



# TECHNICAL DATA SHEET

## PAI 316P2 Rosin Flux

PAI 316P2 Rosin Flux is designed for both tin-lead & lead-free wave & dip soldering processes. It contains rosin, modified resin and organic activator to improve solder-ability.

### Applying Method:

Dip, Wave methods.

### Operating Parameter For Wave Soldering

Item	Typical Level
Amount of Flux Applied	Foam: 500~1200 $\mu\text{g}/\text{in}^2$ of solids/ $\text{in}^2$ Spray: 350~830 $\mu\text{g}/\text{in}^2$ Solids
Topside Preheat Temperature	85°C~130°C (Best: 100°C~125°C)
Bottom side Preheat Temperature	100°C~145°C (Best: 110°C~130°C)
Maximum Ramp Rate of Topside Temp.	2°C/second maximum
Conveyor Speed	0.7~1.5m/min. Best (0.7~1.1m/min)
Conveyor Angle	4° $\Delta$ ~8° $\Delta$ (6° $\Delta$ most common)
Dwell Time	2~6sec
Solder Pot Temp.	255°C~265°C (Sn/Ag3.0~4.0/Cu 0.5~0.9 Solder Bar) 265°C~280°C (Sn/Cu 0.7 Solder Bar) 250°C~260°C (Sn/Pb37 Solder Bar)

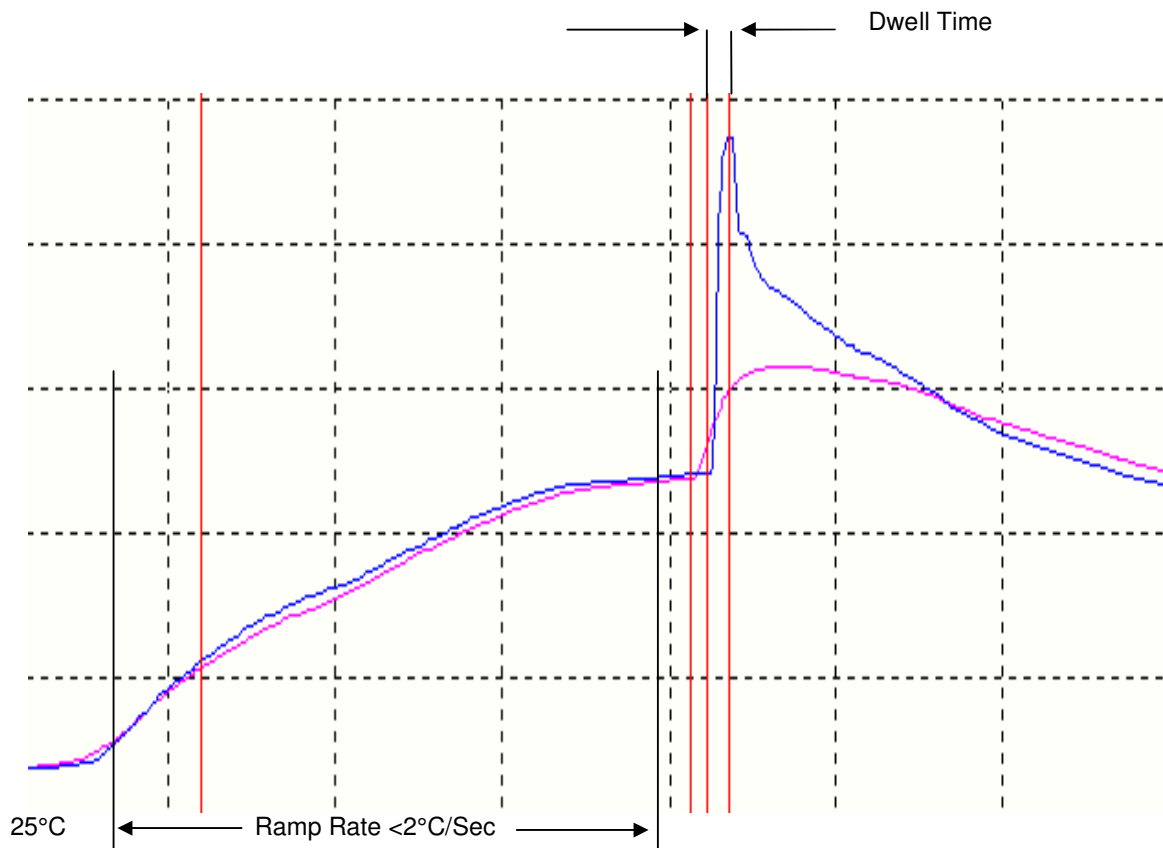


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These are general guidelines which have proven to yield excellent results; however, depending upon your equipment, components, and circuit boards, your optimal settings may be different.

### Technical Specification

Item	Result
Appearance	Light Yellow Semi Liquid
Specific Gravity , 20°C	0.825 ± 0.010
Acid Number, mg KOH/g	19.0 ± 4.5
Solids Content, %	14.3 ± 0.3



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### Physical Properties & Reliability Data

Item	Result	Test Method
Copper Mirror Test	PASS No Complete Removal of Copper	IPC TM650 2.3.32
Copper Corrosion Test	PASS, No Corrosion	IPC TM650 2.6.15
S.I.R Test, Unclean Requirements: Test Board: $\geq 1.0 \times 10^8 \Omega$ Control Board: $\geq 1.0 \times 10^9 \Omega$	PASS Comb-Up, Unclean $1.9 \times 10^9 \Omega$	IPC TM650 2.6.3.3 85°C, 85%RH, 168hrs, -50V IPC-B-24 Test Board, Line 0.4mm, Spacing 0.5mm
Electro migration Test Requirements: No Dendrites or Corrosion	PASS No Dendrites or Corrosion Comb- Up, Unclean $3.1 \times 10^9 \Omega$	Bellcore, GR-78-CORE Issue3 85°C, 85%RH, 500hrs, 10V IPC-B-25B Pattern, Line 12.5mil, Spacing 12.5mil

### Storage, Shelf Life Indication

Store in cool place and tighten the cap. Do not expose to sunlight or heat source. 12 Months from the Date of manufacturing.

### Safety Indication

The flux must not be used near open flames or near non-flameproof electrical equipment. Please refer to the Material Safety Data Sheet as the primary source of health and safety information.

For more details, please visit Our Website at [www.persangalloy.com](http://www.persangalloy.com) or write to us.



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