



QUALITEK®

735-11 Organic Acid, Water Soluble

DESCRIPTION

735-11 is a water removable flux designed for mass soldering of conventional and surface mount assemblies. 735-11 contains a unique activator that permits exceptional wetting on a variety of substrates.

BENEFITS

- Excellent wetting on virtually all type of substrates
- Very bright shiny joints

APPLICATION METHODS

735-11 is designed for automatic soldering operations where rosin fluxes are not sufficiently active, and inorganic acid fluxes are too corrosive. 735-11 may be applied by foam, spray, brush, or wave methods. The flux applicator for 735-11 should be plastic (i.e. PVC or Polypropylene), TFE-coated metal epoxy, or commercially pure titanium. Circuit fingers and conveyor fingers should be titanium. For uniform application, an air knife is recommended. Optimum topside 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

Color and Appearance	Clear Liquid
Solids Content, % (By Wt.)	15.0 – 17.0
Specific Gravity	0.956 +/- 0.006
Flash Point	71°F
pH 5% sol	1.6 – 2.4
Flux Classification per J-STD-004	ORH1
% Halides	3.0 +/- 0.3
Shelf life (un-opened)	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

735-11 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