



182 Soldering Flux

Mildly Activated Rosin Liquid Flux

Product Description

Kester 182 rosin 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
Anton 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

Silver Chromate: Fail
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: 0.05%
Tested to J-STD-004, IPC-TM-650, Method 2.3.35

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 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

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 10-25°C (50-77°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.