



QUALITEK®

737NVF WS VOC Free Flux Neutral

DESCRIPTION

737NVF is a neutral, water removable liquid soldering flux designed for wave soldering of conventional and surface mount PCB assemblies. The organic activating system in 737NVF has a neutral pH at room temperature and becomes activated at soldering temperatures. 737NVF is formulated to be effective over a broad preheat range.

BENEFITS

- Excellent wetting on virtually all types of substrates
- Very bright shiny joints
- Neutral pH
- VOC Free

APPLICATION METHODS

737NVF is designed for automatic soldering applications where rosin fluxes are not sufficiently active and inorganic acid fluxes are too corrosive to be used. The flux applicator should be plastic or titanium only. For optimum wetting action, topside preheat temperature of 210 – 240°F (100 – 115°C) is desired. The flux activity may be monitored by periodic measurement of the pH. DI water is used to restore to the specified value. Adjust the specific gravity with DI Water as needed to ensure consistent performance.

PHYSICAL & CHEMICAL CHARACTERISTICS

Color and Appearance	Clear Liquid
Solids Content, % (By Wt.)	12.0 – 15.0
Specific Gravity	1.010 +/- 0.010
Flash Point	None
pH (as is)	6.8 – 7.8
Flux Classification per J-STD-004	ORH1
% Halides	2.2 +/- 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

737NVF 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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TEL: (630) 628-8083 FAX: (630) 628-6543 E-MAIL: solder@qualitek.com HOME PAGE:<http://www.qualitek.com>

HEADQUARTERS: 315 Fairbank St., Addison, IL 60101 U.S.A.

WORLDWIDE BRANCHES: UNITED KINGDOM – MEXICO – CHINA – PHILIPPINES - SINGAPORE

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Rev: 102102-737NVF

Consult MSDS for health and safety information