

## 952-D6 Flux-Pen®

Low-Solids No-Clean Flux-Pen for Lead-bearing and Lead-free Alloys

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### Product Description

Kester 952-D6 Flux-Pen is a no-clean, non-corrosive, halide-free Flux-Pen that is specifically designed for lead-free rework of conventional and surface mount circuit board assemblies. Essentially no residue remains after soldering. 952-D6 Flux-Pen was developed with a modified surface tension to aid in soldering boards that have surface mount and high component densities. This comprehensive formulation possesses improved wetting characteristics and also exhibits superior corrosion inhibiting properties and provides a non-tacky residue. A major advantage of this flux is the reduced odor associated with the soldering process. 952-D6 Flux-Pen incorporates a small amount of rosin for higher reliability.

### Performance Characteristics:

- Residues almost colorless
- Improves soldering performance
- Reduced odor associated with soldering process
- Eliminates the need and expense of cleaning
- Non-corrosive tack-free residues
- Contains < 0.5% Rosin
- Classified as ORL0 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:**  $0.812 \pm 0.005$

Anton Paar DMA @ 25 °C

**Percent Solids (theoretical):** 3.1%

Tested to J-STD-004, IPC-TM-650, Method 2.3.34

**Acid Number (typical):** 21.4 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

### 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

### Surface Insulation Resistivity (SIR) IPC (typical): Pass

Tested to J-STD-004, IPC-TM-650, Method 2.6.3.3

	Blank	952-D6
Day 1	$2.7 \times 10^{10} \Omega$	$9.4 \times 10^{10} \Omega$
Day 4	$1.3 \times 10^{10} \Omega$	$7.8 \times 10^{10} \Omega$
Day 7	$9.8 \times 10^{10} \Omega$	$6.3 \times 10^{10} \Omega$

## Flux Application

952-D6 Flux-Pen is applied to circuit boards via Flux-Pen for rework of printed wire assemblies.

## Process Considerations

952-D6 Flux-Pen should only be applied to areas that will be fully heated by the soldering iron or other reflow tool. Care should be taken to avoid flooding the assembly. The surface tension has been adjusted to help the flux form a thin film on the board surface allowing rapid solvent evaporation.

## Cleaning

952-D6 Flux-Pen flux residues are non-conductive, non-corrosive and do not require removal in most applications.

## Storage, Handling and Shelf Life

952-D6 Flux-Pen 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). The cap must be in place when not being used.

## 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. Safety Data Sheets are available at <https://www.kester.com/downloads/sds>.

## Contact Information

To confirm this document is the most recent version, please contact  
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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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