

135 Soldering Flux

Non-Activated Rosin Liquid Flux

Product Description

Kester 135 Soldering Flux is a non-activated rosin flux is a clear homogeneous solution of pure water-white rosin dissolved in a suitable solvent. The particular solvents used are liquids which exhibit the same non-corrosive and non-conductive properties as rosin itself. 135 is carefully processed to remove foreign particles found in natural rosin. Under the older MIL-F-14256, this flux was QPL approved as Type R. 135 is considerably more mobile because of its solids content and the low surface tension of the alcohol solvent. The high purity grade of alcohol solvent makes this flux very reliable for solderability testing.

Performance Characteristics:

- High quality for solderability testing
- Classified as ROL0 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.

Physical Properties

Specific Gravity: 0.880 ± 0.005
Antoine Paar DMA 35 @ 25 °C

Percent Solids (typical): 40
Tested to J-STD-004, IPC-TM-650, Method 2.3.34

VOC Content (g/liter): 522

Flash Point: 18 °C (64 °F)

Reliability Properties

Copper Mirror Corrosion: Low
Tested to J-STD-004, IPC-TM-650, Method 2.3.32

Corrosion Test: Low
Tested to J-STD-004, IPC-TM-650, Method 2.6.15

Silver Chromate: Pass

Tested to J-STD-004, IPC-TM-650, Method 2.3.33

Chloride and Bromides: None Detected

Tested to J-STD-004, IPC-TM-650, Method 2.3.35

Fluorides by Spot Test: Pass

Tested to J-STD-004, IPC-TM-650, Method 2.3.35.1

Flux Application

135 is typically applied by a dip process.

Process Considerations

Kester non-activated rosin fluxes are used for applications where active flux is not permitted and critical electronic assemblies are involved. They are highly recommended for solderability testing of leads, printed circuit boards and other electrical components because of their consistently high quality.

Flux Control

Specific gravity is normally the most reliable method to control the flux concentration of rosin-based fluxes. To check concentration, a hydrometer should be used. The complex nature of the solvent system for the flux makes it imperative that Kester 4662 Thinner be used to replace evaporative losses. When excessive debris from circuit boards, such as board fibers and from the airline build up in the flux tank, these particulates will redeposit on the circuit boards which may create a buildup of residues on probe test pins. It is, therefore, necessary to clean the tank and then replenish it with fresh flux when excessive debris accumulates in the flux tank.

Cleaning

135 flux residues are non-conductive, non-corrosive and do not require removal in most applications. If residue removal is required, contact Kester Technical Support.

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 or [link here](#).



Storage, Handling and Shelf Life

135 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). Periodically, flux separation may occur in this product. If this occurs, shake container before use.

Health and Safety

This product, during handling or use, may be hazardous to your health or the environment. Read the Safety Data Sheet and warning label before using this product. Safety Data Sheets are available at this [link](#).

Contact Information

To confirm this document is the most recent version, please contact Assembly@MacDermidAlpha.com

North America 109 Corporate Blvd. South Plainfield, NJ 07080, USA 1.800.253.7837	Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400	Asia Pacific 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100
--	---	--

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

DISCLAIMER: All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. No statement or recommendation shall constitute a representation unless set forth in an agreement signed by officers of seller and manufacturer. NO WARRANTY OF MERCHANTABILITY, WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY IS MADE. The following warranty is made in lieu of such warranties and all other warranties, express, implied, or statutory. Products are warranted to be free from defects in material and workmanship at the time sold. The sole obligation of seller and manufacturer under this warranty shall be to replace any noncompliant product at the time sold. Under no circumstances shall manufacturer or seller be liable for any loss, damage or expense, direct, indirect, incidental or consequential, arising out of the inability to use the product. Notwithstanding the foregoing, if products are supplied in response to a customer request that specifies operating parameters beyond those stated above, or if products are used under conditions exceeding said parameters, the customer by acceptance or use thereof assumes all risk of product failure and of all direct, indirect, incidental and consequential damages that may result from use of the products under such conditions, and agrees to exonerate, indemnify, defend and hold harmless MacDermid, Incorporated and its affiliates therefrom. No suggestion for product use nor anything contained herein shall be construed as a recommendation to use any product in a manner that infringes any patent or other intellectual property rights, and seller and manufacturer assume no responsibility or liability for any such infringement.

© 2019 MacDermid, Inc. and its group of companies. All rights reserved. "R" and "TM" are registered trademarks of MacDermid, Inc. and its group of companies in the United States and/or other countries.