



Product Information

ISO-FLUX® “KF-23”

Halide-free cable flux without resins
DIN EN ISO 9454-1, 2231, DIN EN 61190-1-3, ORLO
Item-No.: 251500..

All information about our products is the result of our long standing experience which we would like to pass on to our customers as application support. However, as we do not have any influence on the application of the works carried out with our products, please see the warranty claims in our conditions of sale because our liability is limited.

This product information does not constitute warranted properties.

Cable flux ISO-Flux® “KF-23”

Description

The cable flux **ISO-Flux® “KF-23”** is a flux on a basis of organic, halide-free activators. In comparison to conventional fluxes it distinguishes itself by the fact that absolutely partial tinning can be achieved. This flux was particularly developed for tinning and soldering of cable shoes, sleeves and plug connections. Even with finest copper braids with high capillary effect the solder will not rise higher, than the wetting of the braid affected by cable flux **ISO-Flux® “KF-23”**. By proper application there is no risk, that the solder creeps under the isolation and limits the flexibility of the wire. The application usually takes place by dipping. The flux also can be applied by spray- or foam fluxer.

ISO-Flux® “KF-32” contains no substances, in concentrations or applications, whose bringing into circulation in products is prohibited according to the valid requirements of the directive 2011/65/EU (“ROHS”).

Properties

Density (20° C):	0,810 g/cm ³
Flaming point:	> 13 ° C
Solid content:	5,0 %
Halide content:	halide-free
Colour:	water clear
Thinner:	VF 2
Processing temperature:	180° - 450° C

By the evaporation of the solvent during the use it can occur that a part of the activators crystallizes. By adding **thinner “VF-2”** these crystals can be brought back into solution again.

With open flux systems the acid value has to be determined daily by titration. This can be done without great effort by the machine operator with our **FELDER Titration Set**.

Residues

After the tinning no disturbing flux residues are visible. The tinned parts are metallic bright and also keep their excellent wetting characteristics after long storage for following soldering works (e. g. on electronic components).

The flux residues comply with the flux specification 2231 according EN ISO 9454-1. The flux residues are not corrosive and may remain on the soldering joint.

A possibly occurring green colouring with copper cables is a reaction product of the copper oxide. This colouring is unavoidable during surface cleaning and may not be confused with corrosion.

Delivery Forms

1 l bottle, 25 l canister

Storage Advice

Store in tightly closed containers protected from humidity, insolation and warmth effect.

Minimum Durability

6 months from production date.