



No-Clean Fluxes

Qualitek no-clean fluxes are formulated to meet the changing requirements for today's soldering operations. Designed for wave soldering conventional and SMT circuit board assemblies, these extremely low solids content fluxes leave practically no residue after soldering. Boards are dry and cosmetically clean as they exit the wave solder machine. There are no residues to interfere with electrical test probes and the expense of cleaning is eliminated.

Qualitek NC fluxes are formulated to provide good activity while being halogen-free, non-corrosive and without surface insulation resistance degradation. No offensive odors are given off during soldering.

No-Clean Flux Titration Kits

- *HDT-200 Titration Kit*

This titration kit is designed for ease in testing the acid number of No-Clean flux. The hand held titrator reads in digital units simplifying process control.



Water-Soluble Fluxes

Organic fluxes are commonly called "water soluble fluxes." Organic fluxes generally provide greater fluxing ability than rosin, but the ionizable nature of the water-soluble residue makes organic fluxes too conductive and potentially corrosive to leave on electronic assemblies. The organic fluxes are not as heat stable as rosin fluxes but do provide more rapid fluxing action for high speed soldering.

Because of the ability to remove organic flux residue with water and the ease of disposal of the cleaning solutions, organic fluxes

Continued Water-Soluble Fluxes

are more frequently being used for electronics soldering applications. A circuit board assembly must be designed for the use of organic flux and water cleaning since all of the residue must be removed.

Rosin Fluxes

Qualitek rosin fluxes are formulated with high quality purified Grade WW rosin conforming to LLL-R-626 in specially blended solvent systems. The choice of the proper flux formula is based on the soldering application, desired rosin percentage, type of solvent and the activity level required.

Rosin Mildly Activated (RMA) Fluxes

Qualitek RMA type fluxes have high thermal stability for soldering multi-layer assemblies. Exposure to high preheat temperatures does not degrade solubility of the residue in normal cleaning solvents.

Fully Activated Rosin Fluxes

These fluxes are clear, homogeneous solutions of Grade WW rosin in special alcohol solvent systems into which have been incorporated highly efficient activating agents. The flux residues are non-corrosive and non-conductive when subjected to normal conditions where the solvent is volatilized and the residue is dry.

Lead Tinning Fluxes

Lead tinning is a process of hot solder dipping of semiconductor and other electronic components. This solder coating provides a thick non-porous surface which enables a long solderable storage life.

Qualitek offers a line of fluxes for use in the lead tinning process. These fluxes are halide free therefore they will not cause internal package corrosion.

Qualitek lead tinning fluxes are precisely formulated to provide an effective solder coat for various types of lead tinning applications.

No-Clean Liquid Fluxes

No-Clean Formula	Specific Gravity	Solid Content (wt.%)	Acid Number	Flash Point (TCC)	Flux Classification
302	0.800	2.0	20.0	53°F	ORLO
305	0.795	5.0	25.0	53°F	ROLO
326	0.806	2.0	19.0	53°F	ORLO
360	0.818	2.5	16.0	58°F	ORLO
365	0.850	2.3	18.0	53°F	ORLO
380	0.793	3.3	18.0	53°F	ROLO
391S	0.804	2.0	18.0	53°F	ORLO
No-Clean VOC Free					
350	1.010	4.3	20.0	None	ORLO
351	1.065	2.8	36.0	None	ORLO
355	1.020	3.0	34.0	None	ORLO
357	1.010	2.0	20.0	None	ORLO
358	1.030	7.0	52.0	None	ORLO

Water-Soluble Liquid Fluxes

Water-Soluble Formula	Specific Gravity	Solid Content (wt.%)	Halides %	Flash Point (TCC)	Flux Classification
713N	0.884	25.0	1.90	62°F	ORH1
714N	0.834	16.0	1.90	53°F	ORH1
735-11	0.956	16.0	3.00	71°F	ORH1
737N	0.846	17.0	2.20	53°F	ORH1
775	0.873	28.0	1.90	53°F	ORM1
Water-Soluble VOC Free					
735VF	1.050	18.0	3.00	None	ORH1
737NVF	1.010	13.0	2.20	None	ORH1

Lead Tinning Fluxes

Lead Tinning Formula	Specific Gravity	Solid Content (wt.%)	PH	Flash Point (TCC)	Flux Classification
813	0.870	18.0	2.80	53°F	ORM0
814	0.942	22.0	2.80	53°F	ORM0
820	0.865	27.0	8.30	53°F	ORM0
737N	0.846	17.0	2.20	53°F	ORM0
Lead Tinning VOC Free					
830VHF	1.050	15.0	3.00	None	ORM0

Rosin Based Fluxes

(Non Activated) R	Specific Gravity	Solid Content (wt.%)	Halides %	Flash Point (TCC)	Flux
125	0.844	25.0	--	53°F	ROLO
140	0.882	40.0	--	53°F	ROLO
(Mildly Activated) RMA					
285	0.871	36.0	0.147	53°F	ROL1
285-85	0.844	25.0	0.147	53°F	ROL1
(Fully Activated) RA					
512MM	0.840	32.0	0.435	53°F	ROM1
515	0.829	19.5	0.304	53°F	ROM1
525MIL	0.840	32.0	0.435	53°F	ROM1
535MIL	0.862	35.0	0.217	53°F	ROM1
545	0.928	50.0	0.440	53°F	ROM1