Product Description

Kester TSF-6522 is a no-clean tacky soldering flux formula designed to be used with a rotating disc, a doctor blade or a drum fluxer. TSF-6522 can also be used in dot dispensing for BGA/PGA sites or in a rework application for surface mount packages. TSF-6522 maintains its activity and dispensing characteristics for up to 8 hours and can be used in a wide range of temperature and humidity conditions. Kester maintains the highest standards by manufacturing TSF-6522 under a vacuum environment.

Performance Characteristics:
- High tack values and long tack life
- Leaves bright/shiny solder joints after reflow
- Can reflow in air or nitrogen environments
- Classified as ROL0 per J-STD-004B
- Compliant to Bellcore GR-78

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

Viscosity (typical): 285 poise
Malcom Viscometer @ 10rpm and 25°C

Initial Tackiness (typical): 100 grams
Tested to J-STD-005, IPC-TM-650, Method 2.4.44

Acid Number: 75.4 mg KOH/g of flux
Tested to J-STD-004, IPC-TM-650, Method 2.3.13

Reliability Properties

Copper Mirror Corrosion: Low
Tested to J-STD-004, IPC-TM-650, Method 2.3.32

Silver Chromate: Pass
Tested to J-STD-004, IPC-TM-650, Method 2.3.33

Chloride and Bromides: None
Detected
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

SIR, IPC (typical): Pass
Tested to J-STD-004, IPC-TM-650, Method 2.6.3.7

<table>
<thead>
<tr>
<th></th>
<th>Blank</th>
<th>TSF-6522</th>
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</thead>
<tbody>
<tr>
<td>Day 1</td>
<td>3.1*10^10 Ω</td>
<td>2.6*10^10 Ω</td>
</tr>
<tr>
<td>Day 4</td>
<td>1.3*10^10 Ω</td>
<td>4.2*10^10 Ω</td>
</tr>
<tr>
<td>Day 7</td>
<td>8.8*10^10 Ω</td>
<td>6.4*10^10 Ω</td>
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</tbody>
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Storage, Handling and Shelf Life

Refrigeration is the recommended optimum storage condition for TSF-6522 to maintain consistent viscosity, reflow characteristics and overall performance. TSF-6522 should be stabilized at room temperature prior to printing. TSF-6522 should be kept at standard refrigeration conditions, 0-10°C (32-50°F). Please contact Kester Technical Support if you require additional advice with regard storage and handling of this material. Shelf life is 6 months from the date of manufacture when handled properly and held at 0-10°C (32-50°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.