



COLOFREC DD6

No-clean low residue rosin Flux

DESCRIPTION

COLOFREC DD6 is a low residue, rosin flux with halogen-free organic activators.

After soldering, flux residues left on the PCB are non aggressive and not liable to cause corrosion.

Electrical insulation performances are especially high when the boards are exposed to extreme accelerated ageing conditions.

APPLICATION

COLOFREC DD6 flux is ideally suited to single or double-wave soldering of conventional components or SMDs.

Besides, in PCB rework operations, **COLOFREC DD6**, when locally applied on connections with a brush or by spraying, enables to easily replace failing components using mini-wave, hot air or thermode.

SPECIFICATIONS

Bulk density at 20°C.....	0,825
Flash point	16°C
Dry extract (3 h at 105°C)	6 %
Halogen content.....	0
Acid index (mg KOH/g).....	32

PROCESSING

COLOFREC DD6 can be applied in foam or by spraying. We recommend the use of an air knife in order to achieve an homogeneous spreading of flux on PCB surface and to eliminate flux in excess from it. A preheat step enables to eliminate solvents by evaporation and to make metal surface deoxidizing easier. The temperature at wave entrance must be of 100-120°C on top of PCB, i.e. 120-140°C under it. During use, the density should be adjusted at regular intervals by adding N°1 THINNER.

In order to ensure consistent performances, it is recommended to entirely renew the flux after 40 work hours.



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P R O D U C T D A T A S H E E T



HEALTH & SAFETY

COLOFREC DD6 should be handled and used in a properly ventilated area away from any flame. Fumes should also be extracted from the fluxing and soldering areas by means of an efficient exhaust system.

PACKAGING

5 and 20 liter 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 no liability whatsoever arising out of its use by others.



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PRODUCT DATA SHEET



Table 1

COLOFREC DD6 SURFACE INSULATION RESISTANCE, IPC SF 818-B25

PROFILE	LOW 90°C*/120°C**		MEDIUM 100°C/130°C		HIGH 130°C/160°C		CONTROL BOARDS MEDIUM PROFILE
	50g/m ²	100g/m ²	50g/m ²	100g/m ²	50g/m ²	100g/m ²	
FLUX AMOUNT APPLIED ON BOARDS	50g/m ²	100g/m ²	50g/m ²	100g/m ²	50g/m ²	100g/m ²	
SIR (OHMS) AT T0 20°C-65% RH	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²
T0 40°C-93% RH	4x10 ⁹	0,5x10 ⁹	7,5x10 ¹⁰	1x10 ⁹	1,8x10 ¹⁰	1,1x10 ¹⁰	3,5x10 ⁹
T7D 40°C-93% RH 5 Volts	1x10 ¹⁰	3,5x10 ⁹	7,5x10 ¹⁰	4x10 ⁹	2,3x10 ¹⁰	2,7x10 ¹⁰	3x10 ¹⁰
T21D 40°C-93% RH 5 Volts	1,3x10 ¹⁰	7x10 ⁹	6,5x10 ¹⁰	7x10 ⁹	3,8x10 ¹⁰	1,7x10 ¹⁰	5x10 ¹⁰
T28D 40°C-93% RH 5 Volts	2,5x10 ¹⁰	1,1x10 ¹⁰	9x10 ¹⁰	1x10 ¹⁰	7,2x10 ¹⁰	1,9x10 ¹⁰	9x10 ¹⁰
T28D 20°C-65% RH	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²	>10 ¹²
T28D 85°C-85% RH 50 Volts	3x10 ⁹	2x10 ⁹	7x10 ⁹	5x10 ⁹	2x10 ¹⁰	9x10 ⁹	4x10 ¹⁰

*Topside Board Preheat Temperature.

**Topside Board Temperature after wave soldering

FPFGB 00006 TSI PRO 01 - 2/06/99



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