



Technical Bulletin

HO 351 Hot Oil Flux

I. Description:

HO351 is a specially formulated chemical used for fusing and leveling solder-plated printed circuit boards by immersion reflow technique. HO351 FUSISNG FLUX serves as a tarnish remover and prevents oxidation during reflow. It also does not splatter and has significantly reduced flammability hazards compared to alcohol-based fluxes.

Benefits

1. Excellent solder finish.
2. Non-Flammable.

Application

The clean solder-plated boards are immersed in a tank or tray of flux for up to 30 seconds. The excess flux is then allowed to dry for a few minutes in atmospheric conditions. After fusing, the excess flux can be easily removed with warm water.

II. Operating Parameters

Make-Up	100% HO351
Temperature	Room temperature
Immersion Time	Up to 30 seconds
Process	Batch
Agitation	Mechanical
Ventilation	Advised
Tanks	Polypropylene, CPVC
Racks and Baskets	PVC Coated
Heaters	Not necessary
Filtration	Not necessary

III. Physical Properties

Specific gravity	0.90 – 0.92
Appearance	Clear-Light Amber liquid
pH	0-2
Odor	Slight sweet smell
Flash Point	>100F

IV. Control Procedures

Consumption of flux is normally limited by drag out. Should control specific gravity within 0.06 units. Dragging water in will increase the specific gravity and drying of solvent in flux will increase the specific gravity.

V. Analysis

Specific gravity analysis if necessary (see section IV)

VI. Safety and Storage

HO351 is acidic and should be handled with care. Avoid open flames. Do not store in direct sunlight, high temperature or below freezing.

VII. Waste Treatment

Hot Oil Fluxes should not be bled into waste treatment systems because of the large percentage of organic solvents. Consult with local officials for waste disposal regulations

Please ask a Florida CirTech technical sales rep. for more information regarding waste treatment of this chemistry and our complete line of waste treatment line if additional help or information is desired.

VIII. Miscellaneous

Available in 5-gallon pails and 55-gallon drums. Consult MSDS sheet for additional information.

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