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TECHNICAL BULLETIN

alpha ASSEMBLY SOLUTIONS™

ALPHA® 857

Water-Soluble Flux

DESCRIPTION

ALPHA 857 is a liquid flux formulated for producing defect-free assemblies in wave soldering processes employing water cleaning.

APPLICATION

ALPHA 857 is a low-smoking, efficient foam flux. Using moderate air flow rates, its fine-bubble foam head is fast-breaking, and recovers rapidly for effective coverage at high production speeds. **ALPHA 857** can also be applied by spraying process. This highly active flux will produce bright shiny solder connections.

THINNING: The consistency of **ALPHA 857** should be maintained by the addition of thinner to compensate for evaporation losses. It is recommended that the specific gravity @ 25°C / 77°F be maintained between 0.860 and 0.875 by the addition of thinner. Only **ALPHA 425** Thinner should be used for this purpose to ensure consistency of flux foaming and soldering characteristics.

RESIDUE REMOVAL: The residues wash off easily to very low levels of ionic contamination. Water washing can be done without the use of rinse aids and with little or no foaming. The flux is formulated so that the cleaning process water effluent is completely biodegradable. Local regulations may require pretreatment to raise the pH and remove dissolved lead from the water effluent.

TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Clear, Pale Yellow Liquid	Flash Point (T.C.C.)	17°C (62°F)
Percent Nonvolatiles	18	Recommended Thinner	**ALPHA 425**
Specific Gravity @ 25°C (77°F)	0.865 ± 0.005	IPC J-STD-004 Designation	ORH1
pH, 5% solution	2.8	Packaging Size	1, 5 & 55 gallon
Shelf Life (from Date of Mfg.)	540 days		

SAFETY

Please refer to the Safety Data Sheet as the primary source of health and safety information. The most recent version of the SDS is available from AlphaAssembly.com.

Observe standard precautions for handling and use, such as well-ventilated areas and avoidance of prolonged or repeated contact with the skin. **ALPHA 857** is flammable; keep away from heat, spark and open flames.

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CONTACT INFORMATION

To confirm this is the most recent issue, please contact Alpha Assembly Solutions

AlphaAssembly.com

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency directory assistance Chemtrec 1 - 800 - 424 - 9300.

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