



TECHNICAL DATA SHEET

Electronic flux BRO-B004

No Clean, water based flux, di-carboxylic acids, resin free, halogen-free (WEEE/RoHS conformant) Type 2131 // ORLO acc. ISO 9454 // DIN EN 61190-1-1

TECHNICAL DATA

| | |
|------------------------------|--------------------------------------|
| Appearance | Clear, colorless liquid |
| Solid content | 3.5-3.7 wt. % |
| Density (20°C) | 0.97-1.00 g/ml |
| Acid number | 28.0-32.0 mg KOH/g |
| Activators | Dicarboxylic acids |
| Solvent | Water |
| Additives | Wetting agents, alcohol compound <7% |
| pH (20°C) | 3-6 |
| Initial boiling point | >90°C |

GENERAL INFORMATION:

The hybrid BRO-B004 was developed to be used in wave, selective soldering, hand soldering and rework and accomplishes with DIN-EN61190-1-1:LO specification. It contains halogen-free activators in a special adapted to the combination thermal requirements of soldering processes.

It exhibits a solids content of 3.5% to 3.7%. It has been developed for a very broad range of applications. The soldering properties are very good, particularly with rise-through and circuit-board wetting. The processing window is very broad with great thermal stability. Practice has shown that with proper application, no washing of circuit boards soldered with this flux is needed. The circuit boards are visually clean.

CUSTOMER ADDED VALUE:

- Very good soldering properties (capillarity, wetting)
- Available as concentrate (granulate)
- Broad process window (high thermal stability, good activity over a long interval)
- Very good residue behavior (optically very clean, high SIR)



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INSTRUCTIONS FOR USE

- Foam fluxing: Not recommended.
- Spray fluxing: If possible, try at first a quantity of 20-30 ml/min. and observe the distribution of the flux. After that, correct to the quantity. Air pressure: 18-22 l/min.
- Preheating: Entering the solder wave, the temperature on the topside of the PCBs should not be below 100°C. For hand soldering and rework is not necessary preheating, room temperature is sufficient.

STORAGE AND HANDLING

- Keep cool. Protect from sunlight. Minimum storage temperature: +10°C.
- Keep container tightly closed.
- Do not handle until all safety precautions have been read and understood.

PACKING UNITS: Plastic jerri cans of 5, 10 and 20 liters.

Plastic bottle 1L./15 units: 1carton box

15 ml. glass container with an application brush /18 units: 1carton box

Revision date: 01/12/2023