

ENVIRO/Flow HOF-5

A Non-Foaming, Alcohol Based Hot Oil Solder Fusing Flux

Product Description

ENVIRO/Flow HOF-5 (HOF-5) is a soldering flux designed to clean water insoluble inorganic residue, organic residue and metal oxides from tin-lead deposits prior to hot oil fusing; thereby assuring optimum appearance and leveling of the fused deposit. Additionally, HOF-5 will clean, activate, and adhere to copper sidewalls improving solder wetting of the sidewall.

HOF-5 is a water free formulation, thereby minimizing spattering during the fusing process.

Performance Features

- ENVIRO/Flow HOF-5 is effective at cleaning oxides from electroplated tin-lead and copper, thereby assuring complete sidewall wetting.
- ENVIRO/Flow HOF-5 is effective at removing non-water soluble contaminants from the surface of tin-lead and copper improving fusing performance.
- ENVIRO/Flow HOF-5 is completely water-soluble assuring trouble free rinsing when employed with the appropriate fusing fluid.
- ENVIRO/Flow HOF-5 will not evaporate from the board, assuring excellent fusing and leveling with manual processes.
- ENVIRO/Flow HOF-5 exhibits a ZERO TDS (total dissolved solids) value and will not contribute to ionic contamination.

Physical Specifications

Physical State	Liquid
Appearance	Transparent - Light Yellow Solution
Odor	Alcohol
Freeze/Thaw Stability	Protect From Freezing
Specific Gravity	0.9
Flash Point	56°F
pH (Neat)	< 2.4

Equipment Requirements

ENVIRO/Flow HOF-5 is compatible with all types of plastic, elastomers, and stainless steel racks employed by standard fluxing equipment. HOF-5 is not compatible with mild steel or aluminum.

Technical Data Sheet

Product Make-Up

ENVIRO/Flow HOF-5 should be used as received. Do not dilute with water or alcohol.

Operating Parameters

ENVIRO/Flow HOF-5 can be applied with a standard flux applicator or by immersion. If applying by immersion, a 10 second dip is typically sufficient to assure complete cleaning. Allow excess flux to drain from panel and fuse. It is not necessary to heat ENVIRO/Flow prior to use. A recommended fusing process would be:

Procedure

1. Apply HOF-5 at room temperature by immersion or roller. Allow excess flux to drain for 5 - 10 seconds.
2. Immerse in a pre-heated fusing fluid at 240 - 260°F such as Seacole's ENVIRO/Flow HO Series fluid for 10 - 20 seconds.
3. Immerse in a full temp fusing fluid at 410 - 440°F for 8 - 10 seconds or until the tin-lead deposit is mirror bright indicating the solder alloy has formed.
4. Immerse in a cool down fusing fluid or return to the pre-heated fusing fluid for 10 - 20 seconds or until the solder freezes.
5. Hot water rinse.

Replenishment

The solution level should be maintained by adding fresh HOF-5 solution. The addition of water and/or isopropyl alcohol is not recommended.

Safety and Handling

Read and understand this products MSDS prior to use.

Waste Treatment

Individual users should verify the nature of spent solutions to assure compliance with local, state, and federal regulations. Contact Seacole for specific details and/or further waste treatment recommendations.

Ordering Information

ENVIRO/Flow HOF-5 is available in 5-gallon pails and 55-gallon drums.

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