



## SRA #912 Rosin Flux, Type R

### Key Features

- A non-activated rosin flux for general-purpose soldering of PCB's, wire, cable, and semiconductors, and hand soldering applications.
- Excellent for a variety of metals including copper, gold, nickel alloys, silver, and tin.
- Can be used for automated and manual soldering operations.
- Flux conforms to IPC-ANSI-J-STD-004, Type ROL0.

### DESCRIPTION

**SRA #912 Rosin Flux, Type R** consists of a homogeneous solution of water-white rosin in an alcohol-base. It is completely free of any activators and leaves a non-corrosive, non-conductive, fungus-proof post-solder residue. The flux is widely used in electronic applications requiring excellent soldering activity and yielding residues with no potential for corrosion. **SRA #912 Rosin Flux, Type R** becomes active above 175°C/340°F, attaining peak activity in the temperature range 200-260°C/390-500°F, where it promotes excellent solderability. It can also be used for high-temperature soldering applications, such as mag-wire tinning at temperatures in the 400-430°C/750-800°F range.

### APPLICATIONS

**SRA #912 Rosin Flux, Type R** is an excellent choice for soldering printed circuit boards (PCBs), wire leads, cables, and component tinning. **SRA #912 Rosin Flux, Type R** can be used to solder many different metals and alloys including copper, brass, and other metals commonly used in electronics applications.

### PHYSICAL PROPERTIES

Form	Light Brown Liquid
Specific Gravity	0.89175 ± 0.00825 @ 20-25°C/68-77°F
Density	7.44 ± 0.7 lbs./gallon @ 20°C/68°F
Solids Content	40 ± 2.0%
Free Acidity	None
Chloride Content	None
Inorganic Cations	None
Recommended Soldering Range	200-260°C/390-500°F
Spread Factor	80 minimum
Flash Point (TCC.)	12°C/53°F
Boiling Point	85°C/180°F
Freezing Effects	None
Residue Characteristics	Non-Corrosive, Non-Conductive

**This Product is RoHS Compliant**



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## SPECIFICATIONS

**SRA #912 Rosin Flux, Type R** meets all the requirements of Mil-F-14256F, Type R.

**SRA #912 Rosin Flux, Type R** meets all the requirements of IPC-ANSI-J-STD-004, Type ROL0.

## DIRECTIONS

**SRA #912 Rosin Flux, Type R** can be applied by foaming, brushing, dipping, rolling and spraying. Soldering need not be carried out immediately after fluxing. The residues are completely non-corrosive, non-conductive and fungus-proof, and need not be removed. However, cleaning is easily accomplished by vapor-degreasing methods, using appropriate solvent systems.

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.
- ❹ Apply solder, dip part, or place iron to area being soldered.
- ❺ Cleaning flux residues from soldered area is optional. Use of solvents to remove residues is commonplace. In aqueous cleaning systems, a saponifier may be used for residue removal to meet environmental or safety requirements.

The specific gravity of the flux increases with prolonged use as the solvents evaporate. It can be restored to the recommended value by adding thinner to the flux and mixing thoroughly.

## SAFETY PRECAUTIONS

**SRA #912 Rosin Flux, Type R** is flammable and should be stored in plastic containers away from heat, sparks or an open flame. Use adequate ventilation to remove flux fumes, along with fumes from the soldering station. Avoid contact with skin and eyes and avoid breathing vapors. Flux has a two (2) year shelf life.

Refer to Material Safety Data Sheet (MSDS) for additional safety information.

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