

## Technical Bulletin



Solder plus Support

### RMA202-25 Rosin Based Flux

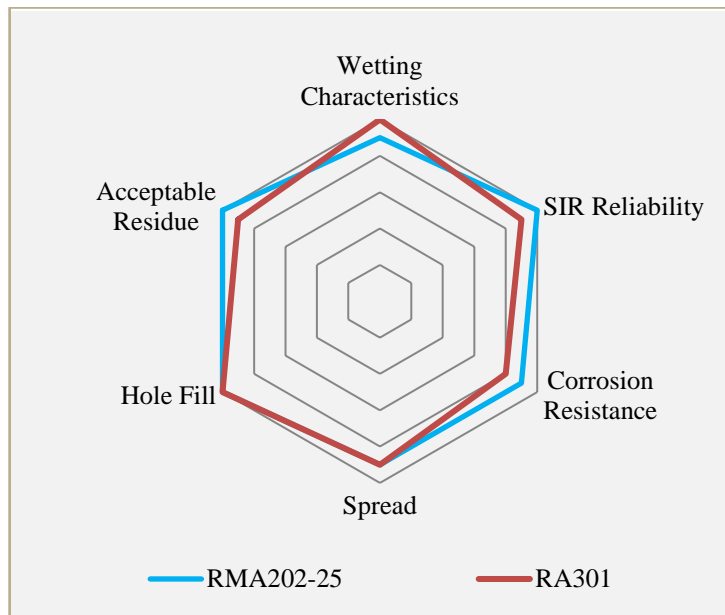
#### DESCRIPTION

RMA202-25 is an IPA based, medium solids, mildly activated liquid flux containing rosin and proprietary activators. RMA202-25 flux does not require removal, but if cleaning is required, residues can be removed with vapor degreasers, solvent cleaners and aqueous wash chemistry. RMA202-25 offers a wide process window, excellent wetting and robust soldering performance.

#### FEATURES AND BENEFITS

- Rosin Mildly Activated
- ROL0 per J-Std-004
- Non-Corrosive/Non-Conductive Residue
- IPC-A-610F Class 3 Compliant
- Military/High Reliability Applications

#### CHARACTERISTICS



#### STORAGE & SHELF LIFE

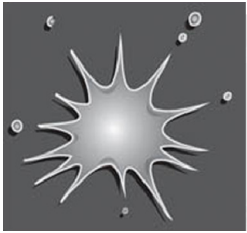
RMA202-25 has a sealed shelf life of one (1) year when stored at room temperature. Do not store near fire or flame. Keep away from sunlight as it may degrade product. RMA202-25 is shipped ready-to-use, no mixing necessary. Do not mix used and unused chemicals in the same container. Reseal any opened containers. Storage conditions range from 4-40°C (40-100°F).

Parameter	Time	Temperature
Sealed Shelf Life	1 year	Room Temperature

#### CLEANING

RMA202-25 can be cleaned using a saponifier and water or solvent cleaners. Contact AIM for additional information.

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# SOLDER CONNECTION

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## APPLICATION

RMA202-25 is formulated for application via spray, brush or dip. RMA202-25 is ready to use directly from its container, no thinning required. When spray fluxing, proper flux coverage and uniformity are imperative. A dry flux coating of 900-1500 micrograms per square inch is typical.

## PROCESS GUIDELINES

Using thermocouples attached to the top of the PCB, the topside assembly temperature should be between 85-110°C (185-230°F). It is important that the flux be dry prior to entering the wave regardless of temperature or spattering will occur. Smoking may occur and is considered normal if it is not excessive. Recommended contact time with the wave is dependent on wave configuration, pot temperature, alloy type and thermal mass of the assembly with 4-7 seconds being typical.

## HEALTH & SAFETY

Use with adequate ventilation and proper personal protective equipment. Refer to the accompanying Safety Data Sheet for any specific emergency information. Do not dispose of any hazardous materials in non-approved containers.

## TEST DATA SUMMARY

Name	Test Method	Results
IPC Flux Classification	J-STD-004	ROLO
Name	Test Method	Results
Copper Mirror	J-STD-004 3.4.1.1 IPC-TM-650 2.3.32	LOW
Corrosion	J-STD-004 3.4.1.2 IPC-TM-650 2.6.15	PASS
Quantitative Halides	J-STD-004 IPC-TM-650 2.3.35	≤ 0 .0
Qualitative Halides, Silver Chromate	J-STD-004 3.5.1.1 IPC-TM-650 2.3.33	PASS
Qualitative Halides, Fluoride Spot	J-STD-004 3.5.1.2 IPC-TM-650 2.3.35.1	PASS
Surface Insulation Resistance	J-STD-004 3.4.1.4 IPC-TM-650 2.6.3.3	PASS
Flux Solids, Nonvolatile Determination	J-STD-004 3.4.2.1 IPC-TM-650 2.3.34	25% Typical
Acid Value Determination	J-STD-004 3.4.2.2 IPC-TM-650 2.3.13	41.2 mg KOH/g Flux Typical
Flux Specific Gravity Determination	J-STD-004 3.4.2.3 ASTM D-1298	0.84 Typical
Visual	J-STD-004 3.4.2.5	Dark Yellow
Wetting	J-STD-005 3.9 IPC-TM-650 2.4.45	PASS

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