



**Laboratory for Chemical Production
in Electronic Industry**

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Technical Data Sheet	MTR264
Product name:	MARMOT® Flux MTR264
Description and key properties:	
<ul style="list-style-type: none">• No clean low residue flux for wave soldering with lead-free (RoHS) solders MARMOT®• Spray or foam application• Highly activated by unique MARMOT® patented combination of hydro-halide and inhibitor of corrosion• For soldering high-end electronics even highly oxidized color metals• Highly activated flux. Also usable for nickel plated components and steel• Flux neutralize itself after soldering depending on process of production• Dilutable flux according to used process of soldering and solderability of soldered parts• Flux for PCB without nonsolderable mask and with epoxy based nonsolderable mask• The flux is not suitable for soldering by naked flame – it is highly flammable	
Operating manual: Flux is applied by foam, spray or wetting. Flux can be accordingly diluted to minimize residues after soldering	

Technical specification:	Corresponds to norm:	Classification:
	EN 29454-1	2.2.2.A
Fully complies EU directive - RoHS	DIN	F-SW-25
	J-STD	ORM1
Form	Liquid	
Aroma	Alcoholic	
Density	0,821	kg/dm ³
Melting point	-	C
Boiling point	82 - 84	C
Color	yellow - brownish	
Spread factor – USA methodology MIL-F-14256D	78-82	%
Spread areal – EU methodology	228	mm ²
Absolute corrosive effect on Cu mirror - EN 29455-5 (ISO 9455-5:1992)	Partial depletion Cu 4000 Angstrom Without corrosion - Complies excellent	
- USA method MIL-F-14256D:	Mild corrosion	
corrosive effect tropical humidity 21 days	Without corrosion - Complies excellent	
Insulation resistance :		
1kV distance 1mm		M ohm
PCB distance 1 x 1mm	6500	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. 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	

11.0.	Safety and health protection
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.	First Aid Inhalation – in case of excessive inhalation of flux fumes emitted during soldering, remove affected person to fresh air. Ingestion – in case of accidental Ingestion, wash out mouth with water and give enough pure water to drink. Skin contact – in case of skin contact, wash the place with soap and warm water. Eye contact – in case of eye contact, flush the eyes immediately with plenty of water. In case of large health damage or eyes contact, seek medical attention.
11.3.	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.