

Kester® NF372-TB

Halogen-Free, High Reliability, Alcohol Based, No-Clean Wave Soldering Flux

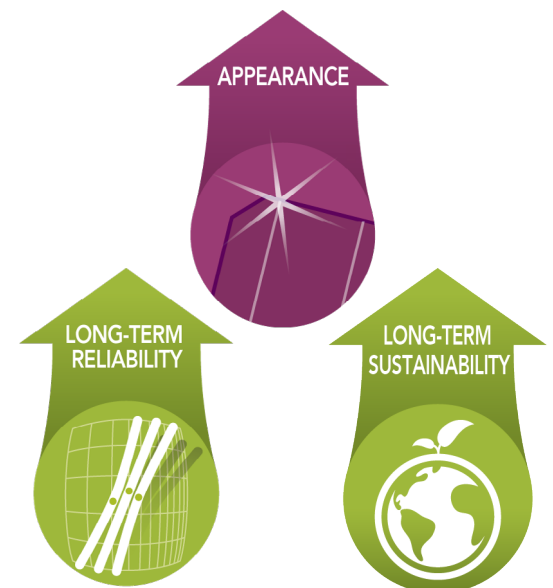
Wave Soldering Flux for Thick Board Applications in Lead-Free Process

Kester NF372-TB is a low solids alcohol based flux designed for both standard and thicker, high-density PCBs. A leading feature is its ability to withstand long dwell times and higher solder pot temperatures needed in thick board assemblies. NF372-TB delivers sustained activity within the flux for good barrel fill in challenging applications, such as reflowed copper OSP boards or with difficult to solder components. NF372-TB residues are minimal, clear and non-tacky for improved cosmetics, and can be used with both leaded and lead-free PCBs.



Key Features

- Unique activator/rosin package: produces highly reliable assemblies with excellent cosmetics and pin testability
- Thermally stable: excellent soldering in both single and dual wave processes, lead-free alloy capable
- Low surface tension: high through hole penetration rate and uniform SMT pad coverage
- Tack free residue: excellent post-soldering cosmetics with pin testable residue
- Halogen-free: environmentally friendly




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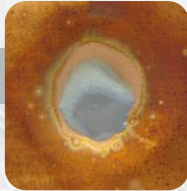
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COPPER CORROSION TEST (IPC-TM-650 2.6.15)

Initial



After Aging




NF372-TB


- Initial and after 10 days of exposure to 40 °C and 93% RH
- No evidence of greening or any change is observed
- These fluxes are classified “L” as per IPC J-STD-004B

COPPER MIRROR TEST (IPC-TM-650 2.3.32)

Control



NF372-TB



- No copper film was removed from the copper mirror
- “L” category corrosion per J-STD-004B

TECHNICAL DATA	KESTER NF372-TB	PROCESS CONTROL	KESTER NF372-TB
Solids Content, wt/wt	3.9%	Flux Application	Spray
Acid Number (mg KOH/gm)	16.6	Amount of Flux Applied	93-217 µg/cm ² of solids
Specific Gravity @ 25 °C	0.793	Top-Side Preheat Temperature	90-140 °C
IPC J-STD-004(B) Designation	ROLO	Bottom-Side Preheat Temperature	0 to +32 °C vs. Topside
Halogen-Free	Yes	Solder Pot	260-270 °C for SnCu or SAC alloy 245-260 °C for Sn63Pb37 alloy
SIR , PC J-STD-004(B)	Passed	Contact Time	3-7 s



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Kester is a product brand of MacDermid Alpha Electronics Solutions.

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