

Product 385-D
Date 2018.04.13
Release 17.1
Language English

General wave soldering flux

Summary

VOC -- High reliability Flux -- Preferably in N2 atmosphere -- anti dendrite

FLUX CODE	385-D
PROCESS	
No-Clean process	5
Post-solder cleaning	2
INDUSTRY APPLICATION	
Consumer electronics	3
Standard industrial electronics	3
Hi-Rel electronics (automotive)	5
PROCESS CAPABILITY	
Foam fluxing	3
Spray fluxing	5
Short preheat	5
Short contact time	5
Pb-free process Air	3
Pb-free process N2 wave	4
Pb-free process N2 Tunnel	5
Skipped joints	4
Solderballing	4
Bridging	4
PTH filling	4
Cosmetic cleanliness	4
Cosmetic cleanliness N2	5
Shiny joint appearance	4
Pin testability	5
Conformal coating (see AN)	5

Legend	
<i>Epecially made for this purpose</i>	5
<i>Generally qualified for this purpose</i>	4
<i>Generally usable, but not the best choice</i>	3
<i>Generally not usable for this purpose</i>	2
<i>Wrong choice</i>	1

CLASSIFICATION

DIN EN 29454-1: 1994	1.2.3.A
IPC-J-STD-004-A: 2004	RELO

PROPERTIES

Density		@20°C [kg/dm³]	0.804
Acid number	IPC-TM-650 2.3.13	[mg KOH/g]	18.8
Solid content	IPC-TM-650 2.3.34	[% w/w]	2.7
Water content		[% w/w]	1
VOC content		[% w/w]	Remainder
Color			Colorless
Odor			Alcoholic
Thinners			425-00

TEST REPORTS

Certificate of Compliance			Website
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		L
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	Pass
Halide	IPC-TM-650 2.3.35.1	[Fluoride by Spot]	Pass
Copper Corrosion	IPC-TM-650 2.6.15		L
SIR	IPC-TM-650 2.6.3.3		Pass

PACKAGING AND STORAGE

Packaging can	(HDPE) [liter]	10
Packaging Drum	(HDPE) [liter]	200
Shelf-life in months		
Storage temperature	20-25 °C	12

Check material compatibility with every process change!

Industrial chemical product.

Read SDS before use.

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