



922-CX / 922-CXF No-Clean Low Solids Liquid Flux

General Information

Kester 922-CX and 922-CXF are non-rosin organic fluxes designed for wave soldering conventional and surface mount circuit board assemblies. These fluxes eliminate defects often experienced in surface mount assembly wave soldering operations with traditional fluxes. These non-corrosive and non-conductive fluxes have an extremely low solids content. There is essentially NO RESIDUE left on the assembly after soldering. There are no residues to interfere with electrical testing and the expense of cleaning is eliminated. A particular feature of 922-CX and 922-CXF is the very dry appearance of PCB assemblies as they exit the wave solder machine. Although cleaning is eliminated, the flux will not harm the electrical reliability of the assembly.

Performance Characteristics

- ◆ Essentially no residue left behind after soldering
- ◆ Eliminates the expense of cleaning
- ◆ Boards are dry as they exit the wave solder machine
- ◆ Non-corrosive and halogen-free
- ◆ No surface insulation resistance degradation
- ◆ No offensive odors given off during soldering
- ◆ Conforms to ANSI/J-STD-004, flux designator ORL0

Application

Kester 922-CX - This formula can be applied to the assembly by dipping, spraying or wave fluxing.

922-CXF - The surface tension of this formula has been adjusted for use in foam fluxing equipment. This flux provides a stable head of small bubbles.

The usable preheat range is 180-230°F (82-110°C), but the optimum preheat temperature for most PCB assemblies is 210-230°F (99-110°C) as measured on the top or component side of the circuit board. Insufficient preheat tends to leave more residue behind after soldering. Excessive preheating time or temperature can partially degrade the flux and result in icicles or solder shorts. 922-CX normally requires less preheat compared to 922-CXF.

Process Control

Control of the flux tank during use is necessary to assure a consistent amount of flux is applied to the circuit boards, the least amount of residue remains after soldering, no interference in electrical probe testing and consistent soldering results are obtained. Kester has developed the PS-20 Flux Test Kit to provide an effective means of determining the relative flux concentration and the proper amount of thinner to add to replace evaporative losses.

Also, debris from circuit boards (board fibers, etc.) and air lines can build up in the flux tank during use. When excessive, it will redeposit on circuit boards which may create a build up of residues on probe test pins and can even affect the foam head characteristic in the flux tank. It is necessary to replace the flux tank with fresh flux when excessive debris accumulates in the flux tank.

Physical Properties

	922-CX	922-CXF	4662
Specific gravity @75°F (24°C)	0.789 ± 0.003	0.802 ± 0.003	0.783 ± 0.003
Pounds per gallon	6.58	6.70	6.53
Solids Content %	2.3	3.2	---
Acid number, mgKOH/gm	14.0 ± 0.7	19.5 ± 1.5	---
Halogen content	None	None	---
Flash point (T.O.C.)	64°F (18°C)	64°F (18°C)	64°F (18°C)
Autoignition temperature	750°F (399°C)	750°F (399°C)	750°F (399°C)
Copper Mirror Corrosion Test	Pass	Pass	---
Surface Insulation Resistance @ 50°C (122°F), 90% humidity*	10 ¹¹ ohm	10 ¹¹ ohm	---
Surface Insulation Resistance @ 85°C (185°F), 85%humidity**	10 ⁹ ohm	10 ⁹ ohm	---
Thinner	4662-SM	4662-SM	

* Test Boards - 12.5 mil lines, 12.5 mil spaces. 50 volts DC bias. Reading taken after 60-sec charge of 100 volts DC with polarity reversed from bias voltage. SIR of unsoldered control = 10¹¹ ohm.

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Residue Properties and Removal

This product is a no-clean flux. For most electronic assemblies, removal of the flux residue is not required. If post soldering residue removal is desired, it can be cleaned with a 2-5% concentration of a saponifier such as the Kester 5768 Bio-Kleen.

Storage & Shelf Life

Kester 922-CX and 922-CXF are flammable. Store away from sources of ignition. Shelf life is 1 year from date of manufacture when handled properly and held at 10-25°C (50-77°F).

Health & Safety

This product, during handling or use, may be hazardous to health or the environment. Read the Material Safety Data Sheet and the label before using this product.

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