

# SOLAR-FLUX

## EO-S-011

**Cat.-no. 6211**

Flux especially for the solar industry -halide free-  
ISO-9454: 2231 (2.2.3.A) / WEEE /RoHS-compliant  
DIN-EN 61190-1-1 (J-STD-004), IEC: ORLO „NO CLEAN“



This flux has been specially developed for solar technology, in particular for soldering solar modules, tabber and stringer material, as well as connecting cells. **EO-S-011** is a NO-CLEAN flux, halide-free formulated and optimized for use in wave, selective and manual soldering processes.

**EO-S-011** leaves no sticky residue. The activators are specially designed for the higher temperatures that are required in the manufacture of solar modules, without affecting their effectiveness. The application can be carried out by any usual application method (except foams).

The solids content is 2%.

**EO-S-011** is totally free from corrosion action.

### Technical specifications

Appearance:	colourless-light yellowish, transparent, liquid
Solid contents:	1,9 – 2,2 %
Density (20° C):	0.86 – 0,88 g/ml
Acid-no.:	16 - 19 mg KOH/g
Activators:	carboxylic and dicarboxylic acids – complex with special resin/rosin additive
Halogen-content:	0 % (halide free)
Solvents:	short chain alcohols with DI water (H <sub>2</sub> O)
Flash-point:	20 °C



### Safety instructions:

Please refer to the current MSDS

### Instructions for use:

This flux is very versatile and OPS-compatible. There are good results for manual, wave and selective soldering, as well as for cable assembly / wire tinning. The general rule of applying fluxes applied in principle as low as possible also applies to this product.

### Recommendation from practice:

*Sprayfluxing:* If possible, try at first a quantity of 30 – 50 ml/min. and observe the distribution of the flux. After that, correct the quantity. Air-pressure: 18 – 20 l/min.

### *Preheating:*

*(If preheating system is used)*

Entering the solder-wave, the temperature on the topside of the pasteboards should be 80 – 110 °C, dependent on type of boards, lay-out etc. – in case of using lead-free solders, preheating temperatures of 100 – 140 °C on the topsides are possible.

**Packing units:** Jerrycans with 5 and 20 litres, other packing sizes on request

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The above described attributes are average values. They are meant solely for your information and are no specifications as such. These instructions of use are without obligation and do not exempt our customers from their own trials of suitability for their own purposes.