



SUPERIOR No. 425



VOC-FREE, NO-CLEAN SOLDERING FLUX

- Contains **no** Volatile Organic Compounds.
- Excellent surface wetting.
- Eliminates the need for cleaning soldered boards.
- May be conformal coated without post cleaning.
- Conforms to ANSI-J-STD-004, Type ORL0.

DESCRIPTION

Superior No. 425 VOC-Free, No-Clean flux is a specially formulated low-solids flux free of any Halides, Resin, or Rosin. This flux was formulated for soldering high quality electronic printed circuit boards (PCBs), such as, through-hole, mixed technology, and surface mount assemblies while eliminating the need for a post cleaning operation. **Superior No. 425 VOC-Free, No-Clean** is formulated for foam or spray applications as supplied.

APPLICATION

WAVE SOLDERING:

Superior No. 425 VOC-Free, No-Clean flux may be applied by foam, spray, or wave application. The optimum topside PCB preheat temperature recommendation is 93-115°C/200-240°F. Too low a preheat setting is indicated by post-solder residues on PCBs that look like water stains and solder spattering when PCBs enter the solder bath. A solder-bath temperature of 480°F ± 20°F is recommended for optimum result.

For optimum soldering results, use the following guidelines:

- ❶ Make certain that PCB surfaces are free of any oil, grease, or other impurities.
- ❷ Maintain a consistent foam head by narrowing the flux chimney, or using dual flux stones.
- ❸ Add fresh flux to maintain proper flux level in flux tank.
- ❹ Replace the flux daily unless a sealed, self-contained system is used - such as in a spray fluxing system.
- ❺ Regularly clean the fluxing equipment. Never leave foaming stone in flux when pressure is not applied.
- ❻ When foam fluxing, flux properties can be maintained by monitoring the specific gravity. However, control by checking the acid value is recommended as the most accurate measure. Titration kits are available from Superior Flux.

SAFETY PRECAUTIONS

Superior No. 425 VOC-Free, No-Clean flux is a non-flammable product, but should be handled with care and the normal precautions taken when working with chemical products.

When soldering with **Superior No. 425**, adequate exhaust ventilation should be provided. Avoid contact with eyes, skin, and mucous membranes. Always wear NIOSH approved safety equipment when working with chemicals. Store in plastic containers away from heat.

Store flux in an area with controlled temperature between 18-25°C/64-77°F.

Refer to Material Safety Data Sheet (MSDS) for additional safety information.

Superior No. 425 VOC-Free, No-Clean has a two (2) year shelf life.

Superior manufactures quality fluxes. Our business is solving problems.



**Superior Flux
& Mfg. Co.**

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