



## DKL Clearflow 300 No Clean Low Residue Solder Flux

### PRODUCT APPLICATION

DKL Clearflow 300 is a new generation Halide and Rosin/Resin free low solids no clean solder flux specified for wave soldering of all through hole, mixed technology and surface mount assemblies. The flux leaves a tack free finish with very low visible residues and a high surface insulation resistance which does not degrade over service life and resists electromigration. Any residues left on the assembly are not corrosive and will not react with Copper or its alloys. DKL Clearflow 300 can also be used as a localized rework flux. If required, any residues can be removed with an Aqueous PCB cleaner.

### CHARACTERISTICS

**Good Fluxing Activity** - Rapidly forms bright even joints with good wetting on a wide range of PCB finishes.

**No Clean formulation** - Residues are minimal, non-corrosive, and non reactive with Copper and its alloys.

**High reliability PCBA's** - Conforms to IPC and Bellcore (IPC-SF-818 and Bellcore TR-NWT-000078) Stds.

### APPLICATION METHODS

DKL Clearflow 300 is suitable for all types of wave configuration including spray and foam application methods. Suggested fluxing quantities will vary according to the PCBA board finish and assembly design, and must be determined by trials. However expected amounts will normally be in the range of 0.645 to 1.29 ugm/mm<sup>2</sup> (1000 to 2000 ugm/mm<sup>2</sup>). Recommended topside preheat temperatures are in the range 80 to 105 deg. C. Adjustment Thinners type are available for customers using foam application systems. The minimal post solder residues can be left in place, but if desired removal cleaning can be carried out on localised cleaning, and in batches offline by immersion or spray in air. DKL Clearflow 300 can also be used as a touch up and rework flux by applying to the localized soldering area by brush, dispenser or dropper bottle.

### PACKAGING AVAILABILITY

DKL Clearflow 300 is packed into plastic containers. Standard pack sizes are 5 litres and 10 litres. Larger pack sizes can be supplied subject to availability.

### PHYSICAL & CHEMICAL PROPERTIES

Appearance: Liquid.

Odour: None.

Solids content wt/wt: 2.14

Colour: Clear - colourless.

Specific Gravity at 25 deg. C: 0.797

Shelf life from supply: One year

Acid value (mg KOH/g): 16.5 typ.

Halide content: None

Flash point: 13 deg. C

### HEALTH & SAFETY

DKL Clearflow 300 should be treated as a corrosive material. Take precautions to minimize risk of splashing or spillage. Use suitable eye and skin personal protection equipment. Read the application notes in this technical data sheet and refer to the safety data sheet for this product.

**DKL Metals Ltd., Bo'ness Road, Grangemouth, FK3 9XF, United Kingdom.**

Tel: +44 (0)1506847710

Email: sales@dklmetals.co.uk

Website: [www.dklmetals.co.uk](http://www.dklmetals.co.uk)