



# QUALITEK®

## 713N Water-soluble Organic Flux

### DESCRIPTION

713N is a highly active organic flux. 713N is designed for complete water cleanability and solubility of post-soldering residues; particularly the ionic and/ or corrosive residues which can cause electrical leakages and corrosion in critical electronic assemblies. Test after test in both in-line and batch cleaning systems showed the cleanliness results of the PC board to exceed the requirements of Specification MIL-P-28809A. 713N is a non-splattering, water-free organic formulation that is suitable for high speed soldering operations. Since 713N does not contain any glycols or its derivatives, it will not evolve an excessive amount of fumes or smoke, nor will it degrade the surface insulation resistance of the soldered assembly. Post-soldering residue is minimal and it can be easily removed using cold or hot water.

### BENEFITS

- Excellent wetting
- Very bright shiny joints

### APPLICATION METHODS

713N is designed for automatic soldering operations where rosin fluxes are not sufficiently active, and inorganic acid fluxes are too corrosive. 713N displays excellent foaming characteristics and may also be applied by spray, dip, brush, or wave methods. The flux applicator and reservoir should be plastic, titanium, or stainless steel. Optimum top-side pre-heat temperature is 170-200°F (77-94°C). Should the flux become too concentrated due to solvent loss, add Qualitek 700 thinner.

### PHYSICAL & CHEMICAL CHARACTERISTICS

<b>Color and Appearance</b>	Light Amber Liquid
<b>Solids Content, % (By Wt.)</b>	25
<b>Specific Gravity</b>	0.884 +/- 0.006
<b>Flash Point</b>	62°F
<b>pH 5% sol</b>	3.5 – 4.0
<b>Flux Classification per J-STD-004</b>	ORH1
<b>% Halides</b>	1.9 +/- 0.3
<b>Shelf life (un-opened)</b>	2 years

### RESIDUE REMOVAL

As with all water-soluble fluxes, post cleaning is required. Residues can be easily removed with both hot and cold water, thus; no neutralizer is needed. De-ionized water should be used in the final rinse for cleanliness results beyond MIL-28809A.

### PACKAGING & STORAGE

713N 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