



Technical Bulletin

RF-450 IR Fusing Flux

I. Description:

RF 450 IR Fusing Flux is an organic water-soluble fusing fluid that has been custom blended for tin-lead infrared fusing machines. It contains activators, which clean exposed copper, thereby providing excellent edge coverage.

Benefits

1. Excellent Solder Cosmetics.
2. Non-Foaming. Easy to rinse.

Application

Apply according to IR equipment manufacturer's recommendations. Solution may be re-circulated 3-4 times before changing. The specific gravity should be maintained by using FLUX THINNER 100. Always rinse boards after processing because the flux remains active and will cause corrosion. DI water is recommended for final rinsing to lower ionic contamination. Rinse aids can also aid in reducing ionic residues if necessary. Anti-foaming agents are available to control excessive foam in rinse water.

II. Operating Parameters

Make-Up	100% RF450
Temperature	Room temperature.
Immersion Time	Not applicable
Process	Automated
Agitation	Not necessary
Ventilation	Advised
Tanks	Polypropylene, CPVC
Racks and Baskets	Not applicable
Heaters	Not necessary
Filtration	Not necessary

III. Physical Properties

Specific gravity	0.98 – 1.00
Appearance	Clear-Light Amber liquid
pH	0.0 – 2.0
Odor	Alcohol
Flash Point	60°F

IV. Control Procedures

Consumption of flux is normally limited by drag out. Should control specific gravity within 0.06 units. Dragging water in will increase the specific gravity and drying of solvent in flux will increase the specific gravity. Thinning can be achieved through appropriate additions of FT-100 Flux thinner.

V. Analysis

Specific gravity analysis if necessary (see section IV)

VI. Safety and Storage

RF450 is acidic and flammable and should be handled with care. Avoid open flames. Do not store in direct sunlight, high temperature or below freezing.

VII. Waste Treatment

IR Fluxes should not be bled into waste treatment systems because of the large percentage of organic solvents. Consult with local officials for waste disposal regulations

Please ask a Florida CirTech technical sales rep. for more information regarding waste treatment of this chemistry and our complete line of waste treatment line if additional help or information is desired.

VIII. Miscellaneous

Available in 5-gallon pails and 55-gallon drums. Consult MSDS sheet for additional information.

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