

KESTER® 952-S SOLDERING FLUX

Zero Halogen, Low-Solid Liquid Flux for Photovoltaic Assembly

DESCRIPTION

Kester 952-S Soldering Flux is a zero-halogen, non-rosin organic flux designed specifically for use in tabber and stringer equipment of Photovoltaic Assembly (PV) module industry by soldering tabs to cell contacts. 952-S could be applied directly to interconnecting ribbon by hand soldering or auto-equipment with tabber and stringer soldering system, by dipping or spraying. The extremely low solids content (< 2%) and nature of the activator system results in practically no residue left on the cell after soldering. Cell are dry and cosmetically clean as they exit the tabber and stringer machine. 952-S has a wider operating window varying with temperature range, and can be used in SnPb, SnAgPb and Pb-free alloys.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES & BENEFITS

- Zero-Halogen
- Produces high reliable ribbon that interconnects solar cells
- Wetting and Drying quickly allowing fast throughput
- Eliminates cleaning process
- Leaves less uniform residue to get higher power transfer efficiencies
- Classified as ORL0 per J-STD-004
- Compatible with the most popular EVA
- Can be applied by spraying and dipping
- Low-Solids

ROHS COMPLIANCE

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

TECHNICAL DATA

Category	Results	Procedure/Remarks
Physical Properties		
Specific Gravity (Typical)	0.803	Anton Paar DMA 35 @ 25 °C
Acid Number (Typical)	15.0 mg KOH/g flux	Tested by potentiometric titration
Percent Solids (Theoretical)	<2%	
Reliability Properties		
Copper Mirror Corrosion	Pass	Tested to J-STD-004, IPC-TM-650, Method 2.3.32
Corrosion Test	Pass	Tested to J-STD-004B, IPC-TM-650, Method 2.6.15
Chloride and Bromide	Non Detected	Tested to J-STD-004, IPC-TM-650, Method 2.3.35
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

FLUX APPLICATION

Need to ensure flux is sufficiently applied on the cell to prevent dewetting and residues.

PROCESSING GUIDELINES

Process Considerations

952-S is engineered for the PV module industry for both automated tabber and stringer application, and hand soldering. Standard pre-heating and heat temperature can be used without special cooling or pre-baking required. Consult your machine supplier or MacDermid Alpha Technical Support for further information.

Cleaning

952-S flux residues are non-conductive, non-corrosive and do not require removal in most applications. If residue removal is required, contact MacDermid Alpha Technical Support for further cleaning recommendation.

Storage, Handling and Shelf Life

952-S is flammable. Store away from sources of ignition. Shelf life is 1 year from the date of manufacture when handled properly and stored between 10 to 43 °C.

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area.



SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available.**

CONTACT INFORMATION

www.macdermidalpha.com

North America 140 Centennial Avenue Piscataway, NJ 08854 1.800.367.5460	Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400	Asia 8/F., Two Sky Parc 51 Hung To Road Kwun Tong, Kowloon, Hong Kong, SAR China 852.2500.5365
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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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