

PRODUCT DATA SHEET



COLOFREC CMA 155

Rosin Flux

DESCRIPTION

COLOFREC CMA 155 is a mildly activated rosin flux consisting in a 14 % part of specially selected, WW type, modified rosin and a synergic mixture of slightly halogenated activators in solution in an alcohol-based solvent.

COLOFREC CMA 155 flux was specially developed to answer all soldering problems encountered in professional as well as top quality consumer applications.

COLOFREC CMA 155 flux offers an excellent compromise of good activation for an efficient deoxidation of all PCBs, and a very low subsequent aggressive action.

COLOFREC CMA 155 provides uniform, bright and mildly charged solderings. The tinnings on power lines show no dewetting ; they are uniform, without any side outflow or dropping. Through a capillary action it ensures a complete, pinhole or gutter free filling of PTHs provided the PCBs were steam-heated prior to soldering.

USE

COLOFREC CMA 155 flux can be used in all types of usual fluxing processes : foam, wave, spraying, etc.

After fluxing it is suitable to pre-heat the PCB at 80/100°C in order to provide a proper activation of the flux. The typical recommended soldering temperature is 245/250°C but it can be matched to the PCB type and speed of the wave process.

The flux residue will be easily removed with :

- PROMOSOL 141b MS
- 3 M[®] HFE 7100 EL 20A Co-solvent
- SHELLSOL[®] TOPKLEAN EC20
- SHELLSOL[®] TOPKLEAN EC 16
- PROMOCLEAN DISPER 20
- PROMOCLEAN DISPER 80
- PROMOCLEAN TP 60
- PROMOCLEAN TP 6

Flux density should be checked regularly and maintained within a 0.830 to 0.840 range per addition of N°1 THINNER

[®] Registered mark 3M

[®] Registered mark SHELL CHEMICAL EUROPE



FRANCE

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SPECIFICATIONS

Bulk density at 20°C0.832
Colouramber yellow
Solubility in waternot soluble
 alcoholvery soluble
Flash point21°C
Dry extract wgt/wgt % (3 h at 105°C).....18
Halogens, % vs dry extract.....0,25
Acid index.....220 mg KOH/g
Chlorinated equivalent.....0.62

HEALTH & SAFETY

As all rosin fluxes **COLOFREC CMA 155** should be handled and used in a properly ventilated area away from flame sources. Fumes should also be drained in the fluxing and soldering areas by means of an efficient exhaust system.

PACKAGING

5 and 20 liters plastic drums.

STORAGE

Store in a cool and properly ventilated area and keep the containers tightly closed. Shelf life is one year.

The information given herein is offered as a possible helpful suggestion only. PROMOSOL assumes nos liability whatsoever arising out of its use by others.

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