



Technical Data Sheet

STANNOL® - Liquid Flux 500-6B

STANNOL® Soldering Flux 500-6B is a rosin based flux meeting specification DIN EN 29454-1 type 1.1.3, EN 61190-1-1 type ROL0 and J-STD-004 type ROL0.

STANNOL® Soldering Flux 500-6B is a ready-to-use flux for single- and double-wave 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® FluxPen**.

STANNOL® Soldering Flux 500-6B possesses very good wetting properties, 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.

Physical Properties

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 VD-500

Packaging 2.5 litre cans (Article No. 164014)
25 litre cans (Article No. 164016)
200 litre drums on request

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

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