

PCB - Soldering

Soldering Equipment & Rework Stations

No. 135 ROSIN SOLDERING PASTE

DESCRIPTION

SRA No. 135 is a Petrolatum-based soldering paste that contains a Rosin and organic acid activator. The Rosin helps protect the solder joint against corrosive attack, and the paste form insures that the flux stays put until soldering. Unlike many paste fluxes, the No. 135 does not contain any Zinc Chloride or Ammonium Chloride, thus making it a safe and effective choice for electrical and electronic applications.

APPLICATIONS

SRA No. 135 is most effective in soldering copper in bare or tinned form. It is employed mainly in electrical and electronic applications. (No. 135 is available in 2-oz "hockey puck") This flux has a two (2) year shelf life.

PHYSICAL PROPERTIES

Form	Colophony Amber Paste
Specific Gravity	0.95 – 1.00
Flash Point	285°C/540°F
Boiling Point	337°C/640°F
Total VOC	3.00%
VOC Less Water and Exempt Solvents	3.00%
Spread Factor	80 Minimum
Soldering Temperature Range	93°C – 315°C/200°F– 600°F
Shelf Life	Two (2) years if stored closed, cool and dry
This Product is RoHS Compliant	

SPECIFICATIONS

SRA No. 135 meets Federal Specifications O-F 506C, Type I, Form A; MIL-S-6872A; IPC ANSI-J-STD-004 ROH1.

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DIRECTIONS

SRA No. 135 is generally applied using an acid brush. The flux is active between 93-315°C/200-600°F. Although the flux is self-cleaning, it is recommended that parts first be cleaned with a graded brushing to remove any impurities from the surface that may prevent solder flow. For most applications, the residues can be removed with a damp rag. However, the following cleaning steps must be followed in critical applications:

1. Degrease with an organic solvent.
2. Rinse in hot water containing 2% HCl solution.
3. Use as many hot de-ionized water rinses as necessary.

SAFETY PRECAUTIONS

SRA No. 135 contains Petrolatum, Rosin, and an organic flux activator. Inhalation of fumes can cause injury to the respiratory tract and skin. In case of external contact, wash with soap and water. For eyes, flush with water for 15 minutes and get immediate medical attention. If swallowed, give plenty of water or milk and call a physician. Keep out of reach of children. Do not store near heat, as Petrolatum melts at 135°F.