



## TEST FLUXES

Test fluxes for solderability testing

### DESCRIPTION

Test fluxes for solderability testing corresponding to national and international standards.

### TEST FLUX SM/NA

SM/NA is a non-activated flux (25%-solution of rosin in Propan-2-ol).

SPECIFICATION	SM/NA
Density at 20°C:	0.846 ± 0.002 g/cm <sup>3</sup>
Solid content:	25 ± 0.5%
Halide content:	zero
Acid Value:	42 mg KOH/g
Boiling point:	>82°C
MAK-(TLV) of Solvent:	200 ppm
Flashpoint of solvent:	12°C

Specifications relevant to Test Flux SM/NA: BS2011:2.1.Ta, 1981 4.6.2, 4.8.2.3, 6.6.1; IEC 68-2-20, 1979 4.6.2, 4.8.2.3, 6.6.1 and IPC-S-801, 1970 5.2

### TEST FLUX ACTIEC 2

ACTIEC 2 is a halide activated flux with halide content of 0.2% related to solid content of 25% rosin (colophony) activated with Diethyl Ammonium Chloride.

SPECIFICATION	ACTIEC 2
Density at 20°C:	0.844 ± 0.002 g/cm <sup>3</sup>
Solid content:	25 ± 0.5%
Halide content:	0.2%, referred to solid content
Acid Value:	42 mg KOH/g
Boiling point:	>82°C
MAK-(TLV) of Solvent:	200 ppm
Flashpoint of solvent:	12°C

Specifications relevant to Test Flux ACTIEC 2: BS2011:2.1.Ta, 1981 4.6.2; BS9760, 1977 1.2.6.6; JEDEC JESD 22-B102D, IEC 249; IEC 326-2, IEC 68-2-20, 1979 6.6.2 and J-STD-002C

## TEST FLUX ACTIEC 5

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ACTIEC 5 is a halide activated flux with halide content of 0.5% related to solid content of 25% rosin (colophony) activated with Diethyl Ammonium Chloride.

SPECIFICATION	ACTIEC 5
Density at 20°C:	0.845 ± 0.002 g/cm <sup>3</sup>
Solid content:	25 ± 0.5%
Halide content:	0.5%, referred to solid content
Acid Value:	42 mg KOH/g
Boiling point:	>82°C
MAK-(TLV) of Solvent:	200 ppm
Flashpoint of solvent:	12°C

Specifications relevant to Test Flux ACTIEC 5: BS2011:2.1.Ta, 1981 4.6.2; 4.8.2.3, 6.6.3 and IEC 68-2-20, 1979 4.6.2, 4.8.2.3, 6.6.3 and J-STD-002C

## TEST FLUX ACTIEC LF-A

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ACTIEC LF-A is a halide-free activated flux with small rosin content of 1.5%.

SPECIFICATION	ACTIEC LF-A
Density at 20°C:	0.803 ± 0.002 g/cm <sup>3</sup>
Solid content:	6 ± 0.1%
Halide content:	zero
Acid Value:	43 mg KOH/g
Boiling point:	>82°C
MAK-(TLV) of Solvent:	200 ppm
Flashpoint of solvent:	12°C

Specifications relevant to Test Flux ACTIEC LF-A: IEC 60068-2-69

## TEST FLUX ACTIEC LF-W

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ACTIEC LF-W is a halide-free activated flux, water based and rosin-free.

SPECIFICATION	ACTIEC LF-W
Density at 20°C:	1.015 ± 0.002 g/cm <sup>3</sup>
Solid content:	4.8 ± 0.1%
Halide content:	zero
Acid Value:	42 mg KOH/g
Boiling point:	>100°C
MAK-(TLV) of Solvent:	---
Flashpoint of solvent:	---

Specifications relevant to Test Flux ACTIEC LF-W: IEC 60068-2-69

## **PACKAGING**

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Stannol Test Fluxes are available in 125ml containers.

## **SHELF LIFE**

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**SM/NA, ACTIEC 2** and **ACTIEC 5**: 2 years after date of delivery (provided proper storage in originally sealed container).  
**ACTIEC LF-A** and **ACTIEC LF-W**: 1 year after date of delivery (provided proper storage in originally sealed container).

## **HEALTH AND SAFETY**

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Before using please read the material safety data sheet carefully and observe the safety precautions described.

## **NOTICE**

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The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.