

**Product** 396-DRX-M+  
**Date** 2018.04.13  
**Release** 14.1  
**Language** English

## General wave soldering flux

### Summary

VOC-free -- General wave flux -- Ultra low residues -- reduces bridging

FLUX CODE	396-DRX-M+
<b>PROCESS</b>	
No-Clean process	5
Post-solder cleaning	4
<b>INDUSTRY APPLICATION</b>	
Consumer electronics	4
Standard industrial electronics	5
Hi-Rel electronics (automotive)	2
<b>PROCESS CAPABILITY</b>	
Foam fluxing	2
Spray fluxing	5
Short preheat	3
Short contact time	5
Pb-free process Air	5
Pb-free process N2 wave	5
Pb-free process N2 Tunnel	4
Skipped joints	5
Solderballing	4
Bridging	5
PTH filling	5
Cosmetic cleanliness	4
Cosmetic cleanliness N2	5
Shiny joint appearance	4
Pin testability	5
Conformal coating (see AN)	TBD

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

### CLASSIFICATION

DIN EN ISO 9454-1: 2016	2131
IPC-J-STD-004-A: 2004	ORL0

### PROPERTIES

Density		@20°C [kg/dm³]	1.008
Acid number	IPC-TM-650 2.3.13	[mg KOH/g]	27.7
Solid content	IPC-TM-650 2.3.34	[% w/w]	3.4
Water content		[% w/w]	96
VOC content		[% w/w]	Remainder
Color			Colorless
Odor			none
Thinners			Di-water

### TEST REPORTS

Certificate of Compliance			Website
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		L
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		L
SIR	IPC-TM-650 2.6.3.3		Pass

### PACKAGING AND STORAGE

Packaging can	(HDPE) [liter]	10
Packaging Drum	(HDPE) [liter]	200
<b>Shelf-life in months</b>		
Storage temperature	20-25 °C	24

Check material compatibility with every process change!

Industrial chemical product.

Read SDS before use.

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