

# ALPHA<sup>®</sup> 6279

## No-Clean Rosin Flux

### DESCRIPTION

**ALPHA 6279** is a foam flux specifically designed for automatic soldering of printed circuit board assemblies. It has been especially formulated with a rosin dissolved in alcohol with a small amount of organic activator.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### FEATURES & BENEFITS

- Mildly activated rosin flux
- Good wetting and capillary action
- Flux residues are fast drying and therefore non-tacky.
- Flux residues are evenly distributed on PCB surface after exit from solder wave.
- Provides super foam characteristics; foam bubbles are even, fine and fast subsiding
- Free from halides; flux residues can be safely left on PCBs without cleaning
- Meets JIS Corrosion Resistance and Surface Insulation Resistance tests

### APPLICATION GUIDELINES

Preheating the circuit assembly will partially dry the flux, enhance oxide removal and promote optimum wicking, as well as superior solder joint formation. Degree of preheat is dependent on many variables, such as conveyor speed, type of components and substrates. Entering the solder wave with a top-side temperature of 88 to 115 °C (190 to 240 °F) and a bottom-side temperature of 121 to 163 °C (250 to 325 °F) is typical.

If flux residue removal is desired, this can be effectively carried out with chlorinated solvents such as ALPHA 564E Cleaner, as well as non-CFC cleaners such as ALPHA 2110.

**TECHNICAL DATA**

Item	Typical Values	Item	Typical Values
Appearance	Clear amber liquid	pH	Acidic, 3 to 5
Solids Content, wt/wt	30%	Halide Content	None
Specific Gravity @ 25 °C (77 °F)	0.865 +/- 0.005	Flash Point	17 °C
Acid Number, mg KOH/gm	62.0 ± 3.0	Ignition Point	450 °C
Viscosity@ 25 °C (Brookfield @50rpm)	18 cps	Shelf Life (from Date of Mfg.)	540 days

**CORROSION & ELECTRICAL TESTING**

Test	Test Method / Requirement	Results
Copper Mirror Test	JIS-Z-3197	Pass
Copper Plate Corrosion Test	JIS-Z-3197, No green or brown corrosion observed after 10 days at 40 °C, 95%RH	Pass
Surface Insulation Resistance	Initial	>10 <sup>12</sup> Ω
	After 96 hours	>10 <sup>12</sup> Ω

**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  
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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 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

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