



## SRA #385 No-Clean Flux, Solvent Based (3% Solids)

### Key Features

- No-Clean flux that eliminates the need for cleaning post-soldered boards.
- Increased activity level.
- No-Clean formulation that can be removed with water.
- Can be used with both Lead-free and Tin-Lead solders.
- Excellent for wire tinning in automated and manual wire tinning systems.
- A good flux for hand soldering PCB assemblies in touch-up or build-out processes.
- Low -solids content.
- Conforms to ANSI-J-STD-004, Type ORL0
- Meets SIR and Ion Chromatography Requirements per IPC Standards (See Page 2)

### DESCRIPTION

**SRA #325 No-Clean Flux, Solvent Based (3% Solids)** flux is formulated for spray fluxing application in wave soldering. It can also be used for wire tinning applications. **SRA #325 No-Clean Flux, Solvent Based (3% Solids)** is an alcohol-based No-Clean flux that contains non-halide activators. The absence of halides and the very low solids content of the flux leaves parts with only negligible traces of low reactivity residues. The flux contains virtually no water and will not spatter on contact with molten solder. This flux contains no rosin or resins, and successfully replaces rosin fluxes. In both electronic applications of PCBs, wave and hand soldering, along with wire tinning, the No. 325 is a No-Clean flux that is also a Water-Soluble flux and can be left on the boards or washed in hot water post-soldering.

### APPLICATION

#### I. WAVE SOLDERING

**SRA #325 No-Clean Flux, Solvent Based (3% Solids)** may be applied by foam, spray, or wave application. The topside board preheat temperature recommendation is 93-115°C/200-240°F.

For optimum soldering results, use the following guidelines:

- ❶ Make certain that the PCB surfaces are free of any oil, grease, or other impurities.
- ❷ Maintain a consistent foam head by narrowing the flux chimney, or using dual flux stones.
- ❸ Add fresh flux to maintain proper flux level in flux tank.
- ❹ Replace the flux daily unless a sealed, self-contained system is used; such as in a spray fluxing system.
- ❺ Regularly clean the fluxing equipment. Never leave foaming stone in flux when pressure is not applied.
- ❻ Clean fluxing stone in flux thinner.
- ❼ When foam fluxing, flux properties can be maintained by monitoring the specific gravity. However, control by checking the acid value is recommended as the most accurate measure. Titration kits are available from Superior Flux.
- ❽ Add flux thinner when needed.

#### II. WIRE TINNING

**SRA #325 No-Clean Flux, Solvent Based (3% Solids)** is an excellent flux for automated or manual wire tinning processes.

For optimum soldering results, use the following guidelines:

- ❶ Make certain that wire surfaces are free of any oil, grease, or other impurities.
- ❷ Dip wire leads in flux



## PHYSICAL PROPERTIES

Form	Clear Liquid
Specific Gravity	0.805 ± 0.01 @ 20-25°C/68-77°F
Density	6.93 lbs/gallon @ 20-25°C/68-77°F
Solids Content	<3.5%
Chloride/Halide Content	None
Flash Point	15.5°C (TCC)
Soldering Range	390-500°F/200-260°C
Water Content	Less than 1%
Boiling Point	78.3°C
Freezing Effects	None
Acid Number	25-30
Discoloration	None
Water-Solubility	Yes, Use Water that is 60°C /140°F

**THIS PRODUCT IS RoHS 3 COMPLIANT.**

## SPECIFICATIONS

- Meets Surface Insulation Resistance Requirements per IPC-TM-650, Method 2.6.3.7 & IPC J-STD-004B, paragraph 3.4.1.4.
- Meets Ion Chromatography Requirements per IPC-TM-650, method 2.3.28.1

## SAFETY PRECAUTIONS

**SRA #325 No-Clean Flux, Solvent Based (3% Solids)** is a flammable product and should be handled with care and the normal precautions taken when working with chemical products.

When soldering with **SRA #325 No-Clean Flux, Solvent Based (3% Solids)**, adequate exhaust ventilation should be provided. Avoid contact with eyes, skin, and mucous membranes. Always wear NIOSH approved safety equipment when working with chemicals. Store in UN plastic containers away from heat.

Store flux in an area with controlled temperature of 18°C/64°F – 25°C/77°F.

Refer to Safety Data Sheet (SDS) for additional safety information.

**SRA #325 No-Clean Flux, Solvent Based (3% Solids)** has a two (2) year shelf life.

