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Language English
SDS 950310



Summary

390-RX-HT+ is an ORL0 classified, alcohol-based flux for wave soldering. It is based on organic acids and is specifically designed for high reliability automotive applications. It shows hardly visible residues at high SIR values.

Flux code	390-RX-HT+
PROCESS	
No-Clean process	9
Post-solder cleaning	4

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

PROCESS CAPABILITY	
Foam fluxing	8
Spray fluxing	9
Short preheat	9
Short contact time	9
Pb-free process Air	8
Pb-free process N2 wave	9
Pb-free process N2 Tunnel	9
Skipped joints	8
Solderballing	8
Bridging	8
Promotes wicking	9
PTH filling	9
Cosmetic cleanliness	9
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 ISO 9454-1: 2016	2221
IPC-J-STD-004-A: 2004	ORL0

PROPERTIES		
Density	@20°C [kg/dm³]	0.812
Solid content	[% w/w]	3.0
Acid number	[mg KOH/g]	17.1
Water content	[% w/w]	4
VOC content	[% w/w]	Remainder
Filmformer(s)		Synthetic
Color		Colorless
Odor		Alcoholic
Flashpoint COC	[°C]	13
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	18

Check material compatibility with every process change!
Industrial chemical product.
Read SDS before use.

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