



SOLDER CONNECTION

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QUALITEK® Technical Bulletin

Delta 285-15 Rosin Mildly Activated Flux

DESCRIPTION

Delta 285-15 rosin mildly activated flux is formulated to meet the requirements of high speed soldering operations, with activities close to that of a fully activated rosin flux. 285-15 meets the requirements of type RMA per JSTD-004 (formerly MIL-F-14256). The unique activator and solvent system keep the activator from separating after a prolonged period of foaming or waving. The flux performance will remain stable throughout the soldering process.

FEATURES AND BENEFITS

- High solids (15%), rosin-containing flux
- Very bright solder joints
- High SIR value
- Non-corrosive
- Meets J-STD-004 (MIL-F-14256)

TECHNICAL DATA

	Specification	Test Method
Flux Classification	ROL1	IPC-J-STD-004B
Color and Appearance	Amber Liquid	
Silver Chromate Paper Test	Pass	IPC-TM-650 2.3.32
Copper Mirror	Pass	IPC-TM-650 2.6.15
Corrosion	Pass	IPC-TM-650 2.6.3.3
Flash point	53°F	
Resistivity	135,000 ohm-cm	IPC-TM-650 2.3.34
Solids Content	14.5 +/- 1.5	

APPLICATION

285-15 can be applied by wave, brush, dip, and foam methods. 285-15 exhibits superior foaming characteristics with a uniform stable foam head, and is excellent for tinning stranded wire, component leads, and attaching lead frames to hybrid circuit assemblies. Should the flux become viscous due to solvent loss simply add thinner to maintain the proper specific gravity and performance.

PACKAGING

1L
5L
10L

CLEANING

Post soldering residue from 285-15 maintains a high resistance value even at temperatures as high as 1600F. The residues may be removed with a CFC substitute or Qualitek Everkleen 1005 saponifier in an aqueous cleaning system.

STORAGE & SHELF LIFE

Liquid flux should be stored in dry, well-ventilated area, away from direct heat and flame. Shelf life is 2 years from date of manufacture

DISPOSAL

285-15 Flux contains hazardous ingredients, therefore, should be disposed of in accordance with local, regional and national requirements.

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