

# SOLDER FLUX SF1000 BIO

Low-solids No-Clean flux



## PRODUCT DESCRIPTION

---

Low-solids No-Clean flux for selective soldering.

The selective flux SF1000 Bio is a flux from Stannol's sustainable greenconnect product family. The solder is the bio variant of the Stannol standard SF1000. The special feature: The use of renewable raw materials achieves a better ecological balance than a conventional flux – and this with consistently high product quality. According to DIN-EN 16785-2, a 95 percent bio-based content is determined.

Stannol soldering flux SF1000 Bio was especially developed for selective soldering of electronic assemblies. The low solids content in combination with specially tailored halogen-free activation results in excellent wetting ability on a wide variety of surfaces (e.g. OSP, Ni/Au, HAL), even with lead-free soldering alloys. This flux can also be used for other soldering processes such as wave and dip soldering.

## PRODUCT PROPERTIES

---

The soldering flux offers the following advantages:

- **J-STD-004** Class ORL0
- 70% CO<sub>2</sub> savings
- **No-Clean**
- low-residue
- resin-free
- optimized solids content – fast wetting
- wide process window
- good ascent

## APPLICATION

---

Stannol SF1000 Bio can be used in spray fluxers. The preheating temperature should be about 70-120 °C on the top of the circuit board, the preheating time can be between 60-180 seconds. These parameters ensure that the solvent evaporates and the flux is sufficiently activated. If necessary, the optimal preheating parameters must be determined experimentally based on the thermal requirements. SF1000 Bio shows good wetting at soldering temperatures in the range of 260 °C – 320 °C.

## PHYSICAL PROPERTIES AND DATA

---

PROPERTIES	SF1000 BIO
Colour:	colourless
Density (20 °C):	0,82 g/cm <sup>3</sup>
Content:	2,5 %
Acid value:	21 mg KOH/g
Thinner:	Stannol VD-900

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

	Norm J-STD-004	Methode IPC-TM-650	Ergebnis
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 <sup>9</sup> 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 10 and 30 °C)

## HEALTH AND SAFETY

---

Read the safety data sheet and observe safety measures before first use. The flux SF1000 Bio 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.