

# Technical Bulletin

## TSC 920 Water Soluble VOC-Free Flux

### DESCRIPTION

TSC 920 is a Water Soluble, VOC-Free flux specifically designed for industrial applications and inline solder tinning applications. This non-corrosive flux formulation may be used with any conventional tin/lead or lead-free solder alloys. TSC 920 flux contains propriety wetting agents within its formulation that increases its overall solderability performance at high temperatures. Post-soldering residues are non-corrosive and will not leave any black residues on the soldered substrate.

### FEATURES & BENEFITS

- Excellent solderability at high temperatures
- Non-corrosive residues
- VOC-Free flux
- Suitable for all common leaded and lead free alloys

### APPLICATION METHODS

- Dipping
- Spraying or waving
- Dip-Tinning

### HANDLING & STORAGE

Store in a closed container at room temperature. Solder flux shelf life is 2 years from date of manufacture.

Shelf life:

2 years	Unopened
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### AVAILABILITY

TSC 920 Water Soluble flux is available in: 1L / 5L / 10L containers

### TECHNICAL DATA

	Specification	Test Method
<b>Flux Classification</b>	ORH1	JSTD-004-00B
<b>Color and Appearance</b>	Clear Colourless Liquid	
<b>Specific Gravity (g/cm<sup>3</sup>)</b>	1.06 ± 0.01	
<b>Solids Content</b>	13 ± 1.0	IPC-TM-650 2.3.34
<b>pH Value (5% Soln)</b>	2.0 ± 0.5	IPC-TM-650 2.3.13
<b>Chlorides &amp; Bromides</b>	6.0 ± 0.2	

### CLEANING

Flux residues are water-based, therefore, no neutralizer or saponifiers are required to wash off the residues. Tap or deionized water may be used for cleaning. For optimum cleaning results, water temperature should be 40 – 60 °C

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## HEALTH & SAFETY

TSC 920 contains hazardous ingredients, therefore, the flux should be disposed of in accordance with all local, regional, national and international regulations.

Use with adequate ventilation and proper personal protective equipment. Refer to the accompanying Safety Data Sheet for any specific emergency information. Do not dispose of any hazardous materials in non-approved containers.

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