



PENTAGAL Chemie u. Maschinenbau GmbH
Date / Revised: 2005 10 26 Version: 3
Product: **Palux 30 H**

Palux 30 H

1. Description

Flux **Palux 30 H** has been developed in compliance with the requirements of lead free tinning. In particular the higher process temperatures and the modified behavior of wetting and oxidization compared to lead/tin solders were taken into account.

Palux 30 H is

- completely soluble in water and therefore washable without residue
- non-foaming
- free of peroxide
- poor in solids

Palux 30 H is characterized by

- very good wetting of the surface
- high temperature stability

Palux 30 H

- removes the oxide film from the copper surface without pitting the metal itself
- eliminates varnish residues

2. Physical data

- | | | |
|------------------------|-------------|----------------------|
| - colour | pink | |
| - odour | organic | |
| - density | 1.07 – 1.10 | g/cm ³ |
| - viscosity | approx. 350 | mm ² /sec |
| - pH-value | approx. 1 | |
| - flash point | > 300 | °C |
| - ignition temperature | approx. 415 | °C |



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3. Application

Palux 30 H should be transfilled in rooms with local exhaust ventilation and processed in closed facilities. In principal there is no fire hazard during normal application even when exceeding the current process temperatures for some 10°C. In case of inflammation despite the high ignition temperature (>400°C) it is not due to flux **Palux 30 H** but to pyrophoric carbon, being formed with increasing dross developing by cracking of the organic flux matrix. Therefore it necessarily must be taken care that the dross will be removed regularly and the bath surface kept clear.

4. Storage

The containers must be kept tightly closed and dry and stored at a cool place.

5. Containers

Palux 30 H will be delivered in plastic containers of 25 l and 1,000 l.