

Date 2021.08.18
Language English
SDS 950309



Summary

385-D is a REL0 classified, alcohol-based flux for high reliability automotive applications under nitrogen atmosphere. It is based on synthetic resins and exhibits minimized dendrite formation.

Flux code	385-D
PROCESS	
No-Clean process	9
Post-solder cleaning	4

INDUSTRY APPLICATION	
Standard electronics	6
Industrial electronics	6
Hi-Rel electronics (automotive)	9

PROCESS CAPABILITY	
Foam fluxing	6
Spray fluxing	9
Short preheat	9
Short contact time	9
Pb-free process Air	6
Pb-free process N2 wave	8
Pb-free process N2 Tunnel	9
Skipped joints	8
Solderballing	8
Bridging	8
Promotes wicking	8
PTH filling	8
Cosmetic cleanliness	8
Cosmetic cleanliness N2	9
Shiny joint appearance	8
Pin testability	9
Conformal coating (see AN)	9

Legend	
<i>Especially made for this purpose</i>	9 - 10
<i>Generally qualified for this purpose</i>	7 - 8
<i>Generally usable, but not the best choice</i>	5 - 6
<i>Generally not usable for this purpose</i>	3 - 4
<i>Wrong choice</i>	1 - 2

CLASSIFICATION	
DIN EN 29454-1: 1994	1.2.3.A
IPC-J-STD-004-A: 2004	REL0

PROPERTIES		
Density	@20°C [kg/dm³]	0.804
Solid content	[% w/w]	2.7
Acid number	[mg KOH/g]	18.8
Water content	[% w/w]	1
VOC content	[% w/w]	Remainder
Filmformer(s)		Synthetic
Color		Colorless
Odor		Alcoholic
Flashpoint COC	[°C]	11.9
Thinners		425-00

TEST REPORTS			
Certificate of Compliance		Website	
Application Note		EN/DE	
Copper Mirror	IPC-TM-650 2.3.32		Pass
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		Pass
SIR	IPC-TM-650 2.6.3.3		Pass
ECM	IPC-TM-650 2.6.14.1		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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