TECHNICAL DATA SHEET

LIQUID FLUX X33-08i PV

Low-residue flux optimized for photovoltaics

PRODUCT DESCRIPTION

Stannol solder flux X33-08i PV has been specially developed for use in the photovoltaic industry. The flux relies on a complex alcohol-based composition that is free of rosin and halogens and also has a low solids content. Due to its excellent wettability on solar cells, X33-08i PV is an excellent choice for companies in the photovoltaic industry looking for a high-quality and reliable soldering flux.

PRODUCT PROPERTIES

The product offers the following advantages:

- optimised for use in photovoltaics
- low residue and non-corrosive
- suitable for immersion and spray application
- excellent peel force resistivity
- excellent wettability on solar cells
- J-STD-004 Class ORL0

APPLICATION

The flux has been specially developed for the photovoltaic industry. It can be applied by spraying or dipping. Stannol X33-08i PV is suitable for both automated spray and stringer applications and can also be used for hand soldering. Stannol X33-08i PV meets the requirements for optical cleanliness. It leaves minor residues in the soldering system.

RECOMMENDED CONDITIONS OF USE

Fluxing: Stannol X33-08i PV can be used in spray fluxers such as immersion processes. Other application methods can be tested.

Preheating: In photovoltaics it is necessary that the flux is sufficiently dried in the preheating process.

Interconnect Ribbon: leaded and lead-free

Thinner: Stannol VD-500

Cleaner: For more detailed information, please contact our application engineers: info@stannol.de.
When changing from another flux to Stannol X33-08i PV, all transport equipment must be carefully cleaned.

Haberstr. 24 • 42551 Velbert • Tel: +49 (0)2051-3120-0 • Fax: +49 (0)2051-3120-111 • E-Mail: info@stannol.de • www.stannol.de

PHYSICAL PROPERTIES AND DATA

PROPERTIES	
Appearance:	clear, colourless liquid
Density [20 °C]:	0,81 g/cm^3
Solid content:	2 %
Acid value:	17 mg KOH/g
J-STD-004:	ORL0

The data in the table are typical values, they do not represent a specification.

	Norm J-STD-004	Method IPC-TM-650	Results
Halogen Content:	Version C (01/2022)	2.3.33D (06/2004)	PASS / (Zero)
Copper Mirror Test:	Version C (01/2022)	2.3.32D (06/2004)	PASS / L0
SIR-Test:	Version C (01/2022)	2.6.3.3B (06/2004) / 2.6.3.7 (03/2007)	PASS / >10^{8}Ohm
Corrosion Test:	Version C (01/2022)	2.6.15C (06/2004)	PASS / L0

SHELF LIFE

2 years from the date of manufacture (with correct handling and storage between 5 and 35 °C)

HEALTH AND SAFETY

Read the safety data sheet and observe safety measures before first use. The flux X33-08i PV is flammable. Store away from sources of ignition.

DISCLAIMER

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.

Haberstr. 24 • 42551 Velbert • Tel: +49 (0)2051-3120-0 • Fax: +49 (0)2051-3120-111 • E-Mail: info@stannol.de • www.stannol.de