

# CHEMTRONICS® Technical Data Sheet

**TDS # CLF8**

## Chemask® Lead-Free Solder Masking Agent

### PRODUCT DESCRIPTION

Chemask® Lead-Free Solder Masking Agent is a temporary, fast curing, peelable solder masking agent formulated for use in high temperature lead-free applications. It is a temperature resistant coating that protects component-free areas of the PCB during wave soldering. Chemask® Lead-Free can be introduced into the preheat oven within 4 minutes of application without adverse effects. Use to protect pins, posts, contacts and edge connections during conformal coating processes.

- Stable to 550°F (288°C)
- Can be used in lead-free or Tin/Lead applications
- Compatible with rosin, no clean, and water soluble fluxes
- Unaffected by cleaning solvents
- Leaves no residue – non-contaminating
- Ready for wave solder in 4 minutes
- Dries tack free in 15 minutes
- RoHS compliant

### TYPICAL APPLICATIONS

Chemask® Lead-Free Solder Masking Agent protects:

- Component Free Areas for Soldering
- Components and Sockets
- Pin Connectors During Soldering
- Temperature Sensitive Components During Wave Soldering

### TYPICAL PRODUCT DATA AND PHYSICAL PROPERTIES

<b>Base Material</b>	Natural latex rubber
<b>Color</b>	Pink
<b>Solvent Stability (cured mask)</b>	Stable in all hydrocarbon, hydrofluorocarbon, chlorinated, and halogenated solvents
<b>Flux Compatibility</b>	All types
<b>Temperature Stability</b>	550°F
<b>Tack-Free Drying Time (10 mils @ 77°F)</b>	15 min.
<b>Cure Time (10 mils @ 77°F)</b>	30 min.
<b>Viscosity (@ 77°F) (± 10,000 cps)</b>	190,000 cps
<b>Viscosity Adjusted With</b>	Deionized water
<b>Solids Content</b>	~ 80%
<b>Flash Point</b>	Nonflammable
<b>Weight/Gallon</b>	7.2 lbs.
<b>Shelflife</b>	2 years

### COMPATIBILITY

Chemask® Lead-Free Solder Masking Agent is generally compatible with most materials used in printed circuit board fabrication. As with any solder masking agent, compatibility with substrate must be determined on a non-critical area prior to use. Test compatibility on bare copper.

### APPLICATION METHOD

Squeeze Bottle/Syringe	Yes
Spatula	Yes
Screening	No
Automatic Dispensing	Yes
Removal/Clean-up	By Hand

### USAGE INSTRUCTIONS

For industrial use only.

Read MSDS carefully prior to use.

Chemask<sup>®</sup> Lead-Free Solder Masking Agent is engineered for all electronic manufacturing applications. When applying by hand using squeeze bottle, syringe or spatula, insure that all areas of the pretinned hole are evenly covered on the side to be soldered. Automatic dispensing equipment may also be used as appropriate.

**REMOVAL:** After allowing the mask to become fully cured, peelable solder mask can be removed by hand or by the use of tweezers. Depending on ambient conditions, peelable mask may remain on assemblies for extended periods of time prior to component insertion.

### AVAILABILITY

CLF8 8 oz. Squeeze Bottle  
CLF1 1 Gal. / 3.7 L liquid

### TECHNICAL & APPLICATION ASSISTANCE

ITW Chemtronics<sup>®</sup> provides a technical hotline to answer your technical and application related questions. The toll free number is: **1-800-TECH-401.**

### NOTE:

This information is believed to be accurate. It is intended for professional end users having the skills to evaluate and use the data properly. ITW CHEMTRONICS<sup>®</sup> does not guarantee the accuracy of the data and assumes no liability in connection with damages incurred while using it.

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