



No Clean Flux TS 3-FL Technical Data

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LOW SOLIDS NO CLEAN FLUX

FOAM, SPRAY AND WAVE APPLICATIONS

DESCRIPTION

TS 3-FL is a low solids no-clean flux containing modified synthetic rosin in a specially blend solvent vehicle containing controlled amount of synergistic organic activating agents.

The residues left on the board is minimal, non hygroscopic and possesses high surface insulation resistance thus making **TS 3-FL** particularly suitable for no-clean application.

The residues are fast drying, tack free, non corrosive and minimum, therefore present no problem to pin testing.



PHYSICAL PROPERTIES

Physical state	: Slight yellow, transparent liquid
Density at 25°C	: 0.801 g/ml
Solid content % W/W	: 3.70 %
Free Halide % W/W	: 0.00 %
Flash Point	: 16.0°C
Surface Insulation Resistance	: 1 X 10 ¹¹ Ohms
IPC SF 818 Flux Classification	: L3NC
Thinner to use	: T 1000 to control the specific gravity between 0.798 and 0.804 at 25°C

PACKAGING

TS 3-FL is available in packing of 20 liters plastic carboy and 200 liters drum packing.

APPLICATION

TS 3-FL is designed for defects free manual and automatic soldering of conventional and SMD printed circuit board. **TS 3-FL** is extremely effective in soldering of dot held surface mountable components, such as leadless chip capacitors and resistors, SOIC's etc using dual wave equipment.

TS 3-FL is suitable for soldering a variety of surfaces including copper, lead, tin, solder and silver.

TS 3-FL can be applied by foaming, wave or spray techniques.

TS 3-FL will give very fine bubble foam when a aerator stone with pores of 10 to 20 µm is used in conjunction with a flux fluid level in the flux tank kept at least 1.5 inches above the aerator stone.

To achieve an optimum soldering result and a tack free surface, a preheat temperature of about 80 to 90°C for single sided board and 90 to 110°C for double sided board (measured on the component side) is recommended.



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