

EM3155R-L

NO CLEAN FLUX

DESCRIPTION

EM3155R-L A halide formula with minimal rosin amount for modern machine soldering of electronic assemblies. Performs well with high density mounting chips and through hole components. Post residue is not tacky.

APPLICATION

EM3155R-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	-	-	Transparent Light Yellowish Liquid
Odor	-	-	Alcohol
Flash Point (T.O.C.)	-	-	18 °C
Specific Gravity@25°C	-	-	0.802 ± 0.005
Solid Content	-	J-STD-004, IPC-TM-650, Method 2.3.34	6.0 ± 2.0 %
Halide Content (%) (Chloride and Bromide)	Max 0.1%	JIS Z 3197, Method 8.1.4.2.1	0.06 ± 0.02 %
Acid Value	-	J-STD-004, IPC-TM-650, Method 2.3.13	18.0 – 24.0 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 ¹⁰ Ω

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WETTING CHARACTERISTICS

Wetting Balance Test of EM3155R-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

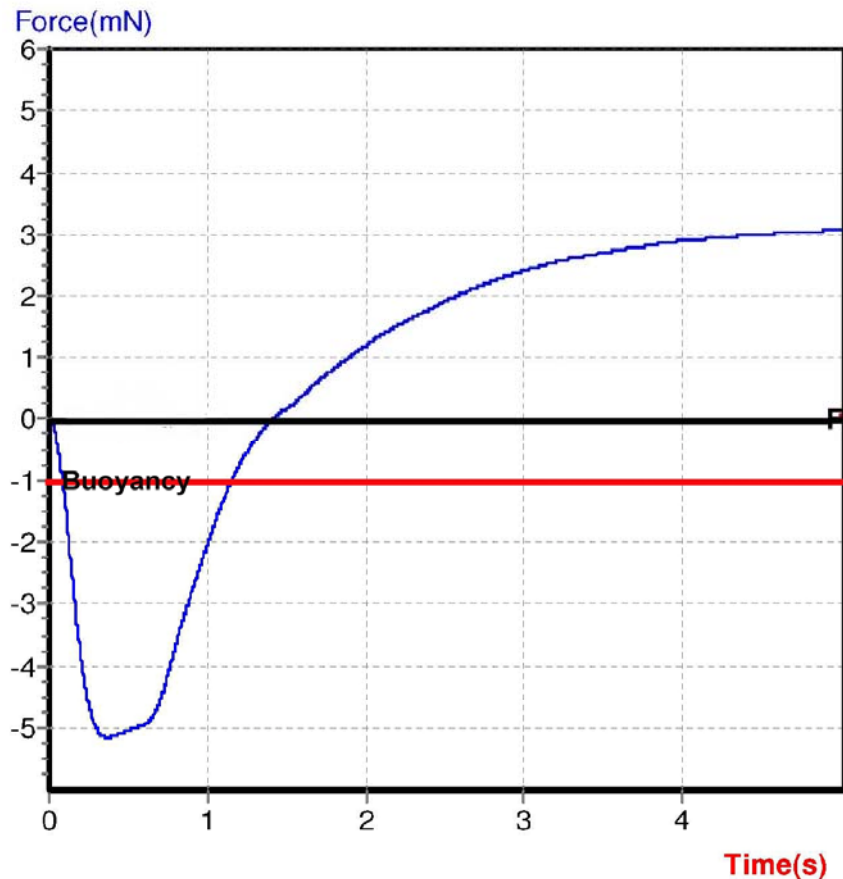


Figure 1: Wetting Characteristics for EM3155R-L with Lead Free Alloy LF-307B

Result: Force Maximum, F_{max} (mN): 3.065

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

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THINNING

EM3155R-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

EM3155R-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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