SOLDER CHEMISTRY

WAVE SOLDERING FLUX PRO 342

Type ISO 9454 / 1-2.2.3 A ; RE L0

GENERAL DATA

PRO 342 is a special spray flux (other applications are possible), developed in compliance with the international standards ISO 9454 / 1-2.2.3 A and IPC J-STD-004 for modern machine soldering of electronic assemblies with standard components as well as SMD's.

PRO 342 contains superior activators for the perfect wetting of soldered surfaces and component leads on PCBs, even if there are slight traces of corrosion. Soldered assemblies are virtually residue free and show excellent and very clean solder points.

PRO 342 is highly efficient, thus very economic for the user. The smallest quantities obtain a super yield of a large number of excellently soldered assemblies.

PRO 342 is suitable for automatic soldering processes. The flux application onto assemblies is possible with all known fluxing methods. PRO 342 has been designed for soldering in double and single waves. The flux sustains its long term stability during the process.

PHYSICAL DATA

Colour	: water clear
Flash point	: 13℃
Density 20℃	: 0.818 g/cm³
Solid content	: 3.5 %
Halide content	: none
Acid number	: 28±2
Flux type	: ISO 9454/1-1.2.3.A/ JPC-J-STD-004 ; RE L0
Solvent	: PRO SOLVENT I

Preheating:

The usual preheat temperature measured at components side should be 90℃ - 12O℃.

Line speed:

Recommended speed on the solder wave : ca. 1.O-2.O m/min.

Solder temperature:

Solder temperature should not pass 260℃

Packing:

Delivery packing are 10 litre and 25 litre plastic canister.

Comments:

At soldering machines which are equiped with a spray head the amounts of dosing have to be reduced and because of the low resin content the spray head and the surrounding have to be cleaned from the residues steadily. Constantly remaining residues can create a resin crust on the surface of the machine parts.
The digestibility of PRO 342 to the all materials used in the electronic productions was tested with positive results. Nevertheless we recommend to do the digestibility tests for some plastics, varnishes or inscribes. Suitability of flux residues according to the function safety of assembly during work should be tested. Especially for the use at higher temperature and humidity (>93%).
During use the assembly should be protected against wetting.
For storage and transport the same protection measures are required.

The use of chemicals requires the following legal regulations. Look at references on Dangerous Properties of Industrial Materials (N.Irving Sax 1984) or ACGIH TLV´s. For waste disposal guidelines follow the material safety data sheet.

Safety measures:

Follow instructions of material safety data sheet Pro 342

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