



Metallic Resources



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), thus promoting 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 one (1) year shelf life from date of manufacture. Refer to the Safety Data Sheet (SDS) for additional information.

Physical Properties

Color	Clear liquid, pale yellow
Specific Gravity	0.833 ± 0.005 g/cc @ 25°C
Density	6.95 lb./gal. @ 25°C
Solids Content	17.0%
Halide Content	2.2%
Flash Point	53°F Closed Cup Method
pH	6.8 – 7.8
Recommended Topside Temperature	190-240 °F
Recommended Soldering Range	390-615 °F (200-315°C)



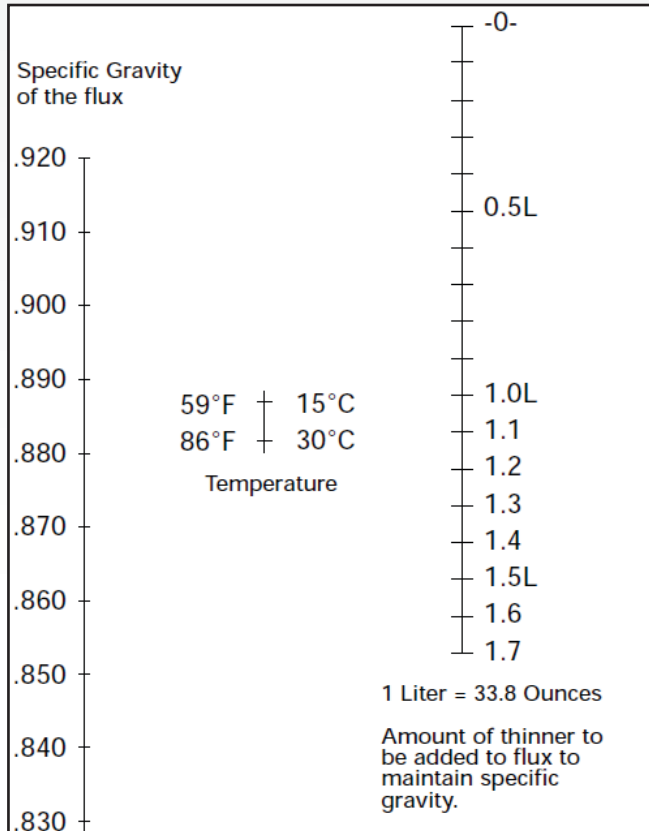
Metallic Resources, Inc.



Ph: 330.425.3155 | Fax: 330.425.2180

2368 E. Enterprise Parkway | Twinsburg, OH 44087

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



Standards Met

IPC J-STD-004
Type ORL1 classification

Metallic Resources, Inc.

Ph: 330.425.3155 | Fax: 330.425.2180
2368 E. Enterprise Parkway | Twinsburg, OH 44087

WS710-0124

DISCLAIMER. This Product Bulletin is provided for general informational purposes only. While the information contained in this Product Bulletin (and any recommendations made by Metallic Resources, Inc. ("MRI") and its authorized representatives relating to the subject matter of this Product Bulletin) is based upon test data, experiments, and experience and is believed to be reliable, no guarantee of accuracy is made. Statements made herein will vary according to the nature of the surfaces to which the product is applied, application technique, and service condition. All products are sold "as is" and upon the condition that the buyer will make their own tests and assume the responsibility for determining the suitability and fitness of the product(s) for their particular purpose. This Product Bulletin is not intended, and shall not be construed, to warrant or guarantee the performance of the described products. MRI shall not be liable for any loss or injury arising out of the use of the information contained herein or the use, misuse or inability to use any products designated herein. In any event, MRI assumes no liability beyond the purchase price of the products involved. As a condition of sale, MRI will (at its option and as buyer's sole and exclusive remedy) 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.