

MetaFlux™ WS-710

Product Bulletin

Alcohol Based Water Soluble Flux

Metallic Resources' MetaFlux WS-710 is an alcohol-based water soluble neutral soldering flux specially formulated for wave soldering applications where post soldering residues are washed with water. It contains a neutral halide activation system that achieves peak efficiency and activity at 500°F (260°C); it thus promotes excellent solderability. It is available in 1-gal. containers, 5-gal. pails, and 55-gal. drums.

For Demanding Applications

MetaFlux WS-710 flux is specially designed for wave soldering applications, component tinning, and wire tinning where post-solder residues are water washed. It is ideal for soldering difficult printed circuit boards where demanding conditions exist.

Versatile and Economical

MetaFlux WS-710 solder flux can be used over a wide variety of electronics applications, thus creating versatility and economy. The high activity makes it ideal for high production rates for greater cost-effectiveness. The neutral pH ensures that a neutral residue remains on the printed circuit board and components after soldering; the residue is easily cleaned in water.

Application Directions

MetaFlux WS-710 is formulated for fluxing in wave soldering applications. The flux is formulated for use as supplied; however, the specific gravity should be checked at least once a day. The specific gravity may increase with prolonged use. If the specific gravity exceeds 0.850, flux thinner 710-T should be added. Boards should be pre-heated to a topside temperature of 190-240°F (88-115°C) for optimum solder performance. After soldering, the residue should be cleaned off and washed with hot distilled or de-ionized water (140°F or 60°C minimum).

Safety Precautions

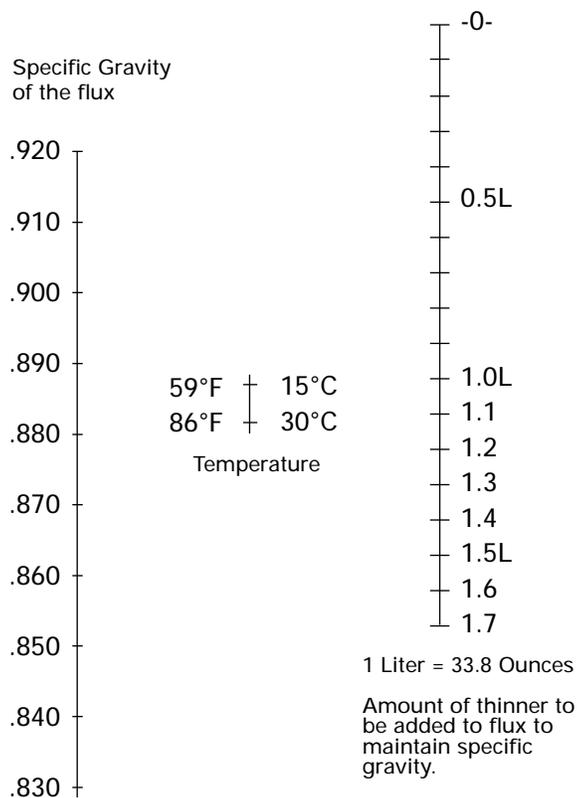
MetaFlux WS-710 is a flammable product. Store containers away from heat, sparks, open flame, and other sources of ignition. Adequate ventilation is recommended to eliminate fumes generated by the flux, the solder, and the circuit boards. The product should be stored in plastic containers away from heat in temperatures between 60°F to 80°F. This product has a two (2) year shelf life from date of manufacture. Refer to the Material Safety Data Sheet (MSDS) for additional information.



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The following Nomograph can be used to measure how much thinner needs to be added to the flux:



Physical Properties

Specific Gravity	0.833 ± 0.005 @ 25°C
Density	6.95 lbs./Gallon @ 25°C
Color	Clear liquid, pale yellow
Solids Content	17%
Halide Content	2.2%
pH	6.8 - 7.8
Flashpoint	53°F Tag Closed Cup Method
Recommended Topside Temperature	190-240°F
Recommended Soldering Range	200-315°C/390-615°F

WS710-0807

Recommendations made by this company and its representatives are based upon test data, experiments, and experience believed to be reliable. No guarantee of accuracy is made, however. All products are sold upon the condition that the buyer will make his own tests and assume the responsibility for the suitability of the product under his application and service conditions. Statements made herein will vary according to the nature of the surfaces to which the product is applied, application technique, and service condition. We in no event assume liability beyond the purchase price of our products involved and make as a condition of sale that we will refund the purchase price or replace materials proven to be defective and reported in a timely fashion, but no later than six (6) months after shipment. No representative of the manufacturer and/or seller has the authority to alter or extend these conditions.