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MacDermid Alpha ELECTRONICS SOLUTIONS

TECHNICAL DATA SHEET

KESTER® 952-D6 FLUX-PEN®

Low-Solids, No-Clean, Flux-Pen for Leaded and Lead-free Alloys

DESCRIPTION

Kester 952-D6 Flux-Pen is a no-clean, non-corrosive, halide-free flux-pen that is specifically designed for lead-free rework of conventional and surface mount circuit board assemblies. Essentially no residue remains after soldering. 952-D6 Flux-Pen was developed with a modified surface tension to aid in soldering boards that have surface mount and high component densities. This comprehensive formulation possesses improved wetting characteristics and also exhibits superior corrosion inhibiting properties and provides a non-tacky residue. A major advantage of this flux is the reduced odor associated with the soldering process. 952-D6 Flux-Pen incorporates a small amount of rosin for higher reliability.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES & BENEFITS

- Residues almost colorless
- Improves soldering performance
- Reduced odor associated with soldering process
- Eliminates the need and expense of cleaning
- Non-corrosive tack-free residues
- Contains < 0.5% Rosin
- Classified as ORL0 per J-STD-004

ROHS COMPLIANCE

This product meets the requirements of the Restriction of Hazardous Substances (RoHS) Directive, 2011/65/EU for the stated banned substances.

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TECHNICAL DATA

Category	Results	Procedure/Remarks
Physical Properties		
Specific Gravity	0.812 ± 0.005	Anton Paar DMA @ 25 °C
Percent Solids (Theoretical)	3.1%	J-STD-004, IPC-TM-650, Method 2.3.34
Acid Number (Typical)	21.4 mg KOH/g of flux	J-STD-004, IPC-TM-650, Method 2.3.13
Reliability Properties		
Copper Mirror Corrosion	Low	J-STD-004, IPC-TM-650, Method 2.3.32
Corrosion Test	Low	J-STD-004, IPC-TM-650, Method 2.6.15
Silver Chromate	Pass	J-STD-004, IPC-TM-650, Method 2.3.33
Chloride and Bromides	None Detected	J-STD-004, IPC-TM-650, Method 2.3.35
Fluorides by Spot Test	Pass	J-STD-004, IPC-TM-650, Method 2.3.35.1
Surface Insulation Resistivity (SIR) IPC (Typical)	Pass	J-STD-004, IPC-TM-650, Method 2.6.3.3

	Blank	952-D6
Day 1	$2.7*10^{10}$ Ω	$9.4*10^{10}$ Ω
Day 4	$1.3*10^{10}$ Ω	$7.8*10^{10}$ Ω
Day 7	$9.8*10^{10}$ Ω	$6.3*10^{10}$ Ω

FLUX APPLICATION

952-D6 Flux-Pen is applied to circuit boards via Flux-Pen for rework of printed wire assemblies.

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PROCESSING GUIDELINES

Process Considerations

952-D6 Flux-Pen should only be applied to areas that will be fully heated by the soldering iron or other reflow tool. Care should be taken to avoid flooding the assembly. The surface tension has been adjusted to help the flux form a thin film on the board surface allowing rapid solvent evaporation.

Cleaning

952-D6 Flux-Pen flux residues are non-conductive, non-corrosive and do not require removal in most applications.

Storage, Handling and Shelf Life

952-D6 Flux-Pen is flammable. Store away from sources of ignition. Shelf life is 2 years from date of manufacture when handled properly and held at 10 to 25 °C (50 to 77 °F). The cap must be in place when not being used.

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area.



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SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available.**

CONTACT INFORMATION

www.macdermidalpha.com

North America 140 Centennial Avenue Piscataway, NJ 08854 1.800.367.5460	**Europe** Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400	**Asia** 8/F., Two Sky Parc 51 Hung To Road Kwun Tong, Kowloon, Hong Kong, SAR China 852.2500.5365

Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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