



Product Information

Palux 30 H

Flux for lead containing and lead-free hot-air-levelling
Item no.: 248000..

All information about our products is the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

Description

The flux **Palux 30 H** is a development adapted to the requirements of lead-free tinning in HAL-systems. Especially the higher process temperatures as well as the changed behaviour of wetting and oxidation in comparison to lead/tin-solders were taken into account.

Palux 30 H is also well suited for all PCBs produced by SMD-technology. After tinning the PCBs' surfaces are glossy and show very good electrical surface resistances.

Palux 30 H is

- completely water-soluble and therefore residue-free washable,
- non-foaming,
- peroxide-free,
- poor in solids.

Palux 30 H distinguishes itself by

- very good wetting of the PCBs,
- high temperature stability.

Palux 30 H

- removes the oxide layer from the copper surface without corroding the metal.

Physical Data

Colour	: pink, transparent
Odour	: organic
Density	: 1,07 – 1,10 g/cm ³
Viscosity	: approx. 350 mm ² /sec
pH-value	: approx. 1 (in a prepared water-solution)
Flash point	: > 300° C
Ignition temperature	: approx. 415° C

Application

Due to the emerging volatile compounds during the dipping process **Palux 30 H** should generally be used in encapsulated systems and under extraction of air as it is the case with the **Pentagal** machines **PENTA 550**, **PENTA 580** and **PENTA Automatic**.

The flux is water-soluble and non-foaming. It can be cleaned with cold water and guarantees lowest ionic impurities.

The extracted air can be cleaned by a packing-air cleaner, preferably functioning on the PENTA Air Cleaner's principle packed-bed scrubber .

The waste water is bio-degradable. If running washing-up water into waste water, local regulations have to be considered.

Further Advices

Palux 30 H is inert to stainless steel and titanium. Air knives, solder pots, covering panels as well as exhaust air systems will not be etched and therefore can be well maintained.

Generally there is no fire hazard during normal application even when slightly exceeding the current process temperatures for some 10° C. In case of inflammation despite the high ignition temperature (> 400° C) it is not due to the flux but to pyrophoric carbon, being formed with increasing dross developing over time by cracking of the organic flux matrix. Therefore necessarily it has to be taken care, that the dross will be regularly removed and the bath surface kept clean.

Palux 30 H should be transferred in rooms with exhaust air systems and processed in encapsulated systems.

Storage

The containers must be stored tightly closed and dry and kept in a cool place.

Shelf Life

Six months after production.

Delivery Form

Palux 30 H will be delivered in plastic containers of 30 and 1.000 litres.