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TECHNICAL BULLETIN

ALPHA NF3000
WATER SOLUBLE FLUX

GENERAL DESCRIPTION

Alpha NF3000 is a water soluble liquid soldering flux principally designed for wave soldering of printed circuit boards. The organic activating system in Alpha NF3000 has a neutral pH at room temperature and becomes activated with elevated temperatures during the soldering process. This flux is developed to operate under a wide thermal window whilst emitting little smoke or odour.

AVAILABILITY

Specific Gravity @ 25°C:	0.845 ± 0.005
Kilograms per litre:	0.71
Solids Content wt/wt:	24%
Flash Point:	13.4°C
Flux Type:	Organic Acid
pH:	7.0 ± 0.5
% Chloride:	2.2 ± 0.3
Packaging:	20 litre containers

APPLICATION GUIDELINES

Alpha NF3000 is designed principally for application by the foam head method. Flux applicators and reservoirs should be plastic or titanium only.

Flux coated surfaces should be preheated to provide optimum wicking and solder joint formation. A typical assembly would be preheated to between 85°C and 95°C on the topside prior to entering the wave.

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The foam applicators should be supplied with compressed air which is filtered to be free of contaminant oil and water. The flux level should be maintained sufficiently above the aerator stone to produce adequate foam height. Air pressure should be adjusted to produce optimum height with foam consisting of small uniform bubbles.

During use, the specific gravity of the flux should be checked periodically with a hydrometer. Evaporated solvent should be replenished with the addition of flux thinner. For consistent soldering performance the flux should be replaced periodically. During this changeout the aerator stone should be thoroughly cleaned with flux thinner.

After soldering NF3000 residues must be removed. Removal can be accomplished by multi-zone conveyorised in-line spray systems, automated batch spray systems or multi-zone batch tank cleaning.

TECHNICAL SUPPORT

For enquiries, assistance and support, contact Technical Services, Alpha Metals UK Ltd.
Telephone: 0181 665 6666 Fax: 0181 665 4737

HEALTH & SAFETY

Observe standard precautions for handling and use. Use in well ventilated areas. Avoid prolonged or repeated contact with the skin by use of solvent resistant gloves. Avoid contact with eyes.

Remove skin splashes by immediate washing with soap and water.

Combustible, DO NOT SMOKE, keep away from open flames.

In order to carry out a full COSHH assessment, consult the product Material Safety Data Sheet (MSDS).

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