

# SRA #99-20 Rosin Flux, Type RMA, No-Clean



# **Key Features**

- ➤ A mildly activated rosin flux for general-purpose soldering of PCB's, wire, cable, and semiconductors, and hand soldering applications.
- Excellent for a variety of metals including copper, gold, nickel alloys, silver, and tin.
- Can be used for automated and manual soldering operations.
- ➤ Conforms to IPC ANSI-J-STD-004, Type ROL1.
- Meets SIR and Ion Chromatography Requirements per IPC Standards (See Page 2)

#### DESCRIPTION

**SRA #99-20 Rosin Flux, Type RMA, No-Clean** consists of a homogeneous solution of water-white rosin in a multi-component solvent system with a brominated organic activator. It is completely chloride-free. The flux is widely used in electronic applications requiring excellent soldering activity and yielding residues with high water-extract resistivities. **SRA #99-20 Rosin Flux, Type RMA, No-Clean** becomes active above 175°C/340°F, attaining peak activity in the temperature range 200-260°C/390-500°F, where it promotes excellent solderability. It can also be used for high-temperature soldering applications, such as mag-wire tinning at temperatures in the 400-430°C/750-800°F range.

# **APPLICATIONS**

**SRA #99-20 Rosin Flux, Type RMA, No-Clean** is an excellent choice for soldering printed circuit boards (PCBs), wire leads, cables, and component tinning. **SRA #99-20 Rosin Flux, Type RMA, No-Clean** can be used to solder many different metals and alloys including copper, gold, alloy 42, alloy 51, nickel alloys, and other metals commonly used in electronics applications.

#### DIRECTIONS

**SRA #99-20 Rosin Flux, Type RMA, No-Clean**can be applied by foaming, brushing, dipping, rolling and spraying. Soldering need not be carried out immediately after fluxing. The residues are completely non-corrosive, non-conductive and fungus-proof, and need not be removed. However, cleaning is easily accomplished by vapor-degreasing methods, using appropriate solvent systems.

The specific gravity of the flux increases with prolonged use as the solvents evaporate. It can be restored to the recommended value by adding **Superior No. 96T Flux Thinner** to the flux and mixing thoroughly.

#### **SPECIFICATIONS**

**SRA #99-20 Rosin Flux, Type RMA, No-Clean** meets all the requirements of Mil-F-14256, Type RMA and is classified as an ROL1 for IPC Standards.





### PHYSICAL PROPERTIES

Form Light Brown Liquid

Specific Gravity 0.859 ± 0.025 @ 20-25°C/68-77°F Density 7.16 lbs./gallon @ 20-25°C/68-77°F

Solids Content  $20\% \pm 1.0\%$ 

Free Acidity
Chloride Content
VOC Content
Inorganic Cations

None
None
None

Recommended Soldering Range 200-260°C/390-500°F

Spread Factor 80 minimum Flash Point (TCC.) 12°C/53°F 82.3°C/180.1°F

Freezing Effects None

Residue Characteristics Non-Corrosive, Non-Conductive

Water Extract Resistivity 150,000 ohm/cm

This Product is RoHS Compliant

## **SPECIFICATIONS**

- Meets Surface Insulation Resistance Requirements per IPC-TM-650, Method 2.6.3.7 & IPC J-STD-004B, paragraph 3.4.1.4.
- Meets Ion Chromatography Requirements per IPC-TM-650, method 2.3.28.1

#### SAFETY PRECAUTIONS

**SRA #99-20 Rosin Flux, Type RMA, No-Clean** is flammable and should be stored in plastic containers away from heat, sparks or an open flame. Use adequate ventilation to remove flux fumes, along with fumes from the soldering station. Avoid contact with skin and eyes and avoid breathing vapors. Flux has a two (2) year shelf life.

Refer to the Safety Data Sheet (SDS) for additional safety information.

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