



**QUALITEK®**



**814 Flux**  
**Water-Soluble, Halide Free**

**DESCRIPTION**

814 is a halogen free, water-soluble organic flux. 814 provides a stable head of tight bubbles in foaming applications. The flux residues are removed easily in warm water.

**BENEFITS**

- Halide-Free
- Excellent wetting on virtually all types of substrates
- Excellent for lead tinning
- Remains active at high temperatures

**APPLICATION METHODS**

814 lends itself particularly well to foaming applications, and may also be applied by dip, spray, or brush methods. 814 provides a rapid break-up of bubbles that evenly coat the board surface. Should the flux become too concentrated due to solvent loss, add Qualitek 800 thinner to maintain the proper specific gravity and performance.

**PHYSICAL & CHEMICAL CHARACTERISTICS**

<b>Color and Appearance</b>	Light Amber Liquid
<b>Solids Content, % (By Wt.)</b>	20.0 – 24.0
<b>Specific Gravity</b>	0.942 +/- 0.010
<b>Flash Point</b>	53°F
<b>pH (as is)</b>	2.5 – 3.5
<b>Flux Classification per J-STD-004</b>	ORM0
<b>Shelf life (un-opened)</b>	2 years

**RESIDUE REMOVAL**

As with all water-soluble fluxes, post 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**

814 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