



EIE Enterprise (M) Sdn. Bhd. (944691-T)

HI-GRADE 3549-3 HF NO-CLEAN FLUX

DESCRIPTION

HI-GRADE 3549-3 HF are specially formulated low solids flux designed for wave soldering where the solder cleaning operations are to be eliminated. This flux contains a small amount of resin which enhances the wetting properties.

HI-GRADE 3549-3 HF is activated by multi-component, synergetic fluxing system, which improves solderability. Any remaining residues after soldering are considered non-corrosive and do not interfere with ATE testing.

BENEFITS

- Meets Bellcore specification TR-NWT-000078
- Meets IPC J-STD-004 specification for flux type LO
- Eliminates the need for cleaning
- Reduces solder ball formation
- Compatible with conformal coatings without cleaning
- Completely non-halide

PROCESS RECOMMENDATIONS

HI-GRADE 3549-3 HF can be applied by wave, foam, or spray. Use the following suggestions to improve the foaming characteristics:

- Narrow the flux chimney
- Use dual stones
- Add brushes inside chimney
- Maintain flux level
- Clean foam fluxing stone regularly
- Maintain specific gravity or acid value with 16-3552X thinner

HI-GRADE 3549-3 HF can be used in all types of spray fluxers. This flux can be used very effectively in single or dual wave soldering systems. Assemblies with surface mount, leaded components or mixed technology can be soldered successfully.

PHYSICAL PROPERTIES

	<u>3549-3HF</u>	<u>16-3552-X</u>
Appearance	Amber	Clear
Specific Gravity		
@77° F(25° C)	0.793	0.783
@60° F(15.5° C)	0.800	0.788
Pounds per Gallon	6.66	6.50
Percent Solids	3%	0%
Acid Value	18.0	None
Flash Point	54° F TCC	54° F TCC
Halide Content	None	N/A
Silver Chromate Paper	Pass	N/A
Copper Mirror	Pass	N/A
Copper Corrosion	Pass	N/A

BELLCORE SURFACE INSULATION RESISTANCE TEST

Test pattern	Boards	Final Reading *
Standard Bellcore test pattern, 0.025" wide lines	Pattern-up	5.53 x 10"
0.050" spacing	Pattern-down	1.68 x 10"

*** ALL READINGS ARE EXPRESSED IN OHMS**

SAFETY

Flammable liquids should always be stored in a dry, well ventilated environment away from open flames, sparks or direct heat. As with all Hi-grade flux products, a material safety data sheet (MSDS) is available.

PACKAGING

25 litres