

KESTER® 135 SOLDERING FLUX

Non-Activated Rosin Liquid Flux

DESCRIPTION

Kester 135 Soldering Flux is a 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.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES & BENEFITS

- 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.

TECHNICAL DATA

Category	Results	Procedure/Remarks
Physical Properties		
Specific Gravity	0.880 ± 0.005	Antoine Paar DMA 35 @ 25 °C
Percent Solids (Typical)	40	Tested to J-STD-004, IPC-TM-650, Method 2.3.34
VOC Content (g/liter)	522	
Flash Point	18 °C (64 °F)	
Reliability Properties		

Category	Results	Procedure/Remarks
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	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

FLUX APPLICATION

135 is typically applied by a dip process.

PROCESSING GUIDELINES

MacDermid Alpha 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 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

135 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.

Storage, Handling and Shelf Life

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 to 25 °C (50 to 77 °F). Periodically, flux separation may occur in this product. If this occurs, shake the container before use.

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

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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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