Water Soluble Flux Pen

Description

837-P is a flux pen containing a water-soluble soldering flux. The flux has a neutral pH at room temperature and becomes highly activated at soldering temperatures. Post-soldering flux residues must be cleaned, but are easily removed with water.

837-P is designed for the prototyping, rework, and repair of conventional and surface mount circuit boards.

Features and Benefits

- *Flux meets IPC J-STD-004B and type ORH1*
- *For both leaded and lead-free solders*
- *Chiseled tip allows precise application*
- *Residues are easily removed with water*
- *RoHS compliant and VOC free*

Usage Parameters

Properties	Value
Shelf life	2 y
Storage temperature limits [a)]	18–27 °C [65–80 °F]

a) Store in a dry area, away from sunlight.

Properties

Flux Properties	Method	Value
Flux classification	J-STD-004B	ORH1
Flux type	J-STD-004B	Organic
Flux activity	J-STD-004B	High
Halides by weight	J-STD-004B	2.2% ±0.3%
Copper mirror	IPC-TM-650 2.3.32	Complete removal of copper film
Corrosion	IPC-TM-650 2.6.15	Pass
Surface insulation resistance (SIR)	IPC-TM-650 2.6.3.3	$1.8 \times 10^{10}\ \Omega$
Cleaning requirements	—	Required
Physical Properties	**Method**	**Value**
Color	—	Colorless
pH	—	6.8–7.8
Solids%	IPC-TM-650 2.3.34	17.5% ±1%
Density	ASTM D 4212	0.85 g/mL
Flash point	Closed cup	12 °C [53 °F]

Health and Safety

Please see the 837-P Safety Data Sheet (SDS) for further details on transportation, storage, handling, safety guidelines, and regulatory compliance.

Application Instructions

1. Depress the tip against a hard surface until the felt tip gets wet, but not flooding.
2. Gently brush the wet tip onto the soldering area to apply. To keep the felt saturated and the flow controlled, only press in the tip as needed.
3. Clean residue with hot or cold water. For best results, use deionized (DI) water for the final rinse.

Note: The felt tip on a new pen will take a few seconds to fully saturate, so expect an initial delay before the flux starts to flow. Moving the tip in circular motion can help loosen the felt fibers and speed up the saturation process.

Packaging and Supporting Products

Cat. No.	Packaging	Net Volume	Net Weight	Packaged Weight
837-P	Pen	10 mL [0.33 fl oz]	8.46 g [0.29 oz]	40 g [0.09 lb]
837LFWS-1L	Bottle	1 L [1.05 qt]	846 g [1.86 lb]	960 g [2.12 lb]

Technical Support

Please contact us regarding any questions, suggestions for improvements, or problems with this product. Application notes, instructions and FAQs are located at www.mgchemicals.com.

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