



# PRODUCT DATA SHEET

## No-Residue™ Flux

January, 2008

### DESCRIPTION

- ◆ **IF2005Mz** is known as the benchmark in No Clean/Residue-Free soldering. This Halide Free product is the chemistry of choice by the leading electronics assembling companies, due to its unparalleled track history. This flux together with the correct machine parameters will totally eliminate the cleaning process without compromising board cosmetics and soldering results.
- ◆ **IF2005Mz** can be used in foam, spray and dipping applications. Recommended preheat temperature 230-266°F (100-130°C) measured at topside of the board before entering the wave. Dwell time in the wave 3 to 4 seconds at solder pot temperatures of 480-500°F (250-260°C) for Sn/Pb and 500-520°F (260-270°C) for lead-free (depending on alloy selection).
- ◆ **IF2005Mz** is the only No-Clean/Residue Free chemistry that ever passed **Mil-F-14256F** and **MIL-STD-2000A Qualifications** without cleaning. (Compliance reports: Mil, Bellcore and IPC are available on request.) Classified as type **ORL0** under IPC J-STD-004.

PHYSICAL PROPERTIES	IF2005Mz Flux	T2005M Conditioner
Appearance	clear, colorless	clear, colorless
Specific gravity @ 20°C	0.810	0.792
Solids	1.8 %	None
Water content	3 - 4 %	N / A
Acid number mg KOH/gr.	11 -17	0.1 - 0.5
Flash point T.O.C.	59°F - 15°C	59°F - 15°C
Required conditioner	<b>T2005M</b>	--

The process parameters are application specific. For information on process specifics and parameters contact our Technical Department at 1-800-843-3589 or 214-350-5565

**SAFETY** **IF2005Mz** flux is a flammable material. Avoid exposure to heat, sparks and open flames. Material Safety Data Sheets are available upon request.

**PACKAGING** Available in 1-gallon jugs, 5-gallon pails and 55-gallon drums.

**STORAGE** **IF2005Mz** has an **unlimited** shelf life when stored in the original sealed container at ambient temperatures.

**“Our commitment to quality and customer service is our most valuable asset”**

The information contained herein is offered free of charge for use by technically qualified personnel at their discretion and risk. All information and recommendations contained herein are based on test and data which we believe to be reliable, but the accuracy or completeness is not guaranteed and no warranty of any kind is made with respect hereto.

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