



## LIQUID FLUX 500-3429/1

Halide-free activated resin flux

### DESCRIPTION

Halide-free activated resin flux conforming to DIN EN 29454-1 Type 2.2.3 (DIN 8511 F-SW 34).

Stannol 500-3429/1 was designed for the use in double wave soldering machines especially to solder SMD components.

Stannol 500-3429/1 offers good wetting of the solder despite the low solid content. Most of the solids are rinsed off by the action of the solder wave so that the PCB surface has a clean aspect. If any residue remains, it has No-Clean properties. Post soldering residues are dry and transparent.

### APPLICATION

Stannol 500-3429/1 is suitable for foam or spray fluxers. The preheat temperature should be adjusted to 100°C at the top side of the board before entering the wave to get optimum results. Depending on the board design other temperatures may be possible.

Evaporation of solvent can change the composition. Evaporation causes an increase of the solid content and therefore the density increases. This can be checked with the Stannol Mini-Titration-Kit.

### PHYSICAL PROPERTIES AND DATA

GENERAL PROPERTIES	LIQUID FLUX 500-3429/1	
Appearance:	light amber liquid	
Density (20°C):	0.802 g/cm <sup>3</sup>	
Flash Point (closed cup):	13°C	
Auto Ignition Temperature:	425°C	
Solid Content:	2.6%	
Acid Value:	16.7 mg KOH/g	
Copper Mirror:	passed	
Silver Chromate Paper Test:	passed	
Halide Content:	none	
SIR:	1.0*10 <sup>12</sup> Ω uncleaned, soldered	8.9*10 <sup>11</sup> Ω fluxed
E-Corrosion:	none	none
Test Method:	Bellcore TR-NWT 000078	
Thinner:	Stannol VD-500	

## **SHELF LIFE**

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2 years after date of delivery (provided proper storage in originally sealed container).

## **HEALTH AND SAFETY**

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Before using please read the material safety data sheet carefully and observe the safety precautions described.

## **NOTICE**

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The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advise is not binding for the company, whether such information originates from the company offices or from a sales representative. This is also in respect of any protection rights of third parties, and does not release the customer from the responsibility of verifying the products of the company for suitability of use for the intended process or purpose. Should any liability on the part of the company arise, the company will only indemnify for loss or damage to the same extent as for defects in quality.