



SRA #300 Organic Acid Flux

Key Features

- Formulated for electronic, electrical, industrial, artisan, and aerospace applications, including:
 - ◆ Printed Circuit Boards (PCBs)
 - ◆ Wire, Cable, and Terminal Lead Tinning and Soldering
 - ◆ Flat and Round Wire Fabrication
 - ◆ Semiconductor and Component Lead Tinning
 - ◆ Stained Glass
- Used for Copper, Beryllium-Copper, Nickel, Alloy 42, Alloy 51, Brass, and some steels.
- VOC-Free formulation is non-hazardous and environmentally friendly.
- Conforms to IPC ANSI J-STD-004, Type ORM1.
- DIN 29-454-1, Type 2.1.2A
- Broad activity range an excellent choice for Tin/Lead, Tin/Silver, Tin/Bismuth, and Indium solder alloys.

DESCRIPTION

SRA #300 Organic Acid Flux contains an amino acid-halide activator which starts to clean metals at room temperature, reaching peak fluxing activity at 260°C/500°F, where it promotes excellent solderability. The broad range of activity makes **SRA #300 Organic Acid Flux** an ideal choice for high production rates or difficult metal surface conditions where an active, but safe, flux is required.

DIRECTIONS

SRA #300 Organic Acid Flux can be used in dipping, spraying, brushing, swabbing, and many other fluxing operations. Soldering processes should include the following steps:

- ❶ Remove any oil, grease, mold release, or other contaminants from the surface to be soldered.
- ❷ Apply flux to joint by dipping, spraying, dragging, swabbing or brushing to area being soldered.
- ❸ Preheat or air-dry area to be soldered after flux has been applied to activate the flux and yield optimum soldering characteristics and reduce or eliminate spattering.
- ❹ Apply solder, dip part, or place iron to area being soldered.
- ❺ Clean flux residues from soldered area using de-ionized, distilled, RO, and in some cases tap water heated to a temperature of 60°C±5°C /140°F±10°F for best results. Room temperature water may also be used.

Post-solder residues from **SRA #300 Organic Acid Flux** are self-neutralizing at soldering temperatures, owing to the unique flux chemistry. However, removal of the residues is imperative for electronic applications to prevent corrosion to sensitive joints and components and promote long-term reliability of assemblies. The residues and raw flux are completely water soluble and should be washed in an aqueous cleaning system using de-ionized or distilled water heated to a recommended temperature of at least 60°C±5°C /140°F±10°F. The addition of one gram of non-ionic surfactant to four (4) liters of water is recommended to reduce the wash water surface tension and make it a more effective cleaner. Each user must determine the best cleaning procedure to meet required specifications.

It is recommended that flux be changed in soldering processes using a flux pot at least once a week to maintain consistent flux performance and provide maintenance and cleaning of the flux pot. However, different environmental conditions may necessitate more frequent or less frequent flux changes to be determined by the end-user.



PHYSICAL PROPERTIES

Form	Clear Blue Liquid
Specific Gravity	1.04 ± 0.01 @ 20-25°C/68-77°F
Density	8.66 Lbs/Gallon
pH	1.125 ± 0.375
Solids Content	12.15%
Chloride Content	12.5 - 17.5 g Chlorine/liter
Chloride %	1.40%
Acid Equivalent	0.60 - 1.00 g H+/liter
Spread Factor	80 minimum
Surface Tension	35 dynes/cm maximum
Flash Point	None
Freezing Effect	None
Inorganic Cation Content	None
Recommended Soldering Range	95-315°C/200-600°F
Residues	Completely Water Soluble

THIS PRODUCT IS RoHS COMPLIANT

CLASSIFICATIONS

- IPC ANSI-J-STD-004, Type ORM1
- US Army Satellite Communications Agency Specification No. SM-A571678.
- Federal Specification QQ-S-571E, Type AC, Non-Rosin Flux, Organic Chloride.
- Federal Specification O-F-506C, Type I, Form B.
- Boeing Aerospace Material Specification BMS No. 7-57A..

DISPOSAL

SRA Organic Acid Flux is a VOC-Free flux containing organic activators. It has a water base that contains no alcohols, solvents, petroleum derivatives, or inorganic material additives

The following steps should be taken to effect proper disposal:

- 1 Measure out the amount of flux for disposal.
- 2 As a general rule, add soda ash in a 1 to 50 ratio of neutralizer to spent flux. This ratio may differ depending upon pre-neutralization solids content and/or pH.
- 3 When the neutralization bubbling subsides, the solution may be flushed down a drain. The neutralized solution has a pH of 6 to 8. Use a pH meter or paper to determine the pH.

Consult local, state, or federal EPA to determine local guidelines regarding disposal.

SAFETY PRECAUTIONS

SRA Organic Acid Flux is a non-hazardous product, but should be treated as an industrial chemical. Store in plastic containers away from heat, sparks, or open flame. Do not store or place flux in contact with metals. Store flux in an area with controlled temperature between 18-25°C/64-77°F. If the flux is colder or warmer than these temperatures, give flux time to return to this storage temperature range.

Adequate ventilation is necessary to remove flux fumes along with vapors and fumes from hot solder. Avoid breathing vapors and contact with skin, eyes and mucous membranes.

SRA Organic Acid Flux has a two (2) year shelf life.

Refer to the MSDS for additional safety information.

