

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.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

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		

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.**

CONTACT INFORMATION

To confirm this document is the most recent version, please contact
Assembly@MacDermidAlpha.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 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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