SM467-3

ALPHA 3355-11
WATER SOLUBLE FLUX

DESCRIPTION
ALPHA 3355-11 Water Soluble Flux is a water removable flux used in the soldering of printed circuit and electronic hardware. This formulation produces exceptional solder wetting to a wide variety of metallic surfaces and is unsurpassed in water solubility for thorough post solder removal.

APPLICATION
Primarily for foam application and conveyorized soldering, **ALPHA 3355-11** Flux can be spray, dip, wave or brush applied. Flux applicators and reservoir should be plastic or titanium only.

Flux coated surfaces should be preheated to provide optimum wicking and solder joint formation. The degree of preheat is dependent on many variables, such as conveyor speed, type of components and substrates. Entering the solder wave with a topside temperature in the 210-230°F range is typical.

CONTROL
The foam applicators should be supplied with compressed air, free of oil and water. Maintain flux fluid level sufficiently above the aerator stone to produce adequate foam height. Adjust air pressure to produce the optimum height with foam consisting of small uniform bubbles.

During use, the specific gravity of the flux should be checked periodically. This can be accomplished with a hydrometer, i.e., **LONCO®** Specific Gravity Kit (EQ030). Evaporated solvent should be replenished by the addition of flux thinner.

In time, debris and contaminants will accumulate in the flux. For consistent soldering performance, replace flux periodically. After dumping used flux, the reservoir and aerator stone should be thoroughly cleaned with flux thinner. Refill the reservoir with fresh flux and allow a few minutes for foam to stabilized before resuming solder operation.

REMOVAL
After soldering, the water soluble residues must be removed. Removal can be accomplished in multi-zone conveyorized in-line spray systems, automated batch spray systems (dishwashers) or multi-stage batch tank cleaning. Multiple zone in-line systems equipped with quality tap or conditioned water, an effective air knife and drying capacity can produce MIL P-28809 ionic cleanliness levels

A **LONCOTERGE®** saponifier or **LONCO** 2051 series Neutralizer product is recommended for improving cleanliness levels in batch and in-line systems with limited cleaning capabilities. Incorporating a saponifier or neutralizer will assist the removal of flux residues, aqueous spot masks and other contaminants.

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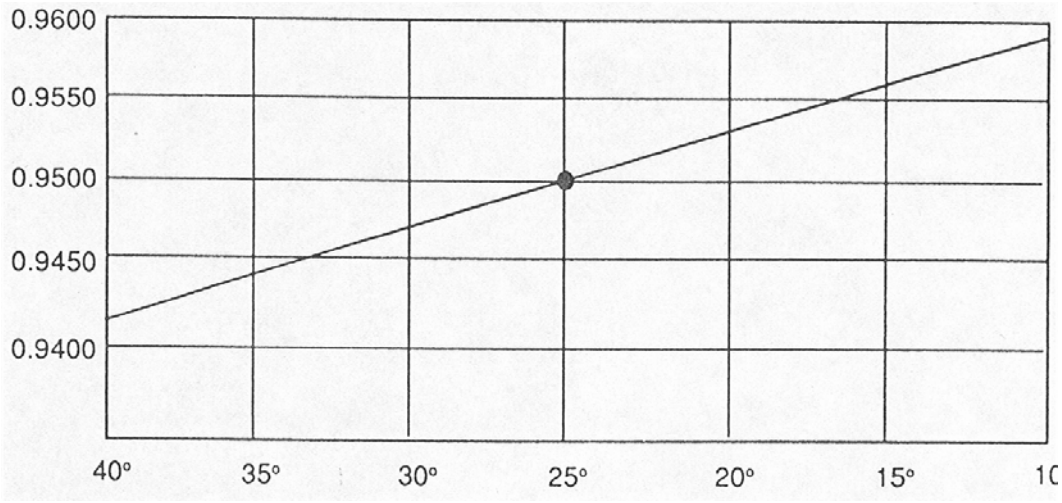
Cookson Electronics ASSEMBLY MATERIALS

ORGANO-FLUX TM 3355-11 FLUX

PHYSICAL PROPERTIES

PARAMETERS	TYPICAL VALUES	TEST METHOD
Specific Gravity @ 25°C	0.95 ± 0.02	5-6-80-CC
Pounds per Gallon	7.91	Calculated
Solids Content wt/wt	17%	Calculated
Flash Point	71°F	6-23-81-BB
Acid Number	60	1-29081 MP
% Chloride	3.0	2-4-81-MP
Flux Thinner	3355-11 Additive	
Classification: ORH1	IPC J-STD-004	

Specific Gravity -vs- Temperture



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