

# KESTER® SF855-LR SOLDERING FLUX

**Low Solid, Low Residue, No-Clean Liquid Flux for Photovoltaic Assembly**

## DESCRIPTION

Kester SF855-LR Soldering Flux is a low solid, low residue, no-clean non-rosin organic flux designed specifically for use in tabber and stringer equipment of Photovoltaic Assembly (PV) through soldering tabs to cell contacts. SF855-LR can be applied directly to interconnecting ribbon by hand soldering and auto equipment with tabbing and stringing soldering system, and by dipping or spraying methods. The extremely low solids content (around 1.6%) and nature of the activator system results in practically no residue left on the cell after soldering. Cells are dry and cosmetically clean as they exit the tabber and stringer machine. SF855-LR has a wide operating window and temperature range. It can be used in SnPb, SnAgPb and Pb-free applications.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

## FEATURES & BENEFITS

- Minimal residue after reflow
- Low solid
- Eliminates cleaning process
- Fast throughput due to quick wetting and drying
- Excellent slip reduction
- Produces high reliable ribbon that interconnects solar cells
- Less residue that support higher power transfer efficiencies
- Compatible with EVA
- Can be applied by using spraying method or via dipping tank

## ROHS COMPLIANCE

This product meets the requirements of the Restriction of Hazardous Substances (RoHS) Directive.

**TECHNICAL DATA**

Category	Results	Procedure/Remarks
<b>Physical Properties</b>		
Appearance	Clear, colorless liquid	
Specific Gravity	0.800	Anton Paar DMA 35 @ 25 °C
Acid Number (Typical)	10.0 mg KOH/g of flux	Tested by potentiometric titration
Flux Percent Solids (wt/wt)	1.6%	
Dry Residue	Less than 0.1%	

**FLUX APPLICATION**

SF855-LR can be applied by a spraying or dipping application method.

SF855-LR is engineered for the PV industry. The chemical flux is designed for both automated tabber and stringer application, including hand soldering. Standard pre-heating and heat temperature can be used without special cooling or pre-baking. Consult your Equipment Supplier or MacDermid Alpha Technical Support for further information.

**PROCESSING GUIDELINES****Cleaning**

SF855-LR flux residues are non-conductive, non-corrosive and do not require removal in most applications. If residue removal is required, consult MacDermid Alpha Technical Support for cleaning recommendation.

**Storage, Handling and Shelf Life**

SF855-LR is flammable. Store away from sources of ignition. Shelf life is 1 year from the date of manufacture when handled properly and held at 10 to 43 °C (50 to 110 °F).

## 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.



## 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.**

## CONTACT INFORMATION

[www.macdermidalpha.com](http://www.macdermidalpha.com)

<b>North America</b> 140 Centennial Avenue Piscataway, NJ 08854 1.800.367.5460	<b>Europe</b> Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400	<b>Asia</b> 8/F., Two Sky Parc 51 Hung To Road Kwun Tong, Kowloon, Hong Kong, SAR China 852.2500.5365
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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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