

**HIGHLIGHTS**

- Highest activity of 1000 series fluxes
- Lowest residues
- High resistance against corrosion and electro migration – No Clean

■ **General Description**

ELFLUX 1025 NC is a solvent-based, halide-free, organic no clean flux for use in automatic wave soldering. ELFLUX 1025 NC is low in solids and is free from rosin. The flux leaves practically no residues and cleaning is in general not necessary.

Residues on the boards, if any, are not tacky. Electronic in-circuit-testing is possible without causing any problems. High surface insulation resistance values can be achieved by virtue of the low solid content of ELFLUX 1025 NC.

■ **Areas of Use**

General application in surface-mount technology, particularly in the automotive and telecommunication sectors. ELFLUX 1025 NC is effective in case of OSP-treated copper as well as for chemical Sn or electrolytic nickel or silver surfaces.

■ **Classification**

ELFLUX 1025 NC is classified as ORL0 per DIN EN 61190-1-1 and per IPC ANSI/J-STD-004.

■ **Technical Specification**

	ELFLUX 1025 NC	ELFLUX Thinner 201
Appearance	Clear, transparent liquid	Clear, transparent liquid
Smell	Mild alcoholic	Mild alcoholic
Density [g/cm <sup>3</sup> ] (20 °C)	0.804 ± 0.005	0.784 ± 0.005
Solids content [%] (per IPC-TM-650 2.3.34)	2.40	None
VOC content [%]	> 90, Solvent-based	100, Solvent
Acid number [mg KOH/gFlux]	20 ± 2	< 1
Halides [%]	None	None
Flash point [°C]	12	12
Ignition temperature [°C]	399	399
Recommended thinner	ELSOLD Thinner 201	

■ **Application**

ELFLUX 1025 NC can be applied by spraying. Dipping and brush application are possible for simple soldering operations. ELFLUX 1025 NC has been developed for soldering in air and inert gas

atmosphere. When selecting the appropriate process parameters it will deliver good results consistently. When setting the process parameters respect the guidelines of the equipment maker and the requirements of the printed circuit boards.

Optimum preheating temperature for most PCB's is 90 – 115 °C as measured at the top side of the PCB. For lead-free applications temperature can be increased by 20 – 30 °C without notable decomposition of activator package.

#### ■ **Process control**

When processing the flux in a spray fluxer from a closed system it is normally not required to control the density or acid number of the flux.

#### ■ **Cleaning**

Cleaning of the boards: ELFLUX 1025 NC is a no clean flux. Generally, cleaning is not required.

#### ■ **General Safety Precautions**

ELFLUX 1025 NC should be used according to industrial standards of practice. For safety advice please refer to the material safety data sheet.

#### ■ **Packing Sizes**

ELFLUX 1025 NC is available in containers of 10 L and 20 L.

#### ■ **Storage**

ELFLUX 1025 NC is flammable. Store away from sources of ignition. Recommended storage temperature: 5 - 25 °C.

#### ■ **Shelf Life**

Under adequate conditions ELFLUX 1025 NC 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. ELSOLD will assume no liability for results obtained or damages incurred through the application of the data presented.