

# 182 Soldering Flux

## Mildly Activated Rosin Liquid Flux

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### Product Description

Kester 182 Soldering Flux is a clear homogeneous solution of 25% pure colophony dissolved in isopropyl alcohol with 0.15% diethylamine hydrochloride (CAS 660-68-4). It has been formulated to meet the requirements of IPC J-STD-002 and J-STD-003 for solderability testing. 182 is highly recommended for solderability testing of leads, printed circuit boards and other electrical components because of its consistently high quality.

### Performance Characteristics:

- High quality for solderability testing
- Classified as ROL1 per J-STD-004

### RoHS Compliance

This product meets the requirements of the Restriction of Hazardous Substances (RoHS) Directive, 2011/65/EU for the stated banned substances.

### Physical Properties

**Specific Gravity:** 0.843 ± 0.005

Antoine Paar DMA @ 25 °C

**Percent Solids (typical):** 25

Tested to J-STD-004, IPC-TM-650, Method 2.3.34

**Flash Point:** 18 °C (64 °F)

### Reliability Properties

**Copper Mirror Corrosion:** Low

Tested to J-STD-004, IPC-TM-650, Method 2.3.32

**Corrosion Test:** Low

Tested to J-STD-004, IPC-TM-650, Method 2.6.15

**Silver Chromate:** Pass

Tested to J-STD-004, IPC-TM-650, Method 2.3.33

**Chloride and Bromides: 0.05%**

Tested to J-STD-004, IPC-TM-650, Method 2.3.35

**Fluorides by Spot Test: Pass**

Tested to J-STD-004, IPC-TM-650, Method 2.3.35.1

## Flux Application

182 is typically applied by a dip process.

## Process Considerations

182 is highly recommended for solderability testing of leads, printed circuit boards and other electrical components because of their consistently high quality.

## Flux Control

Specific gravity is normally the most reliable method to control the flux concentration of rosin-based fluxes. To check concentration, a hydrometer should be used. The solvent system for the flux makes it imperative that Kester 4662 Thinner be used to replace evaporative losses. When excessive debris from circuit boards, such as board fibers and from the airline build up in the flux tank, these particulates will redeposit on the circuit boards which may create a buildup of residues on probe test pins. It is, therefore, necessary to clean the tank and then replenish it with fresh flux when excessive debris accumulates in the flux tank.

## Cleaning

182 residues are non-conductive, non-corrosive and do not require removal in most applications. If residue removal is required, call Kester Technical Support.

## Storage, Handling and Shelf Life

182 is flammable. Store away from sources of ignition. Shelf life is 2 years from the date of manufacture when handled properly and held at 10 to 25 °C (50 to 77 °F).

## Health and Safety

This product, during handling or use, may be hazardous to your health or the environment. Read the Safety Data Sheet and warning label before using this product. Safety Data Sheets are available at <https://www.kester.com/downloads/sds>.

## Contact Information

To confirm this document is the most recent version, please contact [Assembly@MacDermidAlpha.com](mailto:Assembly@MacDermidAlpha.com)

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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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