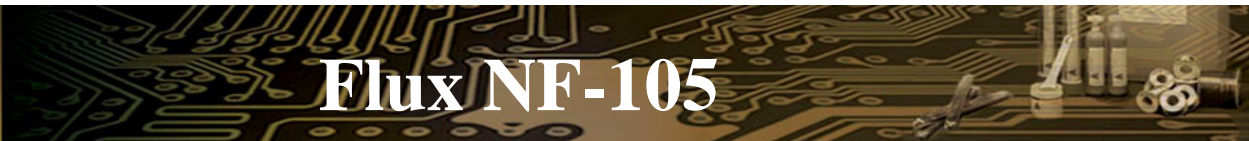




Flux NF-105



Water Soluble Liquid Flux

Description:

NF-105 is a water soluble heat exchange flux offering superior performance for your complete brass & copper heat exchange process. This flux is to be utilized for your tube, bake, header dip, & hand soldering. It is compatible with tin/lead or lead-free alloys. NF-105 offers a high dilution ratio with minimal charring and does not leave a corrosive residue.

Features:

- Zinc Free – contains no heavy metals
- Bright, smooth surface – good solder flow
- High temperature stability – no charring
- Non-corrosive residue – no post soldering cleaning
- Environmentally friendly – safe to use
- Low smoke & odor – operator friendly
- High dilution ratio – cost effective
- Excellent wetting – strong bond
- Minimal residue – clean surface
- Reduces equipment corrosion
- Low foam – compatible with spray/waterfall systems

Flux Application:

NF-105 is formulated for application via dip, brush or spray.

Dilution Ratio		
Bake 25:1	Header 2:1	Hand 2:1

Acid Number and Density:

Dilution Chart			
Flux + Water	Specific Gravity g/cc	NF105 Acid Value	NF105 Free Acid
		IPC-TM-650 2.3.13	Hach Test Kit 22709-00
Super conc.	1.0925	126.0	22.29
1+1	1.0462	63.0	11.15
1+2	1.0308	42.0	7.34
1+3	1.0231	32.0	5.32
1+4	1.0185	25.2	4.17
1+5	1.0154	21.0	3.41
1+6	1.0132	18.0	2.90
1+7	1.0116	15.7	2.53
1+8	1.0103	14.0	2.15
1+ 9	1.0092	12.6	1.89
1+ 10	1.0084	11.4	1.63
1+ 11	1.0077	10.5	1.52
1+ 12	1.0071	9.7	1.39
1 + 13	1.0066	9.0	1.26
1+ 14	1.0062	8.4	1.14
1+ 15	1.0058	7.9	1.01
1+ 16	1.0054	7.4	0.88
1+ 19	1.0046	6.3	0.63
1+24	1.0037	5.0	0.50

Acid Value: As IPC J-STD-004B IPC –TM-650 2.3.13

Free Acid: Determined by Hach Test Kit 22709-00, with Methyl Orange Indicator

Cleaning:

NF-105 is easy to clean with water.

Handling and Storage:

- NF-105 Flux has an unopened shelf life of 2 years when stored at room temperature.
- Do not store near fire or flame.
- Keep away from sunlight as it may degrade product.
- NF-105 Flux is shipped ready-to-use, no mixing necessary.
- Do not mix used and unused chemical in the same container.
- Reseal any opened containers.

Safety:

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying Material Safety Data Sheet for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

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AIM IS ISO9001:2008 & ISO14001:2004 CERTIFIED

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