



FCT ASSEMBLY

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Technical Bulletin WW325 Rosin Solder Flux

DESCRIPTION:

WW325 Rosin Flux is an activated, non-corrosive, type RA rosin flux that displays excellent activity and superior mobility for wave soldering through-hole, mixed and surface mount assemblies. Use of WW325 will result in faster throughput, reduced solder build-up, fewer defects, and less residue than conventional high solids type RA fluxes.

APPLICATION:

WW325 Rosin Flux was formulated by the Florida Cirtech Research Laboratory to meet the needs for a highly reliable type RA flux that will leave less residue than the higher solids (>40%) formulas commonly used today. It is formulated for foam, spray, wave or dip applications. WW325 leaves a non-corrosive, hard, protective residue that does not need to be removed in most applications. It can also be used for tinning leads and other dip operations where a lower residue level is desired.

THINNING:

The consistency of WW325 Rosin Flux should be maintained by the addition of thinner to compensate for evaporation losses. It is recommended that the specific gravity @77F be maintained between 0.875 and 0.895 by addition of thinner. Only Flux Thinner FT-100 should be used for this purpose to ensure consistency of flux foaming and soldering characteristics.

PHYSICAL PROPERTIES

VALUES

Specific gravity at 77°F (25°C)	0.885 +/-0.005
Halide Content	0.25% +/- 0.025
Color	Amber
% Non-volatiles	25%
Flashpoint (closed cup)	53°F (12°C)

SAFETY AND HANDLING

Keep away from heat, sparks and open flames. Use in well-ventilated area and observe standard precautions for handling and use. Refer to the Material Safety Data Sheet for further information.

Available in 1-gallon jugs, 5-gallon pails and 55-gallon drums.
Refer to MSDS for additional information.