



## Technical Data Sheet

### STANNOL® liquid flux AK-S-1

Slightly halide activated, resin free flux conforming DIN EN 29454-1  
Type 2.2.2.A (F-SW 25).

#### Description

The **STANNOL® AK-S-1** was formulated for cable tinning, stranded wires, tinning of components leads or copper-passivated surfaces, which are difficult to solder.

#### Application

**STANNOL® AK-S-1** can be applied by a dipping method. Depending on the process, other application methods are also possible e.g. brushing, dropping and dispensing.

The flux is suitable for dip, wave and induction soldering processes, soldering with heating plates or soldering irons.

The flux residues after soldering are very low and in general not visible. It should be tested whether residues must be removed or remain on surfaces. Any excess residues (in case of overdosing) can be removed with an appropriate, organic solvent cleaner of the **STANNOL® Flux-Ex** series (e.g. **STANNOL® Flux-Ex Flux-Ex 402**) or the thinner **STANNOL® VD-500**.

#### Physical Properties

|                              |                         |
|------------------------------|-------------------------|
| <b>Colour:</b>               | colourless liquid       |
| <b>Density (20°C):</b>       | 0.810 g/cm <sup>3</sup> |
| <b>Flash point (Abel):</b>   | 12°C                    |
| <b>Ignition temperature:</b> | 425°C                   |

**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.

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