



**STANNOL**®

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

## Technical Data Sheet

### STANNOL® liquid flux EasyFlux 350

No-clean flux classified as type 2.2.3.A according to DIN-EN 29454-1, type ORL0 according to EN 61190-1-1 and type ORL0 according to J-STD-004.

- **multi-purpose application, low residues**
- **moderate solid content - fast wetting**
- **no-clean application, electrically safe**
- **perfect wetting results with lead containing and lead-free alloys**

#### Description

**STANNOL® EasyFlux 350** is halide free activated. The new formula of the activators guarantees an optimum wetting of the different surfaces (such as OSP, Ni/Au, HAL, chem Sn and chem.Ag) used in PCB manufacturing and so avoids problems when new printed circuit boards with alternative surfaces are introduced. The EF350 may be used with lead-containing and lead-free solders, where best wetting result may be achieved. Best results were achieved when using **STANNOL® ECOLOY®** and **FLOWTIN® TSC** (Tin/Silver/Copper), **TS** (Tin/Silver) and **TC** (Tin/Copper) alloys.

A low percentage of special additives were integrated into the flux formulation in order to meet the requirements on the soldering behaviour of the flux and the electrical safety of the residues, left after soldering.

#### Application

The **STANNOL® EasyFlux 350** has been developed for application with **spray fluxers**, but foam fluxers can also be used. The preheat temperature should be at least 90° C measured on the surface of the circuit board when entering the solder wave. This temperature ensures the evaporation of the solvent and a sufficient activation of the flux. Preheat temperatures up to 120-130°C for a short period of time may be tolerated by the flux.

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

<b>Colour:</b>	light-yellow
<b>Density at (20° C):</b>	0.811 g/cm <sup>3</sup>
<b>Flash point (closed crucible):</b>	12°C
<b>Ignition temperature:</b>	425°C
<b>Solid content:</b>	3.5 %
<b>Acid rating:</b>	27.0 mg KOH/g
<b>Halide content:</b>	none
<b>Copper mirror test:</b>	passed
<b>Silver chromate paper test:</b>	passed
<b>Surface Insulation Resistance:</b>	>10 <sup>8</sup> Ω
<b>Corrosion:</b>	none

**Thinner:** STANNOL® VD-500

#### 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.

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