



**Laboratory for Chemical Production  
in Electronic Industry**

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| <b>Technical Data Sheet</b>   | <b>MTR261</b>              |
| <b>Product name:</b>  | <b>MARMOT® Flux MTR261</b> |
| <b>Description and key properties:</b>  |                            |
| <ul style="list-style-type: none"><li>• <b>No clean low residue flux for wave soldering with solder Sn60-63%Pb. Spray or foam application</b></li><li>• <b>Activated without content of halides</b></li><li>• <b>For soldering high-end, military electronics and avionics even mildly oxidized color metals</b></li><li>• <b>Flux neutralize itself after soldering depending on process of production</b></li><li>• <b>Dilutable flux according to used process of soldering and solderability of soldered parts</b></li><li>• <b>Flux for PCB without nonsolderable mask and with epoxy based nonsolderable mask</b></li><li>• <b>The flux is not suitable for soldering by naked flame – it is highly flammable</b></li></ul> |                            |
| <b>Operating manual:</b><br>Flux is applied by foam, spray or wetting.<br>Flux can be accordingly diluted to minimize residues after soldering  |                            |

| Technical specification:  | Corresponds to norm:   | Classification:    |
|---|--|--------------------|
|   | EN 29454-1   | 2.2.3.A            |
| <b>Fully complies EU directive - RoHS</b>   | DIN  | F-SW-34            |
|   | J-STD  | ORLO               |
| Form  | Liquid   |                    |
| Aroma   | Alcoholic  |                    |
| Density   | 0,786  | kg/dm <sup>3</sup> |
| Melting point   | -  | C                  |
| Boiling point   | 82 - 84  | C                  |
| Color   | yellow - brownish  |                    |
| Spread factor – USA methodology MIL-F-14256D  | 78-80  | %                  |
| Spread areal – EU methodology   | 225  | mm <sup>2</sup>    |
| Absolute corrosive effect on Cu mirror<br>- EN 29455-5 (ISO 9455-5:1992)  | Without depletion Cu 4000 Angstrom<br>Without corrosion - Complies excellent |                    |
| - USA method MIL-F-14256D:  | Without corrosion - Complies excellent                                       |                    |
| corrosive effect tropical humidity 21 days  | Without corrosion - Complies excellent                                       |                    |
| <b>Insulation resistance :</b>  |  |                    |
| 1kV distance 1mm  |  | M ohm              |
| PCB distance 1 x 1mm  | 3250   | G ohm              |
| electrical breakdown distance 1mm   |  | KV                 |
| Soluble in:   | Isopropyl alcohol  | without limits     |
|   |  | g/lit.             |
| Recommended thinner :   | Isopropyl alcohol  |                    |
| Recommended cleaner:  | Hot water – hot water with wetting agent                                     |                    |
| Used methodology conform the norm MARMOT, M01-3 for led free solders M01.1  |  |                    |
| Other proprieties: Solid substance read safety data sheet if released   |  |                    |
| For aviation and military devices is recommend cleaning, for other usage we recommend to test the influence of flux residues on the device, according to the aspect of device and process of production.<br>In all other application where the small residuum of the flux after soldering does not affect the product is not necessary to apply cleaning. |  |                    |
| Issued:   | 22.7.2008  |                    |
| Revised   | 25.01.2013   |                    |

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| 11.0. | <b>Safety and health protection</b>   |
| 11.1. | Long lasting and repeated contact with skin can cause irritation and sensibility, therefore is necessary to avoid direct contact. In case when it is not possible exclude possibility of direct skin contact, the workers must wear suitable personal protective equipment. Work area must be ventilated. Do not drink or eat during work. Do not use naked flame. After work, hands should be washed with soap and warm water and cared with protective cream.   |
| 11.2. | <b>First Aid</b><br><b>Inhalation</b> – in case of excessive inhalation of flux fumes emitted during soldering, remove affected person to fresh air.<br><b>Ingestion</b> – in case of accidental Ingestion, wash out mouth with water and give enough pure water to drink.<br><b>Skin contact</b> – in case of skin contact, wash the place with soap and warm water.<br><b>Eye contact</b> – in case of eye contact, flush the eyes immediately with plenty of water.<br>In case of large health damage or eyes contact, seek medical attention. |
| 11.3. | <b>Above mentioned precautions are recommended for health protection of the workers, obligatory measures are described in Safety Data Sheet (SDS) - if released, and do not substitute internal safety regulations of final customer.</b>   |