

# ECOFREC™ CMA 155



## Rosin flux

### FEATURES

**ECOFREC™ CMA 155** is a halogenated rosin flux that presents a very good wetting and a high aptitude for cleaning with solvent or detergent.

### SPECIFICATIONS

Bulk density at 20°C	0.832
Colour	amber yellow
Solubility	not soluble
in water	very soluble
in alcohol	
Flash point (°C)	21
Dry extract wgt/wgt % (3 h at 105°C)	18
Halogens, % vs dry extract	0.25
Acid index (mg KOH/g)	220
Chlorinated equivalent	0.62
Classification according to J-STD-004	ROL1

### CHARACTERISTICS

**ECOFREC™ 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.

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

**ECOFREC™ CMA 155** flux offers an excellent compromise of good activation for an efficient deoxidisation of all PCBs, and a very low subsequent aggressive action.

**ECOFREC™ CMA 155** provides uniform, bright and mildly charged soldering. The tinning 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.

### PACKAGING

Plastic drums

20 litres

## STORAGE & SHELF LIFE

Store in a cool and properly ventilated area (between 5° and 30°C) and keep the containers tightly closed. Shelf life is a year.

## PROCESS PARAMETERS

ECOFREC™ 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 easily be removed with :

PROCESS	Immersion / Spray system (water based solution)	Automatic system (solvent based solution)	Manual use (Solvent based solution)
INVENTEC SOLUTION	PROMOCLEAN™ DISPER 605 (as packaged, pH=11.9)	HFE + co-solvents : TOPKLEAN™ EL-20A TOPKLEAN™ EL-20R Under vacuum system : TOPKLEAN™ EL-20D	TOPKLEAN™ EL-10F QUICKSOLV™ DEF 90 TOPKLEAN™ EL-60

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

## HSE

As all rosin fluxes ECOFREC™ 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.

Please refer to MSDS before use.

No issues when used as recommended.

***Although the conformity to ROHS 2002/95CE applies to EQUIPMENT put on the market and not to a component in particular, we warranty that this product contains less than 0.1% of mercury, lead, chromium VI, polybrominated biphenyls (PBB) and polybrominated diphenyl ethers (PBDE) and less than 0.01% for the cadmium, in accordance with the decision of The European Commission dated 18/08/2005, fixing the maximal concentration values.***

*This data is based on information that the manufacturer believe to be reliable and offered in good faith. In no event will INVENTEC be responsible for special, incidental and consequential damages. The user is responsible to the Administrative Authorities (regulations for the protection of the Environment) for the conformity of his installation.*

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