



135 Soldering Flux

Non-Activated Rosin Liquid Flux

Product Description

Kester 135 non-activated rosin flux is a clear homogeneous solution of pure water-white rosin dissolved in a suitable solvent. The particular solvents used are liquids which exhibit the same non-corrosive and non-conductive properties as rosin itself. 135 is carefully processed to remove foreign particles found in natural rosin. Under the older MIL-F-14256, this flux was QPL approved as Type R. 135 is considerably more mobile because of its solids content and the low surface tension of the alcohol solvent. The high purity grade of alcohol solvent makes this flux very reliable for solderability testing.

Performance Characteristics:

- High quality for solderability testing
- Classified as ROL0 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: 0.880 ± 0.005
Antoine Paar DMA 35 @ 25°C

VOC Content (g/liter): 522

Flash Point: 18°C (64°F)

Percent Solids (typical): 40
Tested to J-STD-004, IPC-TM-650, Method 2.3.34

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

Fluorides by Spot Test: Pass
Tested to J-STD-004, IPC-TM-650, Method 2.3.35.1

Corrosion Test: Low
Tested to J-STD-004, IPC-TM-650, Method 2.6.15

Chloride and Bromides: None
Detected
Tested to J-STD-004, IPC-TM-650, Method 2.3.35

Flux Application

Kester 135 is typically applied by a dip process.

Process Considerations

Kester non-activated rosin fluxes are used for applications where active flux is not permitted and critical electronic assemblies are involved. They are 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 complex nature of 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 air line build up in the flux tank, these particulates will redeposit on the circuit boards which may create a build up 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

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

Storage and Shelf Life

Kester 135 is flammable. Store away from sources of ignition. Shelf life is 2 years from date of manufacture when handled properly and held at 10-25°C (50-77°F). Periodically, flux separation may occur in this product. If this occurs, shake container before use.

Health and Safety

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