STANNOL®

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When it's about soldering
Quand il s'agit du soudage

Technical Data Sheet

STANNOL® KOLO 400-25

Description

STANNOL® KOLO 400-25 is a halide-activated rosin flux and conforms to DIN EN 29454-1 1.1.2 (former DIN 8511 F-SW26).

STANNOL® KOLO 400-25 has been specially formulated for applications in the electronic industry for surfaces which are difficult to solder. An excellent wetting efficiency when soldering printed circuits, especially in foam fluxers, is achieved by the use of a stabiliser. The flux has good wetting properties and guarantees a complete flux coverage during the soldering process due to the high rosin contents. The flux residues remaining after the soldering process are dry, plastic and transparent.
STANNOL® KOLO 400-25 has a very wide process window and can be used without any problems.

Application

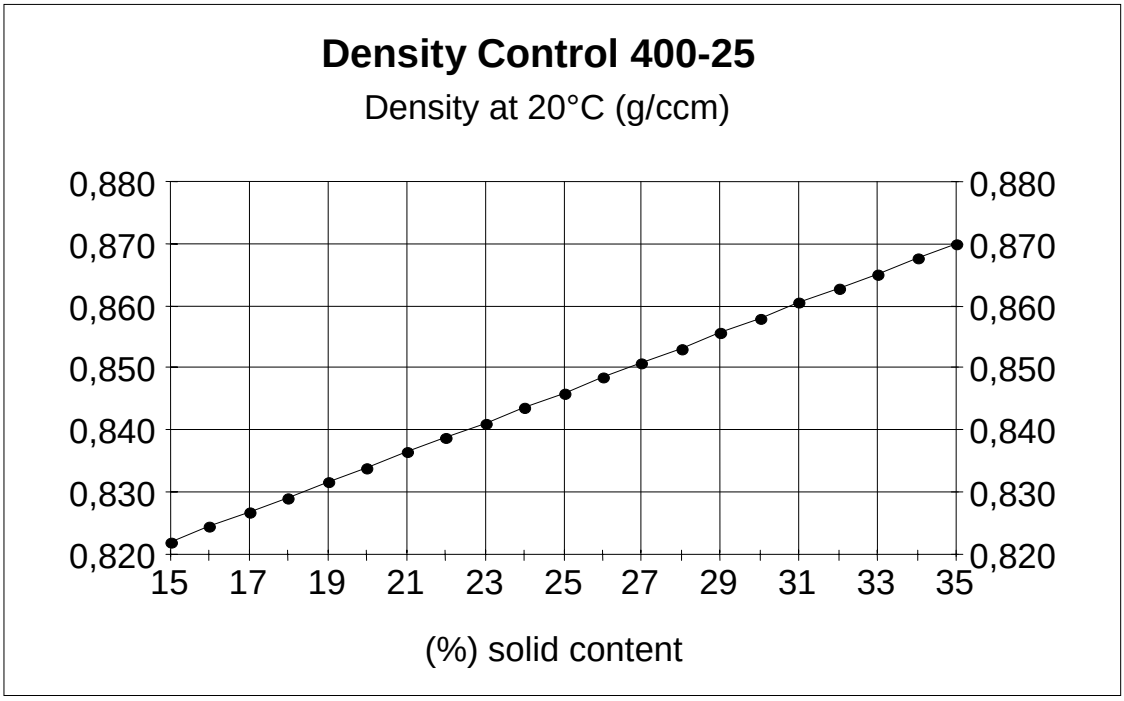
STANNOL® KOLO 400-25 flux can be applied with foam fluxers, but also by dipping, spraying and brushing. The preheating temperature on the PCB top surface can be set between 80° C and 120° C. During the soldering process a considerable part of the flux is rinsed off the PCB. If cleaning is required, flux residues can be removed completely with a commercial cleaner. All known cleaning processes, such as by brushing, ultrasonic, steam etc. are appropriate.

Physical Properties and Data

Colour:		amber liquid
Density (at 20° C):		0.846 g/ cm³
Flash point (closed crucible):		13° C
Ignition temperature:		425° C
Solid content:		25%
Acid rating:		48 mg KOH/g
Copper mirror test:		passed
Chromate paper:		discoloration
Halide content:		1.5% IPC – SF – 818
Surface resistance:	$1.0*10^{12}\Omega$ uncleaned, soldered	$4.0*10^{11}\Omega$ fluxed
E-corrosion:	none	none
Requirements:		Bellcore TR-NWT 000078

By evaporation the flux composition may change which can be corrected by adding the correct thinner volume. When the flux density rises above 0.848 g/cm³ (at 20° C) it should be reset to 0.846 g/cm³ (at 20° C). Only the thinner VD-500 should be used to compensate for evaporation losses, as this thinner type contains the stabilizing components required especially for foam fluxers.

Determine the correct density (with regard to the temperature) using an areometer and on the basis of the following diagram:



As the density is also depending on the temperature, it must be corrected by –0.001 g/cm³ per degree of rise in temperature.

Thinner VD-500

Can sizes

2.5 l canister,	Part No.: 160053
25 l canister,	Part No.: 160052
200 l drum upon request	

Health and Safety

Read the Material Safety Data Sheet carefully and observe the safety instructions before use.

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