

## No Clean, Halogen Free Flux

### Description

836-P is a flux pen containing a halogen-free organic flux with low activity. The flux has a low solids content and leaves virtually no residue. Solder joints appear shiny after soldering, even without cleaning.

836-P is designed for the prototyping, rework and repair of conventional and surface mount circuit boards.

### Features and Benefits

- *Meets IPC J-STD-004B and type ORLO*
- *For both leaded and lead-free solders*
- *Chiseled tip allows precise application*
- *Residues do not require cleaning*
- *Rosin/resin free*
- *Halogen-free*
- *RoHS compliant*

### Usage Parameters

Properties	Value
Shelf life	2 y
Storage temperature limits	0–27 °C [32–80 °F]

## Properties

Flux Properties	Method	Value
Flux classification	J-STD-004B	ORLO
Flux type	J-STD-004B	Organic
Flux activity	J-STD-004B	Low
Halides by weight	IPC-TM-650 2.3.35	<0.5%
Surface insulation resistance (SIR) SIR, J-STD-004	IPC-TM-650 2.6.3.3	$2.1 \times 10^9 \Omega$
Copper mirror	IPC-TM-650 2.3.32	Pass
Acid number (mg KOH/g)	Titration	14–16
Cleaning requirements	—	Recommended
Physical Properties	Method	Value
Color	—	Colorless
Solids %	—	1.9–2.5%
Density	J-STD-004B	0.81 g/mL
Flash point	Closed cup	12 °C [53 °F]

## Health and Safety

Please see the 836-pen Safety Data Sheet (SDS) for further details on transportation, storage, handling, safety guidelines, and regulatory compliance.

## Application Instructions

1. Depress the tip against a hard surface until the felt tip gets wet, but not flooding.
2. Gently brush the wet tip onto the soldering area to apply. To keep the felt saturated and the flow controlled, only press in the tip as needed.
3. Clean residue with MG 4140 or 413B flux removers.

**Note:** The felt tip on a new pen will take a few seconds to fully saturate, so expect an initial delay before the flux starts to flow. Moving the tip in circular motion can help loosen the felt fibers and speed up the saturation process.

## Packaging and Supporting Products

Cat. No.	Packaging	Net Volume	Net Weight	Packaged Weight
836-P	Pen	10 mL [0.33 fl oz]	8.10 g [0.28 oz]	40 g [0.09 lb]
836LFNC-1L	Bottle	1 L [1.05 qt]	810 g [1.78 lb]	912 g [2.01 lb]

## Technical Support

Please contact us regarding any questions, suggestions for improvements, or problems with this product. Application notes, instructions and FAQs are located at [www.mgchemicals.com](http://www.mgchemicals.com).

**Email:** [support@mgchemicals.com](mailto:support@mgchemicals.com)

**Phone:** +(1) 800-340-0772 (Canada, Mexico & USA)

+(1) 905-331-1396 (International)

+(44) 1663 362888 (UK & Europe)

**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

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