



QUALITEK®

775 Flux Water Soluble Rosin

DESCRIPTION

775 is a water-soluble rosin flux containing organic acid and other activators. 775 has been specifically formulated for high-speed wave soldering applications and water cleaning systems. The superior fluxing activity of 775 provides fast wetting action and effective oxide reduction. Post soldering residue does not require immediate cleaning or rinsing since the residue is not corrosive like most organic fluxes. The residue is effectively removed in standard water cleaning systems without the need for detergent or neutralizer in the prewash stage.

BENEFITS

- High activity
- Minimal icicling and bridging
- Compatible with most solder masks and board laminates
- Immediate cleaning not required

APPLICATION METHODS

775 is designed for automatic soldering applications where rosin fluxes are not sufficiently active and inorganic acid fluxes are too corrosive. 775 may be applied by foam, wave, spray, dip, or brush methods. The flux applicator should be plastic or titanium only. The optimum topside preheat temperature is 170-200°F (77-94°C) on the topside of the circuit board. Adjust the specific gravity with Qualitek 700 thinner as needed to ensure consistent performance.

PHYSICAL & CHEMICAL CHARACTERISTICS

| | |
|------------------------------------------|-----------------|
| Color and Appearance | Amber Liquid |
| Solids Content, % (By Wt.) | 25.0 – 30.0 |
| Specific Gravity | 0.873 +/- 0.006 |
| Flash Point | 53°F |
| pH (as is) | 3.1 – 3.5 |
| Flux Classification per J-STD-004 | ORM1 |
| % Halides | 1.9 +/- 0.3 |
| Shelf life (un-opened) | 2 years |

RESIDUE REMOVAL

As with all water-soluble fluxes, post-soldering cleaning is required. Residues can be easily removed with both hot and cold water, thus; no neutralizer is needed. De-ionized water should be used in the final rinse for cleanliness results beyond MIL-28809A.

PACKAGING & STORAGE

775 flux is available in 1, 5 and 55 gallon containers. It should be stored in cool, dry place away from ignition sources.

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Consult MSDS for health and safety information