

ECOFREC™ HT 504



High Temperature Solder Flux Excellent Wetting

BENEFITS

ECOFREC™ HT 504 is a non corrosive rosin based no-clean flux designed for soldering at high temperature of passive components and other power semiconductors. It can also be used for rework and repair.

- Very efficient wetting at high reflow temperature
- High auto-ignition point allowing soldering temperature from 250 to 400°C
- Excellent wetting on different surface finishes including silver, gold, copper and tin
- The flux residue is non corrosive
- The flux residue can be easily removed by a cleaning operation

SPECIFICATIONS

Flux appearance	Amber
Density 20°C (g/cm ³)	1
Solid content (%)	30
Acid index (mg KOH/g)	43.5 - 49.5
Halogen content	No halogen
Auto-ignition point	> 370°C

CHARACTERISTICS

ECOFREC™ HT504 is a high viscosity flux.

- Free of halide (Fluoride, Chloride, Bromide) and amine
- Non corrosive residue
- Complex blending of rosins, activators and solvents.

Standards tests	Results	Procedures
Flux Classification	ROL0	ANSI/J-STD-004
SIR/Electromigration (IPC)	Pass	ANSI/J-STD-004
Chromate paper	Pass	ANSI/J-STD-004
Copper mirror	Pass	ANSI/J-STD-004

PROCESS PARAMETERS

ECOFREC™ HT 504 can be applied by dipping or by brush.

For high temperature applications it is recommended to use several baths at different preheat temperatures to avoid damaging the parts.

Cleaning

After soldering, the flux residue remaining of ECOFREC™ HT 504 does not have to be removed by a cleaning operation as it is chemically inert. However, if cleaning is required, the residue left after reflow can be easily removed if needed with a large range of cleaning solutions, such as detergents, hydro-carbonated solvents or halogenated solvents, all included in the INVENTEC cleaning range.

PROCESS Type	INVENTEC Defluxing solutions
Manual	Topklean™ EL10F/ Topklean™ EL60/ Quicksolv™ DEF90 EL
Aqueous system (Immersion or spray)	Promoclean™ DISPER 605 and DISPER 607
Co-solvent system	Topklean™ EL 20 series
Under vacuum system	Topklean™ EL 20D
Mono-solvent (Azeotropic)	Promosolv™ 70ES

PACKAGING, STORAGE & SHELF LIFE

To ensure the best product performance, the recommended storage temperature range is room temperature.

Plastic drum	20L	18 months
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HSE

Use in well-ventilated areas. Safety glasses and gloves should always be worn when handling the flux. No issues when used as recommended.

Please refer to Material Safety Data Sheet before use.

INVENTEC Material Safety Data sheets can be found at www.quickfds.com

Although the conformity to ROHS 2015/863/UE applies to EQUIPMENT put on the market and not a component in particular, we warranty that this product does not contains in quantities exceeding less than 0.1% of Hg, Pb, Cr VI, PBB, PBDE, DEHP, BBP, DBP, DIBP and less than 0.01% of Cd, in accordance with the decision of The European Commission, fixing the maximal concentration values.

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