



STANNOL®

Wenn's ums Löten geht
When it's about soldering
Quand il s'agit du soudage

Technical Data Sheet

STANNOL® NO-CLEAN flux 900-3302

Halide-free activated flux classified as 2.2.3.A according to DIN EN 29454-1 (DIN 8511 F-SW23).
The residues are not corrosive according to tests in accordance with DIN 8527 F-SW 32.

Description

STANNOL® 900-3302 has a solid content of only 1.9%, virtually all of the residues are rinsed off the printed circuit assembly during the soldering operation. This means that ATE (Automatic Testing Equipment) can be used without the necessity for prior cleaning. The test probes are not contaminated by insulating flux residues. The remaining residues are faintly visible, but dry. Boards soldered with **STANNOL® 900-3302** can also be conformally-coated without difficulty.

The composition of **STANNOL® 900-3302** permits it to be successfully used even in double-wave soldering applications, as in soldering of SMD-components. Unlike most conventional low-residue no-clean fluxes, the **STANNOL® 900-3302** formulation ensures that sufficient flux is carried from the first wave to the second. This assists in removing excess solder, providing perfectly formed fillets and evenly-coated circuitry. In inert atmosphere equipment, the low solid content results in virtually residue-free printed circuit boards.

Application

STANNOL® 900-3302 was developed specifically for foam-fluxing applications. Excessive flux should be blown off the assemblies by means of an air knife. Other methods of application such as spray-fluxing can also be used without difficulty. It is recommended that for greatest fluxing efficiency the top side of the printed circuit assembly should be preheated prior to soldering to a temperature of approximately 90°-110°C.

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

Colour:	colourless
Specific Gravity (20°C):	0.820 g/cm ³
Flashpoint (closed cup):	12°C
Auto Ignition Temperature:	425°C
Solids Content:	1.9%
Acid Number:	16 mg KOH/g
Changes in SIR:	passes DIN 8511 F-SW 32
SIR:	passes Belcore TR-NWT-00078 (>1 * 10 ¹¹)
Corrosion:	passes DIN 8527 F-SW 32
Copper Mirror Test:	passes IPC-SF-818
Copper Corrosion:	none (10 days) IPC-SF-818

Thinner: STANNOL® VD-E 3302

Shelf life

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

Health and Safety

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

The above values are typical and represent no form of specification. The Data Sheet serves for information purposes. Any verbal or written advice 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.