SRA SOLDERING® PRODUCTS

SKU: FLS99-20-1G

TECHNICAL DATASHEET

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

MADE IN USA

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-Cleancan 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.

SRA Soldering Products
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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% ± 1.0%
Free Acidity	None
Chloride Content	None
VOC Content	76.18%
Inorganic Cations	None
Recommended Soldering Range	200-260°C/390-500°F
Spread Factor	80 minimum
Flash Point (TCC.)	12°C/53°F
Boiling Point	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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