

PRODUCT DATA SHEET

**ROSIN
FLUX**

PAI - 316 P2

PUB # 316 P2
FEBRUARY, 2003
3 PAGES

PERSANG ALLOY INDUSTRIES P. LTD.
PLOT NO 188/7, G.I.D.C.
WAGHODIA - 391 760
DISTRICT : BARODA
TEL :02668-262556
TEL OFF : 91-265-2330606/2331328
FAX OFF : 91-265-2310647/2312933
E-mail: sales@persangalloy.com

PAI - 316 P2 ROSIN FLUX

GENERAL INFORMATION

PAI - 316 P2 rosin based flux is activated for excellent soldering with good electrical insulation property of commercial type printed circuit board. PAI - 316 P2 Flux can be used for both conventional through hole and S.M.D. soldering. Its flux residue is non-corrosive in presence of highly insulative rosin. The low solid content of 16% wt. in flux gives the advantage of leaving lesser amount of residue on the board after soldering.

APPLICATION INFORMATION

PAI - 316 P2 is applicable in any of the existing wave soldering machines used in the industry today. Application of the flux can be of the three methods: Dip, Wave and Foam. Preheat temperature of between 85° C and 95° C on the component side of the board is recommended.

For best foaming result, the level of flux in the fluxing tank should be maintained at about 1.3 to 2.0 cm above the foaming stone. Periodic monitoring of specific gravity with a hydrometer or automatic density censoring system and addition of the appropriate amount of flux reducer is necessary to ascertain consistent soldering results.

FLUX QUALITY

In time, debris and contaminates will accumulate in the flux. These contamination will affect the quality of flux, hence soldering. For consistent soldering performance, replace flux periodically. Before replacing the flux reservoir with fresh flux, the reservoir, fluxing attachment and aerator stone should be thoroughly cleaned with a suitable flux cleaner. During the cleaning process, it would be as good a time to clean the conveyor belt fingers and jigs of accumulated flux residue. After cleaning, rinse all relevant parts with a suitable flux reducer. Refill flux reservoir with fresh flux & allow a few minutes for foam to stabilize before resuming soldering operation.

FLUX REMOVAL

The flux residue that remained after soldering is safe and no cleaning is necessary. Should the need arises, the residue could be removed by a solvent or saponification system.

SAFETY & STORAGE

This flux is to be stored in proper areas away from direct sunlight and source of ignition. Storage temperature should be between 10°C and 30°C. Avoid eye and skin by using goggle and/or vinyl glove during handling. Sufficient localized exhaust should be provided in area where vapour is generated.

PHYSICAL PROPERTIES

Model Number	PAI - 316 P2
Type	RA
Class	JIS-Z-3197/QQ-S-571E
Physical State	Liquid
Colour	Amber
Surface Appearance	Shining
Solid Content	16 % wt.
Specific Gravity At 30°C	0.825
Flash Point	18°C
Surface Insulation Resistance	$1 \times 10^{11} \Omega$
Water Insulation Resistance	>45,000 Ω -cm
Flux Reducer	T.316
Standard Packing	10 liters carboy 20 liters carboy

Note: The above Specification is in general Specs. Alteration can be made as per requirement of an individual customer.

Ref. No : Flux PAI - 316 P2		Revised on : 24.02.2003
--------------------------------	--	----------------------------

MATERIAL SAFETY DATA SHEET

TOTAL NUMBER OF
PAGES - 3

PERSANG ALLOY INDUSTRIES P. LTD.
PLOT NO 188/7, G.I.D.C.
WAGHODIA - 391 760
DISTRICT : BARODA
TEL :02668-262556
TEL OFF : 91-265-2310647/2312933
FAX OFF : 91-265-2310647/2312933

MATERIAL SAFETY DATA SHEET

IDENTIFICATION

Products Number	PAI - 316 P2
Products Type	Rosin Activated Flux

PHYSICAL DATA

Boiling Point	< 70°C
Vapour Pressure (mm Hg)	NE
Vapour Density (air = 1)	< 1.5
Solubility	Alcohol, water and oil
Appearance	Colourless Liquid
Odour	Pleasant
Melting point	NE
Evaporation Rate (butyl acetate = 1)	< 2
Specific Gravity	0.825

REACTIVITY DATA

Incompatibility	NE
Stability	Stable
Decomposition or Byproducts	NE
Polymerisation	NE

HAZARDOUS INGREDIENTS

Material

None	
------	--

FIRE AND EXPLOSIVE DATA

Flash Points	18 °C
Flammable Limits	NE
Extinguishing Media	Dry Chemical
Special Fire Fighting Procedure	Use self contained breathing apparatus
Unusual Fire and Explosion Hazards	None

HEALTH HAZARD DATA

Routes of Entry	Inhalation, skin, ingestion
Health Hazards	Degreasing and irritation of skin, possibly anemic and poisonous if taken orally
Carcinogenicity	NE

NE = Not Established

Signs and Symptoms of Exposure

Skin	Inflammation
Eyes	Redness, burning, tearing, blurred vision
Ingestion	Nausea, vomiting
Inhalation	Headache, dizziness, difficult breathing

Emergency First Aid Procedures

Skin	Flush with water for 15 minutes. Seek medical attention, if irritation persists.
Eyes	Flush with water immediately. Seek medical attention, if irritation persists.
Ingestion	Drink large amount of water. Seek medical attention, if irritation persists. Never give liquids to an unconscious person.
Inhalation	Remove to fresh air. Support respiration if required. Seek medical attention.

PRECAUTIONS FOR SAFE HANDLING AND USE

Spill, Leak or Release	Flush into a chemical sewer or soak up with suitable absorbent.
Waste Disposal	Dispose of in accordance with local state and federal regulations.
Storage	In low temperature and low humidity area.
Handling	Wear Protection glasses and gloves

PROTECTION INFORMATION

Respiration Protection (type)	Organic vapour mask for fumes.
Ventilation	Local exhaust preferred.
Protective Gloves	Plastic or Rubber
Protective Cloth	As required to avoid contact.
Eye Protection	Goggle or Face Shield.
Hygienic Practices	Wash after handling or use.

NE = Not Established.

* We continuously upgrade our product. Conditions are subject to change without prior notification.