

# ALPHA<sup>®</sup> RF-800M

## No Clean Flux

### DESCRIPTION

**ALPHA RF-800M** is a no clean flux formulated with a small percentage of rosin and chloride-free activators. This singular rosin-activation system promotes excellent solder wetting to protect copper and solder coated surfaces.

Post soldering residue of Rosin Flux **ALPHA RF-800M** is minimal after wave soldering, leaving bright, shiny joints.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### APPLICATION GUIDELINE

**Flux Application:** ALPHA RF-800M is very well suited for the wave, foam and spray fluxing. The successful use of this no-clean flux is guaranteed because of the density and activity of the flux. Flux deposition density and uniformity are critical to the successful use of this no-clean flux. Applying ALPHA RF-800M to a dry flux coating density of 80 to 230 micrograms per square cm is recommended. Preheating the circuit assembly will partially dry the flux, enhance oxide removal and promote optimum wicking as well as superior solder joint formation. Degree of preheat is dependent on many variables such as conveyor speed, type of components and substrates. Entering the solder wave with a top side temperature of 90 to 115 °C and a bottom side temperature of 120 to 140 °C are recommended.

**Control:** In order to adjust, and maintain the equilibrium of the flux components, the addition of ALPHA Thinner is necessary, because of the low solids content of ALPHA RF-800M the specific gravity is not the effective method for controlling the solids content. The acid number should be checked instead and is recommended to be between 13 and 15 mgKOH/gm.

With circulation systems, impurities in the flux enrich themselves with time. To maintain consistent soldering performance, dispose of the used flux on a regular basis. After the removal of the used flux, the flux reservoir and the system should be cleaned with ALPHA Thinner. The reservoir can then be topped up with fresh flux. Upon resumption of the wave process, wait a few minutes so that the system can stabilize.

**TECHNICAL DATA**

Item	Typical Values	Item	Typical Values
Appearance	Clear, pale yellow liquid	Flash Point (T.C.C.)	13 °C
Solids Content, %wt/wt	2.5%	Shelf Life (from Date of Mfg.)	360 days
Specific Gravity @ 25 °C (77°F)	0.788 ± 0.005	IPC J-STD-004 Designation	ROL0
Acid Number (mg KOH/g)	13.8 ± 1.0	Packaging Size	25 liters

**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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