STANNOL®

Wenn's ums Löten geht
When it's about soldering
Quand il s'agit du soudage

Technical Data Sheet

STANNOL® liquid flux 500-6B

Rosin based flux corresponding to DIN EN 29454-1 type 1.1.3, EN 61190-1-1 type ROL0 and J-STD-004 type ROL0.

Description

STANNOL® 500-6B is a ready-to-use flux for single-, double-wave and selective soldering processes. It can also be used for manual soldering as it leaves very safe residues either by use in a dipping process or in a **STANNOL® Flux-Pen**.

STANNOL® 500-6B possesses very good wetting properties on all available lead-free and lead containing solders and permits handling immediately after soldering because of its special resin composition. The halide-free resin residues have a high surface insulation value. A subsequent cleaning operation can therefore be eliminated. The hard residues provide improved adhesion properties for the application of conformal coatings of either silicone or polyurethane. Even connectors of brass or bronze, which normally require the use of halide-activated fluxes, can be successfully soldered with the **STANNOL® 500-6B** flux.

Application

In principle, all application methods are feasible, although when foaming is employed some modification of the fluxer may be needed. The preheating should be set in such a way that the temperature on the top side of the printed circuit board reaches 90°-110°C. The solder temperature should be between 245°-260°C.

Evaporation of solvent can change the composition. Evaporation causes an increase of the solid content and therefore the density increases. This can be checked with the **STANNOL® Mini-Titration-Kit**.

Physical Properties and Data

Colour:	amber coloured liquid
Density at 20°C:	0.801 g/cm^3
Flash point (closed cup):	13°C
Ignition point:	425°C
Solid content:	6 %
Acid value:	23 mg KOH/g
Copper mirror test:	passed
Silver chromate paper test:	passed
Halide content:	none
Surface Insulation Resistance:	1.5 x 10^{12} Ω uncleaned, soldered / 2.4 x 10^{12} Ω fluxed
Corrosion:	none
Environmental Conditions:	Bellcore TR-NWT 000078
Thinner:	**STANNOL® VD-500**

Shelf life

2 years after date of delivery (provided proper storage in originally sealed container).

Health and Safety

Before using please read the material safety data sheet carefully and observe the safety precautions described.

The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.

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