FluxPlus®

EFD® A NORDSON COMPANY

We listen and respond.

6-412 Product Specification

Product Description

EFD 6-412 No-Clean (NC) flux is designed for both dispensing and printing. It offers up to eight (8) hours of print life and four (4) hours of tack time. It offers exceptional lot-to-lot consistency with excellent dispense and print resolution and reproducibility.

6-412 NC flux residue is colorless, transparent, hard, non-corrosive, inert, and designed to be left on your assembly. Cleaning is optional.

FluxPlus dispensable and printable paste fluxes are designed to meet a wide variety of fluxing needs and are formulated to perform well with all dispensing and printing technologies in use today. Electronic assembly applications include BGA/PGA sphere and pin attachment, BGA and other rework, and fluxing of pre-bumped flip chips and solder pads.

Quality

EFD paste fluxes meet or exceed IPC Joint Industry standards J-STD-004 for flux.

Material Properties

J-STD-004	
Classification	ROL0
Copper Mirror	No Breakthrough
Silver Chromate	Pass
Fluoride Spot	Pass
Corrosion	None
SIR 24 hours*	1.1 x 10 Ω
SIR 96 hours*	9.7 x 10^9 Ω
SIR 168 hours*	7.0 x 10^9 Ω
Physical Properties	
Acid Value (ASTM D-465-82)	105 +/- 10
Color	Amber
Specific Gravity	1.01 +/- 0.05
Percent Solids	59 +/- 2%
Penetration Value (ASTM D-937-92)	200 +/- 25 mm

Delivery

FluxPlus paste flux is shipped direct from our factory via two-day air service within three (3) business days of order receipt, excluding weekend deliveries. For the full range of packaging options, reference our Packaging Guide.

Storage and Handling

Store between 4˚ and 21˚C (40˚ and 70˚F). Do not Freeze. Allow four (4) hours at room temperature before using. Exposure to temperatures in excess of 27˚C may cause chemical decomposition. When not in use, containers should be kept closed.

Guarantee

EFD paste fluxes have a guaranteed shelf life of six (6) months from date of shipment when stored and handled as recommended.

Safety

Read the MSDS prior to use. Care should be taken to prevent accidental ingestion and contact with the eyes. Use adequate ventilation and avoid breathing soldering fumes. Wash hands thoroughly after use.

Technical Support

Our Product Specialists and Technical Service Team are available to evaluate your process requirements and develop a soldering solution with you.

Application Guidelines

Deposition	
Best Working Environment	20˚C to 25˚C (68˚F to 77˚F) at 35% to 60% Relative Humidity
Fluxing Process	Ref: FluxPlus Fluxing Guide
Reflow	
Heating Guideline	Max 330ºC
Cleaning	
Solvents	Ref: Flux Residue Removal Guide**
No Clean	Residue is designed to be left in place for typical applications.

* Nominal/Typical values

** EFD does not sell or recommend specific solvents but collaborates with any solvent vendor.

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