

## ALPHA<sup>®</sup> 260-HF

Halide-Free, Water Soluble Flux

### DESCRIPTION

**ALPHA 260-HF** is a highly active, halide-free, water soluble organic flux especially designed to give excellent solder wetting with Kovar, Alloy 42, Nickel and Copper surfaces. The residues from **ALPHA 260-HF** can be cleaned to low levels of ionic contamination.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### APPLICATION GUIDELINES

ALPHA 260-HF is recommended for automatic wave soldering applications where there is a concern about the presence of halide activator in the flux. This concern may arise from the possibility of either flux penetrating micro-cracks in component seals, or flux entrapment underneath or in open or porous cavities of components.

ALPHA 260-HF can be used both as a flux for wave soldering printed circuit assemblies, and for tinning lead frames and component leads. ALPHA 260-HF can be applied by foam, wave, dip or spray techniques.

**RESIDUE REMOVAL:** Residues from ALPHA 260-HF flux should be removed after soldering as soon as possible. Thorough cleaning of these residues can be accomplished with warm to hot water. For critical cleanliness requirements, final rinsing with DI water may be required.

**Thinning:** The non-volatiles content of ALPHA 260-HF flux should be maintained by the addition of thinner to compensate for evaporation losses. ALPHA 411 Thinner is recommended for ALPHA 260-HF.

**TECHNICAL DATA**

Item	Typical Values	Item	Typical Values
Appearance	Clear, Pale Yellow Liquid	pH, 5% in Water	3.0
Non-volatiles, %wt/wt	25.5	Flash Point (T.C.C.)	16 °C (61 °F)
Specific Gravity @ 25 °C (77 °F)	0.919 ± 0.005	Recommended Thinner	ALPHA 411
Total HALIDES	10ppm max.	Shelf Life (from Date of Mfg.)	540 days
Acid Number (mg KOH/g)	112 ± 10	Packaging Size	1, 5 and 55 gallons

**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)**

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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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