

<b>Product</b>	<b>95-DRX+</b>
<b>Date</b>	2018.04.13
<b>Release</b>	14.1
<b>Language</b>	English

## General wave soldering flux

### Summary

Low-VOC -- Ultra low residues -- preferable in N2 atmosphere

FLUX CODE	95-DRX+
<b>PROCESS</b>	
No-Clean process	5
Post-solder cleaning	4
<b>INDUSTRY APPLICATION</b>	
Consumer electronics	3
Standard industrial electronics	5
Hi-Rel electronics (automotive)	3
<b>PROCESS CAPABILITY</b>	
Foam fluxing	4
Spray fluxing	5
Short preheat	4
Short contact time	4
Pb-free process Air	4
Pb-free process N2 wave	4
Pb-free process N2 Tunnel	5
Skipped joints	5
Solderballing	4
Bridging	4
PTH filling	5
Cosmetic cleanliness	5
Cosmetic cleanliness N2	5
Shiny joint appearance	4
Pin testability	5
Conformal coating (see AN)	TBD

Legend	
<i>Epecially 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]	0.895
Acid number	IPC-TM-650 2.3.13	[mg KOH/g]	22.3
Solid content	IPC-TM-650 2.3.34	[% w/w]	2.7
Water content		[% w/w]	40
VOC content		[% w/w]	Remainder
Color			Colorless
Odor			Mild Alcoholic
Thinners			425-00

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	9

Check material compatibility with every process change!

Industrial chemical product.

Read SDS before use.

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