

PRODUCT DATA SHEET

**TRANSPARENT
HALIDE FREE
LOW SOLID
FLUX**

PAI-8239

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4 PAGES

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GENERAL INFORMATION

PAI - 8239 is a liquid soldering flux that provides good soldering without colored residue to mar surface finish. In cases, where the transformer's plastic preform, that is used to configure the winding of copper wire, is white in Colour, PAI - 8239 is the most suitable flux.

ADVANTAGES OF USING PAI - 8239

PAI - 8239 flux was specially formulated to meet very stringent conditions and improve on production process. As a result, PAI - 8239's derived numerous advantages as compared to normal fluxes, which are listed below.

1. Non-sticky.
2. No residue.
3. No test probe contact problem.
4. Non-halide.
5. Not corrosive soldering pot.
6. Very easy to use.
7. Lead is very clean after soldering.
8. Transformer not colored by flux after soldering.
9. Eliminate the use of temporary solder mask/anti-flux chemical.

APPLICATION INFORMATION

PAI - 8239 liquid flux is applicable without preheat or specialise machinery. Just dip into the flux solder pot. Solder pot temperature is recommend to be at least 250°C for better soldering result. It is very important to clean away solder oxide from the surface of the solder pot just before dip soldering is carried out.

For better economical use of flux, it is recommended that the flux be rebottle in a smaller plastic container. This container ideal volume ought to reflect the daily volume of flux used. With this recommendation, the flux will retain its specific gravity better for a continuing good soldering result.

INSPECTION AND MAINTENANCE

Periodic monitoring of specific gravity with a hydrometer or automatic density censoring system and addition of the appropriate amount of flux Reducer T.8239 is necessary to retain the designed flux properties.

FLUX QUALITY

In time, debris and contaminants will accumulate in the flux. These contaminations will affect the quality of flux, hence soldering. For consistent soldering performance, replace flux periodically. Before replacing the flux reservoir with fresh flux, the reservoir, fluxing attachment and aerator stone should be thoroughly clean with a suitable flux cleaner. During the cleaning process, it would as good a time to clean the conveyor belt fingers and jigs of accumulated flux residue. After cleaning, rinse all relevant parts with a suitable flux reducer. Refill flux reservoir with fresh flux and allow a few minutes for foam to stabilize before resuming soldering operation.

SAFETY & STORAGE

Store away from direct sunlight and source of ignition. Storage temperature should be between 10°C and 30°C. Avoid eye and skin contact by using goggles and / or vinyl gloves during handling. Sufficient localised exhaust should be provided in areas where vapour is generated.

PHYSICAL PROPERTIES

Model Number	PAI – 8239
Type	HALIDE FREE
Class	DIN 8511 F - SW – 32
Physical State	Liquid
Colour	Slightly Yellow Color.
Fillet Surface Appearance	Shinning
Fillet Size	Large
Solid Content	2.8 % wt.
Specific Gravity at 30°C	0.795
Flash Point (open cup)	12°C
Surface Insulation Resistance	$1 \times 10^9 \Omega$
Water Insulation Resistance	$> 45,000 \Omega - \text{cm}$
Flux Reducer	T.8239
Standard packing	10 liters carboy 20 liters carboy

Note: The above Specification is in general Specs. Alteration can be made as per requirement of an individual customer.

MATERIAL SAFETY DATA SHEET

TOTAL NUMBER OF
PAGES - 3

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MATERIAL SAFETY DATA SHEET

IDENTIFICATION

Products Number	PAI - 8239
Products Type	Halide Free Low Solid Flux

PHYSICAL DATA

Boiling Point	< 70°C
Vapour Pressure (mm Hg)	NE
Vapour Density (air = 1)	< 1.5
Solubility	Alcohol, water and oil
Appearance	Slightly Yellow Liquid
Odour	Pleasant
Melting point	NE
Evaporation Rate (butyl acetate = 1)	< 2
Specific Gravity	0.795

REACTIVITY DATA

Incompatibility	NE
Stability	Stable
Decomposition or Byproducts	NE
Polymerisation	NE

HAZARDOUS INGREDIENTS

Material

None	
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FIRE AND EXPLOSIVE DATA

Flash Points	12 °C
Flammable Limits	NE
Extinguishing Media	Dry Chemical
Special Fire Fighting Procedure	Use self contained breathing apparatus
Unusual Fire and Explosion Hazards	None

HEALTH HAZARD DATA

Routes of Entry	Inhalation, skin, ingestion
Health Hazards	Degreasing and irritation of skin, possibly anemic and poisonous if taken orally
Carcinogenicity	NE

NE = Not Established

SIGNS AND SYMPTOMS OF EXPOSURE

Skin	Inflammation
Eyes	Redness, burning, tearing, blurred vision
Ingestion	Nausea, vomiting
Inhalation	Headache, dizziness, difficult breathing

EMERGENCY FIRST AID PROCEDURES

Skin	Flush with water for 15 minutes. Seek medical attention, if irritation persists.
Eyes	Flush with water immediately. Seek medical attention, if irritation persists.
Ingestion	Drink large amount of water. Seek medical attention, if irritation persists. Never give liquids to an unconscious person.
Inhalation	Remove to fresh air. Support respiration if required. Seek medical attention.

PRECAUTIONS FOR SAFE HANDLING AND USE

Spill, Leak or Release	Flush into a chemical sewer or soak up with suitable absorbent.
Waste Disposal	Dispose of in accordance with local state and federal regulations.
Storage	In low temperature and low humidity area.
Handling	Wear Protection glasses and gloves

PROTECTION INFORMATION

Respiration Protection (type)	Organic vapor mask for fumes.
Ventilation	Local exhaust preferred.
Protective Gloves	Plastic or Rubber
Protective Cloth	As required to avoid contact.
Eye Protection	Goggle or Face Shield.
Hygienic Practices	Wash after handling or use.

NE = Not Established.

* We continuously upgrade our product. Conditions are subject to change without prior notification.