

Date	2021.03.09
Language	English
SDS	950505



## SUMMARY

Tacky flux for SnPb application

PASTE	385-TEM
<b>PROCESS</b>	
No-Clean process	7
Post-solder cleaning	7

INDUSTRY APPLICATION	
Consumer electronics	5
Standard industrial electronics	4
Hi-Rel electronics (automotive)	4

PROCESS CAPABILITY	
Printing	4
Pb-free Profile Air, short	7
Pb-free Profile Air, long	5
Pb-free process N2	6
Disc / Dip transfer	7
Long open time	6
Reduces dewetting	7
Cosmetic cleanliness	6
ICCT compatible	7
Conformal coating	6

Legend	
<i>Epecially 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

Check material compatibility with every process change!

Industrial chemical product.

Read MSDS before use.

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## CLASSIFICATION

DIN-EN-29454-1: 1994	1.2.3.A
IPC-J-STD-004-A: 2004	REM0

## PROPERTIES

Flux code		385-TEM	
Solids	[% w/w]	43	
VOC content	[% w/w]	Remainder	
Filmformer		Synthetic Resin	
Max. printing speed	[mm/s]	200	
Recomended peak temp.	[°C]	260	
Acid number	[mg KOH/g]	66	
Residues		Amber	
Tackiness Malcom TK1	IPC-TM650 2.4.44	[gf] @ 0h	150

## TEST REPORTS

Certificate of Compliance	Website
Application Note	N/A

## PACKAGING AND STORAGE

Packaging syringe	HDPE [g]	10
Packaging jar	PP [g]	90
Packaging cartridge	HDPE [g]	250
Minimum shelf-life in months	4-10 °C	12