

Product Data Sheet

Product	385-D
Productgroup	General Wave Solder Flux
Date	19-09-2006
Release	6.1

5	Especially made for this purpose
4	Generally qualified for this purpose
3	Generally usable, but not the best choice
2	Generally not usable for this purpose
1	Wrong choice

ISO 9454-1	1.2.3.A
IPC-ANSI-J-STD-004	RELO
JIS Z 3197	1.2.3.N_1
No-Clean process	5
Post-solder cleaning	2
Selective Soldering	5
Pb-Free process - Ambient	4
Pb-Free process - N2	5
N2 Process - Full Tunnel	5
N2 Process - Wave Only	5
Consumer electronics	3
Med-Rel electronics	5
Hi-Rel electronics	5
1-layer, video/tv boards	2
2-layer boards	5
Multi-layer boards	5
OSP compatible	4
Ni/Au compatibel	5
Ni/Pd compatible	5
Ag compatible	4
Sn compatible	5
Foam fluxing	5
Nozzle-spray fluxing	5
Moderate preheat	5
Short contact time with solder	5
Reduces skipped joints	5
Reduces solder balling	4
Reduces bridging	4
Promotes wicking	4
Cosmetic cleanliness	4
Cosmetic cleanliness N2	5
Dull/frosty joints	2
ICCT compatible	5
Conformal coating	5

SG @ 20 °C [kg/dm3] (+/- 0.5%)	0.804
Solids content [% w/w]	1.91
Halides [Silver-Chromate Test]	Pass
Halides [Potentiometric]	Pass
Acid number [mgKOH] (+/-2.5%)	18.75
Water content [% w/w]	1.
VOC-content [% w/w]**	94.00
Filmformer(s)	Synthetic
Flashpoint COC [°C]	11.9
Odor	Alcoholic
Color	Colorless
Telcordia/Bellcore TR-NWT-000078/3	-
Test report(s)	-
Certificate of Compliance	Available
SPC-data*	Auditable
Environmental Load Unit	6.60
RoHS-Compliance Certificate	Available
User's Guidelines	English
Thinner	425-00
Packaging	
Can (HDPE) [liter]	10
Drum (HDPE) [liter]	200
Shelf-life (Weeks)	
Storage 20 [°C]	52.
Storage 25 [°C]	40.
*Certain conditions apply.	
**Having a vapor pressure of >0.01 mm Hg @ 25 °C	
Industrial chemical product. Read MSDS before use.	