points for the optimisation of individual soldering processes.



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. ELSOLD will assume no liability for results obtained or damages incurred through the application of the data presented.