



EIE Enterprise (M) Sdn. Bhd. (944691-T)

HI-GRADE #1081 HALIDE-FREE WATER

SOLUBLE FLUX

DESCRIPTION

HI-GRADE #1081 FLUX is a halide-free, organic acid activated water soluble flux for wave soldering. Free of chloride, fluoride, bromide and polyglycols, HI-Grade #1081 reduces or eliminates effluent treatment and provides complete cleaning in water to low ionic levels while leaving a surface which has high surface insulation resistance (SIR).

BENEFITS

- Mild activity
- Cleans to low ionic levels
- Halide free, polyglycol free
- Reduces or eliminates effluent treatment

APPLICATION AND USES

HI-GRADE #1081 provides excellent wetting on solder and copper surfaces. The unique blend of activators makes it ideal for use in wave soldering operation. HI-Grade #1081 Flux is mildly active, contains no glycol, and the easy water cleaning eliminates the cost and environmental concerns of solvent cleaning.

HI-GRADE #1081 FLUX residues are removed by hot water between 140-160° F to MIL-STD-2000 requirements. Water quality has the largest impact when water washing. A final rinse in deionized water will produce the best results. There is no need to add rinse aids, defoamers or neutralizers into the rinse water.

Hi-GRADE #1081 FLUX can be applied by foam, dip, wave or spray fluxing equipment. The best results can be obtained by following these guidelines:

- 1) Keep foam-head, wave height, or pot level consistent through appropriate adjustments. Replace flux daily if self-contained storage is not available; otherwise, replace after 40 hours of operation.
- 2) Adjust specific gravity to the nominal level, + 0.005, with Hi-Grade #16-1081 Thinner.
- 3) Add fresh flux to maintain the appropriate flux level.
- 4) Clean fluxing equipment regularly to remove debris, trapped oil or water. When foam fluxing, clean foaming stone in the Hi-Grade #16-1081 Thinner whenever the flux is changed, or as needed.

HI-GRADE #1081 WATER SOLUBLE FLUX (continued)

PHYSICAL PROPERTIES

<u>TEST</u>	<u>#1081</u>
Color	Light straw
Specific Gravity @ 77° F (25° C)	0.957
@ 60° F (15.5° C)	0.963
Solids Content	25.0
Pounds per Gallon	7.96
Halide Content	None
Flash Point	65° F TCC

SAFETY

All fluxes with low flash points should be handled with caution. Store in a dry, well ventilated area away from sparks, flames, direct heat. Consult material safety data sheet for full details.

PACKAGING

25 /LTR