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| Updated: 21/05/2015 | TECHNICAL DATA SHEET |  |
| Ref. : Flux | <u>BC 310.45</u> | |
| Created: 08/03/01 | <u>Rosinous RMA Soldering Flux</u> | |



GENERAL CHARACTERISTICS:

Flux BC310.45 contains 45% of activated rosin.
 Flux type ROL1 according to standard J-STD-004.
 Flux type 1.1.2 according to standard ISO EN 9454.

PHYSIOCHEMICAL CHARACTERISTICS:

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| Solution | : Alcoholised |
| Colour | : Honey |
| Density at 20°C | : 0.905 |
| Efficiency (SAR) | : Angle < 30° - grade III |
| Water washing | : Insoluble |
| Alcohol washing | : Very soluble |
| Flash point | : 12°C |
| Dry extract | : 45% |
| Acid value | : 85.5 mgKOH/g |
| Chloride content | : 0.11% |

ADDITIONAL INFORMATION:

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in Europe).

A quality Certificate can be obtained on Request



INSTRUCTION OF USE :

Flux BC310.45 can be used for foam fluxing in all types of automatic flow soldering machines. Due to its concentration, this flux avoids the formation of icicles, craters and facilitates a good capillary rise in metallized holes.

Preheat temperature after fluxing should be between 90° and 100°C to give a good activation.

Flux BC 310.45 residue may remain on the circuit without risk of corrosion or loss of insulation resistance. Any remaining residues can be cleaned efficiently leaving no surface film, by means of alcoholised solvent.

Maintenance of the flux density is achieved by adding dilutant D305 to within the limits of SPG. 0.900 to 0.910.

MISCELLANEOUS:

Health and Safety : As with all soldering fluxes, BC310.45 must be used in a well ventilated area away from any source of flame or ignition (COSH sheet available).

Packaging : Throwaway plastic containers of 5, 10 and 20 litres.

Storage : In original hermetically sealed containers, stored at an ideal temperature near 20°C for 12 months maximum.

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