



QUALITEK®

285 and 285-25 Rosin Mildly Activated (RMA)

DESCRIPTION

285 and 285-25 rosin mildly activated flux is formulated to meet the requirements of high speed soldering operations, with activities close to that of a fully activated rosin flux. 285 and 285-25 meet the requirements of type ROL1 per J-STD-004 (formerly MIL-F-14256). The unique activator and solvent system keep the activator from separating after a prolonged period of foaming or waving. The flux performance will remain stable throughout the soldering process.

BENEFITS

- Very bright solder joints
- High SIR value
- Minimal defects
- Non-corrosive
- Meets J-STD-004 (MIL-F-14256)

APPLICATION METHODS

285 and 285-25 can be applied by wave, brush, dip, and foam methods. 285 and 285-25 exhibits superior foaming characteristics with a uniform stable foam head, and is excellent for tinning stranded wire, component leads, and attaching lead frames to hybrid circuit assemblies. Should the flux become viscous due to solvent loss simply add Qualitek 200 thinner to maintain the proper specific gravity and performance.

PHYSICAL & CHEMICAL CHARACTERISTICS

	285	285-25
Color and Appearance	Amber Liquid	Amber Liquid
Solids Content, % (By Wt.)	36 +/- 1.5	25 +/- 1.5
Specific Gravity	0.871 +/- 0.006	0.844 +/- 0.006
Flash Point	53°F	53°F
Water Extract Resistivity	>130,000 ohm-cm	>130,000 ohm-cm
Flux Classification per J-STD-004	ROL1	ROL1
Silver Chromate Paper Test	Pass	Pass
Copper Mirror Test	Pass	Pass
Shelf life (un-opened)	2 years	2 years

RESIDUE REMOVAL

Post soldering residues may be removed with a CFC substitute or Qualitek Everkleen 1005 saponifier in an aqueous cleaning system.

PACKAGING & STORAGE

285 and 285-25 flux is available in 1, 5 and 55 gallon containers. It should be stored in cool, dry place away from ignition sources.

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Consult MSDS for health and safety information