CHEMTRONICS®
Technical Data Sheet

TDS #CW 8300

CircuitWorks® Water Soluble Flux Pen

PRODUCT DESCRIPTION

CircuitWorks® Water Soluble Flux Pen is designed specifically to apply water soluble flux with precision control. The Water Soluble Flux consists of a neutral pH organic water soluble flux compatible with most solder masks. The high activity organic product cleans easily with water, reducing cleaning cost.

- pH neutral
- Completely portable package
- Cleans with water
- Excellent material compatibility
- Good soldering properties
- ORH1 Classification

TYPICAL APPLICATIONS

CircuitWorks® Flux Dispensing Pens precisely dispense flux on:

- Printed Circuit Boards
- Chip Carriers
- Heat Sinks
- Surface Mount Device Pads
- Switches
- Sockets

TYPICAL PRODUCT DATA AND PHYSICAL PROPERTIES

Water Soluble Flux Pen – CW8300

Flux Type	Water Soluble ORH1
Flash Point (TCC)	60°F (16°C)
pH	6.0 – 7.0
Appearance	Yellow Liquid
Odor	Slight
Shelflife	2 years
RoHS Compliant	RoHS WEEE Compliant

RELIABILITY PROPERTIES

Copper Mirror Corrosion: High
Tested to J-STD-004, IPC TM-650, Method 2.3.32

Corrosion Test: High
Tested to J-STD-004, IPC-TM-650, Method 2.6.15

Silver Chromate: Fail
Tested to J-STD-004, IPC-TM-650, Method 2.3.33

Chloride and Bromides: 2.2%
Tested to J-STD-004, IPC-TM-650, Method 2.3.35

Fluorides by Spot Test: Pass
Tested to J-STD-004, IPC-TM-650, Method 2.3.35.1

SIR, IPC (typical): Pass
Tested to J-STD-004, IPC-TM-650, Method 2.6.3.3

COMPATIBILITY

CircuitWorks® Water Soluble Flux Pen is generally compatible with most materials used in the electronics industry. As with any cleaning agent, material compatibility should be determined on a non-critical area prior to use.

USAGE INSTRUCTIONS

For industrial use only.
Read MSDS carefully prior to use.

Flux Application: Water Soluble Flux should only be applied to areas to be soldered. Hold pen vertically, touch surface of PCB and briefly depress tip to start liquid flow. Lightly wipe pen tip over surface to be fluxed. Use a ControlWipe™ dry wipe to remove flux buildup.

Cleaning: Flux residues must be removed after soldering as they are conductive and corrosive. No neutralizer, saponifiers or detergent are necessary for complete removal of flux residues. It is not recommended to use high mineral content tap water, therefore deionized or softened water may be used for cleaning. The optimum water temperature is 54-66°C (130-150°F). Chemtronics® Flux-Off® Water Soluble may also be used as a flux remover.

TECHNICAL & APPLICATION ASSISTANCE

ITW Chemtronics® provides a technical hotline to answer your technical and application related questions. The toll free number is: **1-800-TECH-401.**

AVAILABILITY

CW8300 9 gm (0.32 oz) Flux Pen

ENVIRONMENTAL IMPACT DATA			
ODP	None	VOC	Yes
HCFC	None	HFC	None

Ozone depletion potential (ODP) is determined in accordance with the Montreal Protocol and U.S. Clean Air Act of 1990. Hydrochlorofluorocarbons (HCFCs) are regulated under the Montreal Protocol as Class II ozone depleting substances. Volatile Organic Compound (VOC) information is calculated on a weight basis using the VOC definition of California Air Resources Board (CARB) Consumer Product Regulations, South Coast Air Quality Management District (SCAQMD) Rule 102 and the Federal definition published in 40 CFR 51.100(s). Hydrofluorocarbons (HFCs) are not currently regulated.

NOTE: This information is believed to be accurate. It is intended for professional end users having the skills to evaluate and use the data properly.
ITW CHEMTRONICS® does not guarantee the accuracy of the data and assumes no liability in connection with damages incurred while using it.

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