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TECHNICAL DATA  
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CIRCUIT CHEMICALS  
PRODUCT RANGE

## **LEAD FREE HOT AIR LEVEL FLUX 1295EM**

- for PTH and surface mount with photoimageable, two-pack or UV solder masks -

### **Description:**

BLT Hot Air Levelling Flux **1295EM** has been formulated to provide PC manufacturers with a product to suit all types of printed circuit and solder mask. BLT's **1295EM** produces level, brilliant solder deposits with minimal flux residue. Compatible with all lead free and leaded alloys.

### **Benefits:**

- Free rinsing in warm water
- Low smoking
- Non offensive odour
- Complete wetting
- Uniform lead free coverage
- No solder pick-up
- Good laminate and solder mask protection
- Low foaming in rinse water
- Reduces copper pick-up in solder pot
- Reduces machine attack

### **Application:**

#### **Pre-cleaning**

Copper should be thoroughly degreased and micro etched prior to flux application.

**Copperwet 1130** and **Copperwet 1173** have been formulated specifically for this application and are suitable for use in spray equipment.

#### **Flux Application**

Ideally **1295EM** should be applied using automatic, soft roller coating units but can be applied by dipping and allowing excess flux to drain off the boards.



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### **Rinsing**

Spray rinsing with warm water is recommended to ensure complete removal of all flux residues.

### **Equipment**

**1295EM** can be used with all commercially available Hot Air Levellers.

### **Process Control**

It is normally acceptable to 'top-up' flux reservoirs with new flux to compensate for drag out. However if the leveller is used intermittently then it is advisable to periodically drain the flux reservoir and refill with new flux.

### **Physical Properties**

<b>Appearance</b>	Viscous Yellow Brown liquid
<b>S.G at 20°C</b>	1.1
<b>pH</b>	2.0 (10% solution)
<b>Flash Point</b>	> 270°C
<b>Pour Point</b>	5°C

**NOTE:** Do not allow product to freeze as separation will occur if the product solidifies.

### **Handling Precautions:**

Provide extraction to remove fumes from the work area.  
Avoid contact with skin and eyes.  
Wash spillages with water.  
Refer to separate Material Safety Data Sheet.

### **Disposal of Spent Baths and Spillages:**

Rinse spillages with water.  
Spent baths should be removed for controlled incineration.

### **Warranty**

All reasonable endeavours have been made to ensure that the information contained in this data sheet is accurate, but it is submitted on the express condition that BLT Circuit Services Ltd. shall be under no liability whatsoever in respect thereof or for any loss, injury, damage or liability of whatsoever nature arising, suffered or incurred as a consequence of its use.