

# ALPHA<sup>®</sup> 630-20

## Water Soluble Halide-Free Flux

### DESCRIPTION

**ALPHA 630-20** is a halide-free, organic, water soluble flux formulated to meet the requirements of Military Specification MIL-F-14256F, Flux Type WSF-0 ("Does not contain Polyglycol(s)").

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### APPLICATION GUIDELINES

ALPHA 630-20 flux can be applied by foam, spray or wave techniques. Preheat temperatures of 80 to 105 °C (180 to 220 °F), as measured on the board topside, are recommended.

Post soldering residues should be removed after soldering as soon as possible. Thorough cleaning can be accomplished with 50 to 70 °C (120 to 170 °F) water. For critical cleanliness requirements, final rinsing with DI water may be required. ALPHA 2444 rinse aid may optionally be used to enhance the cleanliness of high reliability assemblies.

### TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Clear, yellow liquid	Recommended Thinner	ALPHA 411
Non-volatiles, % by wt	20	Shelf Life (from Date of Mfg.)	540 Days
Specific Gravity @ 25 °C (77 °F)	0.902 ± 0.005	IPC J-STD-004 Designation	ORM0
pH, 5% aqueous solution	2.60 ± 0.30	SIR per IPC J-STD-004	9.4 x 10 <sup>8</sup> ;
Halide Content	None	85 °C/85% R.H., 7 days	PASS
Flash Point (T.C.C.)	12 °C	Packaging Size	1, 5, 55 Gallons

**RECYCLING SERVICES**

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



**SAFETY & WARNING**

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at [MacdermidAlpha.com/assembly-solutions/knowledge-base](http://MacdermidAlpha.com/assembly-solutions/knowledge-base).**

**CONTACT INFORMATION**

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. **READ IT THOROUGHLY PRIOR TO PRODUCT USE.** Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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