

EM3115R-L NO CLEAN FLUX

DESCRIPTION

EM3115R-L High rosin mildly activated flux consisting of pure rosin blended with a solvent system exhibiting excellent wetting power.

APPLICATION

EM3115R-L is formulated for use in foaming, spraying, dipping and brushing technique. Recommended topside preheat temperature is 100-120 °C.

PHYSICAL PROPERTIES AND RELIABILITY DATA

PHYSICAL PROPERTIES AND RELIABILITY DATA	SPECIFICATION	TEST METHOD	RESULT (TYPICAL)
Flux Type	-	-	No Clean
Class Type	Refer to J-STD-004	-	ROL1
Color / Appearance	-	-	Amber Liquid
Odor	-	-	Alcohol
Flash Point (T.O.C.)	-	-	18 °C
Specific Gravity@25°C	-	-	0.823 ± 0.005
Solid Content	-	J-STD-004, IPC-TM-650, Method 2.3.34	15.0 ± 2.0 %
Halide Content (%) (Chloride and Bromide)	Max 0.1%	JIS Z 3197, Method 8.1.4.2.1	0.07 ± 0.02 %
Acid Value	-	J-STD-004, IPC-TM-650, Method 2.3.13	19.0 – 25.0 mg KOH/g
Corrosion Test	-	J-STD-004, IPC-TM-650, Method 2.6.15	Pass
SIR, IPC (Typical) 85°C / 85% RH After 168 hours	Min 1 x 10 ⁸ Ω	J-STD-004, IPC-TM-650, Method 2.6.3.3	≥ 1 X 10 ⁹ Ω

The information and statements herein are believed to be reliable but are not to be construed as a warranty or representation for which we assure legal responsibility. Users should undertake sufficient verification and testing to determine the suitability for their own particular purpose of any information or products referred to herein. No warranty of fitness for a particular purpose is made. Properties are typical and not to be used as specifications.

WETTING CHARACTERISTICS

Wetting Balance Test of EM3115R-L

Test Equipment: GEN 3 System - MUST System II Solderability Tester

Test Parameter	
Dimension Copper Test Coupon	25mm x 6mm x 0.5mm
Test Temperature	260 °C
Immersion Depth	5 mm
Immersion Speed	20 mm/s
Test/Dip Time	5s

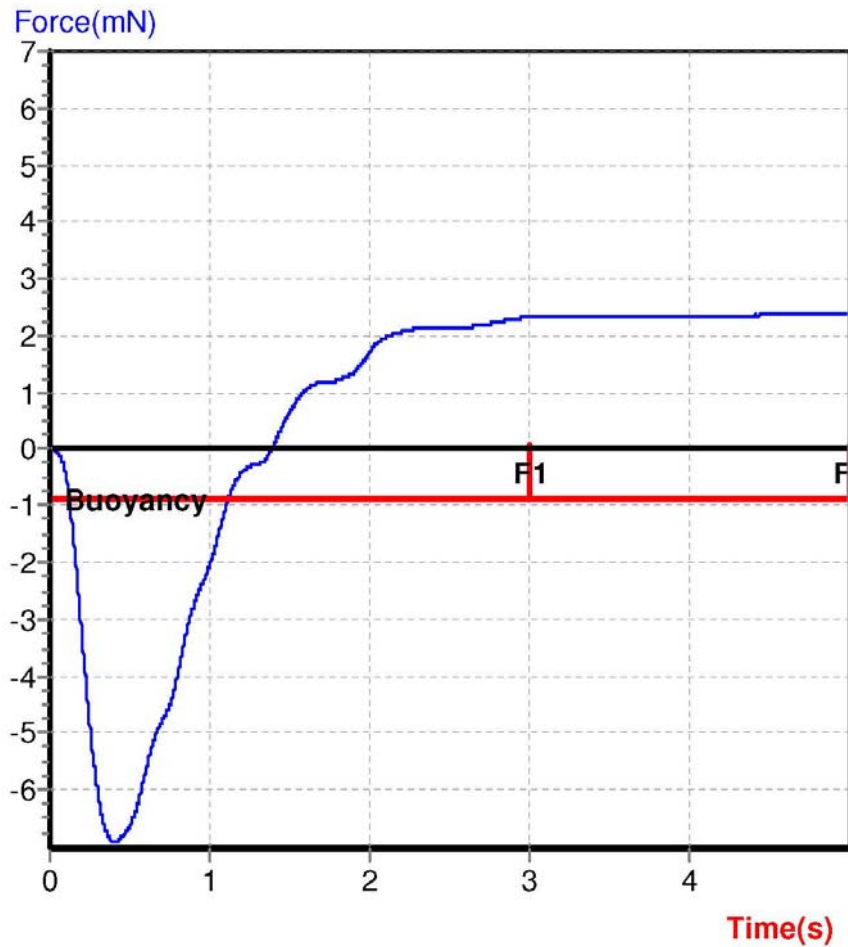


Figure 1: Wetting Characteristics for EM3115R-L with Lead Free Alloy LF-307B

Result: Force Maximum, F_{max} (mN): 2.519

Complied with J-STD-003B Wetting Balance Parameter and Suggested Criteria.

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RESIDUE

The residue is considered non-hygroscopic, non-tacky and can be removed easily with bi-polar solvent. It is suggested, when applicable, to remove all undecomposed flux to attain higher reliability.

THINNING

EM3115R-L does exhibit some evaporation under normal operating conditions and in order to restore it to its original specific gravity, thinner should be used.

PACKING

Available in 25 litres carboy or 200 litres drum.

STORAGE

EM3115R-L flux is alcohol-based and is flammable. Store away from sources of ignition.

HEALTH AND SAFETY

Refer to the MSDS for guidance on safety and health issues

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