

Description

The 836-P *No Clean Flux Pen* contains a homogenous mixture of halogen-free, low solids, organic flux. Exhibits excellent wetting and fluxing activities with essentially no residue left on the assembly after soldering. 836-P *No Clean Flux Pen* may be used for both leaded and lead-free applications. A chiseled tip provides exact delivery of flux to surface.

Application

The 836-P pen is designed to dispense flux in a precise application. Excellent for prototyping and rework/repair on printed circuit boards. Works well on chip carriers, heat sinks, surface mounted device pads, switches and sockets.

Features and Benefits

- **Halogen-free**
- **Excellent wetting**
- **Bright, shiny solder joints**
- **Low Residue**
- **Rosin/Resin free**
- **Compatible with Lead-Free & Leaded Solder Systems**

Flux Paste Properties

<i>Flux Properties</i>	<i>Method</i>	<i>Value</i>
Flux type		Organic
Flux Activity		Low
Halides %(wt)		0%
Flux Classification	J-STD-004	ORL0
Acid number		28-30
Copper Mirror	IPC-TM-650 2.3.32	Pass (no complete breakthrough)
Corrosion Test	IPC-TM-650 2.6.15	Pass (non-corrosive)
Spot Test		Pass (no color change)
Silver Chromate	IPC-TM-650 2.3.33	Pass (no discoloration)
Surface insulation resistance (SIR)		
SIR, JSTD-004	IPC-TM-650 2.6.3.3	1 × 10 ¹¹ Ω
Bellcore compliant		Yes
Cleaning requirements	—	None
<i>Physical Properties</i>	<i>Method</i>	<i>Value</i>
Color		Colorless
Solids%		3.0%–3.6%
Density		0.81
Flash Point	Closed cup	12 °C [53 °F]

Storage and Shelf Life

Store at around room temperature and protect from direct heat or sunlight.

<i>Properties</i>	<i>Value</i>
Shelf Life after DOM	2 years
Storage Temperature	18 to 27 °C [65 to 80 °F]

DOM = date of manufacture

Cleaning

If removal is desired, a solvent system like the *MG 4140* or *MG 413B* can be used. For best results, warm the cleaning solution to about 40 °C [104 °F].

Health and Safety

Please see the 836 **Safety Data Sheet** (SDS) for more details on transportation, storage, handling and other security guidelines.

Environmental Impact: The volatile organic content is 50% by EPA and WHMIS standards.



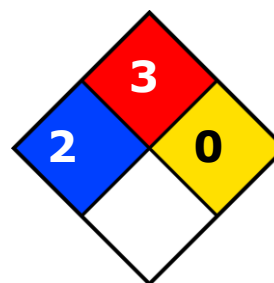
This product meets the European Directive 2011/65/EU Annex II (ROHS); recasting 2002/95/EC.

Health and Safety: Avoid breathing fumes. Wash hands thoroughly after use. Do not ingest.

HMIS® RATING

HEALTH:	2
FLAMMABILITY:	3
PHYSICAL HAZARD:	0
PERSONAL PROTECTION:	

NFPA® 704 CODES



Approximate HMIS and NFPA Risk Ratings Legend:

0 (Low or none); 1 (Slight); 2 (Moderate); 3 (Serious); 4 (Severe)

Application Instructions

Apply flux by direct dispensing via the pen.

Packaging and Supporting Products

<i>Cat. No.</i>	<i>Form</i>	<i>Net Volume</i>	<i>Net Weight</i>
836-P	Pen	10 mL 0.34 fl oz	8 g 0.28 oz

Suitable Flux Cleaners

- *Heavy Duty Flux Remover*: Cat. No. 413B-1L, 413B-4L, 413B-20L, 413B-425G
- *Flux Remover for PC Boards*: Cat. No. 4140-P, 4140-400G, 4140-1L, 4140-4L, 4140-20L

Technical Support

Contact us regarding any questions, improvement suggestions, or problems with this product. Application notes, instructions, and FAQs are located at www.mgchemicals.com.

Email: support@mgchemicals.com

Phone: 1-800-340-0772 (Canada, Mexico & USA)
1-905-331-1396 (International)

Fax: 1-905-331-2862 or 1-800-340-0773

Mailing address: **Manufacturing & Support**
1210 Corporate Drive
Burlington, Ontario, Canada
L7L 5R6

Head Office
9347-193rd Street
Surrey, British Columbia, Canada
V4N 4E7

Warranty

M.G. Chemicals Ltd. warrants this product for 12 months from the date of purchase by the end user. *M.G. Chemicals Ltd.* makes no claims as to shelf life of this product for the warranty. The liability of *M.G. Chemicals Ltd.* whether based on its warranty, contracts, or otherwise shall in no case include incidental or consequential damage.

Disclaimer

This information is believed to be accurate. It is intended for professional end users having the skills to evaluate and use the data properly. *M.G. Chemicals Ltd.* does not guarantee the accuracy of the data and assumes no liability in connection with damages incurred while using it.