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| Updated: 15/04/2020 | Technical Data Sheet |  |
| Ref. : Flux | Soldering Flux Type <u>MBO 45</u> | |
| Creation date: 08/03/2001 | No Clean flux | |



1 – GENERAL CHARACTERISTICS :

- **MBO 45** is specifically manufactured to leave no residue after flow soldering, so eliminating the need for post cleaning of circuit, offering an appreciable gain of production time.
 - Dirt accumulation in machines and on circuit boards carriages is also reduced.
 - Soldering efficiency is equal to resinous flux, type RMA.
 - Halide free, it leaves no corrosive elements after processing.
- MBO 45** flux is manufactured to conform European Standards.

2 – PHYSIOCHEMICAL CHARACTERISTICS :

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|-----------------------------|------------------------|
| a) Solution | : Alcoholised |
| b) Colour | : Colourless |
| c) Density at 20°C | : 0.803 +/- 0.5% |
| d) Non volatile content | : 1.7 % |
| e) Chlorine rate | : Halide free |
| f) Flash point | : 18°C |
| g) Acidity | : 13.3 +/- 0.5 mg/g |
| h) Corrosiveness | : None |
| i) Insulation resistance | : > 100 GΩ |
| j) Efficiency (SAR) | : <30° SAR – grade III |
| k) J-STD 004 classification | : ORL0 |


3– INSTRUCTION OF USE :

Flux MBO 45 can be used with all fluxing systems – spray, foam, sprinkle, dipping, etc. in all types of automatic machines (single or double wave).

Carry out a regular check of the density or acidity index and maintain the level by adding **DILUANT D45**. Nominal density is 0.800 to 0.810 @ 20°C.

The circuit topside drying temperature after fluxing should be 90 to 100°C.
The alloy bath temperature should be between 235 and 260°C.

Conveyor speed should be between 0.8 and 2 meters per minute, depend on the type of circuit. Contact time between circuit and solder wave should not exceed 4 seconds.

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4 – MISCELLANEOUS :

Health and Safety : As with all soldering fluxes, **MBO 45** must be used in a well ventilated area away from any source of flame or ignition.

Packaging : Throwaway plastic containers of 5, 10 and 20 litres.

Storage : In original hermetically sealed containers, stored at an ideal temperature near 20°C for 12 months maximum.

ADDITIONAL INFORMATION:

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in France).



We cannot anticipate any and all conditions and situations under which the information and our products or the combination of both with others will be used. We do not assume any liability in the safety and suitability of our products alone or in combination with others. Users must make their own tests to determine the safety and suitability of each product used alone or with other products for their own use. Except any previous written agreement, our products are sold without guarantee and customers must assume all liability for any loss or damage suffered by themselves or by third parties, either from handling or use of our products alone or with others. In case of any difference or variation seen during the use of the products we request that you contact our technical department.