SPRKLE FLUX

EZR-02T

Flux R&D Dept.

SMIC

General Description

SPARKLE FLUX EZR-02T is developed for use lead-free soldering of printed circuit boards.

This flux is a no clean type flux with 2% solid content for soldering machine.

This flux provides high wettability and reliability, and suitable for chip mounted boards.

Features

- This flux is a no clean type flux and ORL0 type flux.
- This flux is developed for use lead-free soldering.
- Suitable for double-wave soldering bath.
- Suitable for chip mounted boards and discrete boards.
- Low residue offers beautiful finish.
- The flux residue dries quickly and has no tack.

Inspection

Item	Properties	Remarks
	EZR-02T	
Appearance	Light color liquid	visible
Specific gravity	0.792	JIS Z 3197
Viscosity	2 mPa･s	JIS Z 3197
Halide content	< 0.002%	JIS Z 3197
Solid content	2%	JIS Z 3197
Spread factor	55% (Sn-3.0Ag-0.5Cu)	JIS Z 3197
Copper corrosion	Pass	JIS Z 3197
Insulation resistance	1 x 10^9 Ω or more	JIS Z 3197
Acid Value	15 mg-KOH/g	IPC-TM-650 2.3.13
Dryness	Pass	JIS Z 3197

Flux Application

EZR-02T can be applied by spray, foam.
In the case of foam, An air knife after the flux tank is recommended to remove excess flux from the circuit board and prevent dripping on the preheater surface.

Wave Soldering Machine Settings

Factors	Parameter
Wave Solder temperature (°C)	255-265
Top side preheat (°C)	105-120
Conveyor speed (m/min)	1.0-1.8
Amount of Flux (Applied by Spray) Single Wave:	78-124 μg/cm^2 of solids (500-800 μg/in^2 of solids)
Amount of Flux (Applied by Spray) Dual Wave:	132-217 μg/cm^2 of solids (850-1400 μg/in^2 of solids)
Dipping time in the wave (Solder)	2-5 seconds

Storage condition

Recommended temperature: Please keep it in a cold and dark place.

Shelf life : 15 month when sealed in original packaging.

Keep away from extreme heat as it is a flammable material.

Health & Safety

Please refer to the Safety Data Sheet as the primary source of health and safety information.
Inhalation of the flux solvent and volatilized activator fumes, which are generated at soldering temperatures, may cause headaches, dizziness and nausea.
Suitable fume extraction equipment should be used to remove the flux from the work area.
Suitable protective clothing should be worn to prevent the material from coming in contact with skin and eyes.
This flux contains a highly flammable solvent. The flux must not be used near open flames or near non-flameproof electrical equipment.