

# ALPHA<sup>®</sup> 6219

Low Solids, No-Clean Flux

## DESCRIPTION

**ALPHA 6219** is a very efficient halide-free and rosin / resin-free, low solids no-clean flux which can be applied by wave, spray and foam techniques. After soldering a very small amount of barely visible residue is left which is tack-free and non-corrosive.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

## APPLICATION GUIDELINES

Preheat temperatures of 82 to 104 °C (180 to 220 °F), as measured on the board topside, are recommended. When applying the flux by foam technique, it is recommended that the flux be filled to a level approximately 4cm (1 ½ inches) above the foam stone element to obtain the best foam head.

## TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Clear, Colorless to Pale Yellow Liquid	Flash Point (T.C.C.)	16 °C (61 °F)
Solids Content, %wt/wt	2.7	Recommended Thinner	<b>ALPHA 425</b>
Specific Gravity @ 25 °C (77 °F)	0.793 ± 0.003	Shelf Life (from Date of Mfg.)	540 Days
Acid Number (mg KOH/g)	20.00 ± 2.00	IPC J-STD-004 Designation	ORL0
Packaging Size	1, 5 & 55 Gallons		

**CORROSION & ELECTRICAL TESTING**

**Per IPC-SF-818**

Requirement	Results
Silver Chromate Paper Test	PASS
Copper Mirror Test	PASS
Copper Corrosion Test	PASS
Surface Insulation Resistance Test (50 °C / 90% RH, 7 days, 12.5mil spacing comb pattern)	PASS

**RECYCLING SERVICES**

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



**SAFETY & WARNING**

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at [MacDermidAlpha.com/assembly-solutions/knowledge-base..](http://MacDermidAlpha.com/assembly-solutions/knowledge-base..)**

**CONTACT INFORMATION**

To confirm this document is the most recent version, please contact  
**Assembly@MacDermidAlpha.com**  
[www.macdermidalpha.com](http://www.macdermidalpha.com)

<p><b>North America</b>          109 Corporate Blvd.          South Plainfield, NJ 07080, USA          1.800.367.5460</p>	<p><b>Europe</b>          Unit 2, Genesis Business Park          Albert Drive          Woking, Surrey, GU21 5RW, UK          44.01483.758400</p>	<p><b>Asia</b>          8/F., Paul Y. Centre          51 Hung To Road          Kwun Tong, Kowloon, Hong Kong          852.3190.3100</p>
---	--	---

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 safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

DISCLAIMER: All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. No statement or recommendation shall constitute a representation unless set forth in an agreement signed by officers of seller and manufacturer. NO WARRANTY OF MERCHANTABILITY, WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY IS MADE. The following warranty is made in lieu of such warranties and all other warranties, express, implied, or statutory. Products are warranted to be free from defects in material and workmanship at the time sold. The sole obligation of seller and manufacturer under this warranty shall be to replace any noncompliant product at the time sold. Under no circumstances shall manufacturer or seller be liable for any loss, damage or expense, direct, indirect, incidental or consequential, arising out of the inability to use the product. Notwithstanding the foregoing, if products are supplied in response to a customer request that specifies operating parameters beyond those stated above, or if products are used under conditions exceeding said parameters, the customer by acceptance or use thereof assumes all risk of product failure and of all direct, indirect, incidental and consequential damages that may result from use of the products under such conditions, and agrees to exonerate, indemnify, defend and hold harmless MacDermid, Incorporated and its affiliates therefrom. No suggestion for product use nor anything contained herein shall be construed as a recommendation to use any product in a manner that infringes any patent or other intellectual property rights, and seller and manufacturer assume no responsibility or liability for any such infringement.

© 2019 MacDermid, Inc. and its group of companies. All rights reserved. "R" and "TM" are registered trademarks or trademarks of MacDermid, Inc. and its group of companies in the United States and/or other countries.