



SRA #3150-PLF No-Clean Soldering Flux – 15mL

KEY FEATURES

- Eliminates the need for cleaning soldered boards.
- May be conformal coated without post cleaning.
- Can be used with lead free solder.
- Conforms to IPC ANSI-J-STD-004, Type ORL0.

DESCRIPTION

SRA #3150-PLF is specially formulated for Lead-Free wave soldering. This flux was designed for soldering high quality electronic printed circuit boards (PCBs), such as, through-hole, mixed technology, and surface mount assemblies while eliminating the need for a post cleaning operation. **SRA #3150-PLF** is formulated for foam and/or spray applications as supplied.

APPLICATION

SRA #3150-PLF No-Clean Flux may be applied by foam, spray, or wave application. The optimum topside PCB preheat temperature recommendation is 93-115°C/200-240°F. Too low a preheat setting is indicated by post-solder residues on PCBs that look like water stains.

For optimum soldering results, use the following guidelines:

- Make certain that the PCB surfaces are free of any oil, grease, or other impurities.
- Maintain a consistent foam head by narrowing the flux chimney, or using dual flux stones.
- Add fresh flux to maintain proper flux level in flux tank.
- Replace the flux daily unless a sealed, self-contained system is used; such as in a spray fluxing system.
- Regularly clean the fluxing equipment. Never leave foaming stone in flux when pressure is not applied.
- Clean fluxing stone in **SRA #950T** flux thinner.
- When foam fluxing, flux properties can be maintained by monitoring the specific gravity. However, control by checking the acid value is recommended as the most accurate measure. Titration kits are available from Superior Flux.
- Add **SRA #950T** flux thinner when needed.
- The recommended amount of flux to apply to PCB surface is between 550 and 1300 µg per in²



PHYSICAL PROPERTIES

Specific Gravity	0.825 ± 0.010 @ 20-25°C/68-77°F
Density	6.76 lb/gal @ 20-25°C/68-77°F
Color	Water white & clear
Halide Content	None
pH 1% Water Solution	4.01 @ 20-25°C/68-77°F
Acid Value	36-44
Percent Solids	4.0 ± 0.2
Flash Point (TCC)	18.3°C/65°F

THIS PRODUCT IS RoHS COMPLIANT

SAFETY PRECAUTIONS

SRA #3150-PLF is a flammable product and should be handled with care and the normal precautions taken when working with chemical products.

When soldering with **SRA #3150-PLF**, adequate exhaust ventilation should be provided. Avoid contact with eyes, skin, and mucous membranes. It is recommended that one wear NIOSH approved safety equipment when working with chemicals. Store in plastic containers away from heat.

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

Store flux in an area with controlled temperature between 18-25°C/64-77°F.

Superior No. 315PLF has a two (2) year shelf life.

