

Description

The 8351 *No Clean Flux, Halogen Free* is designed for lead free alloys and is also well suited for leaded alloys. Because it is low solids, this organic flux leaves virtually no residues so that the board appears cosmetically clean after exiting the wave soldering machine. It is specially designed to minimize bridge defects and solder defects.

Application

Use the MG 8351 flux for solder touch up, repair, or rework surface mount assemblies.

The 8351 is re-flowable in air or nitrogen. It can be used with profiles with peak maximum up to 270 °C and reflow times between 30 to 90 seconds.

Benefits

- **Halogen Free**
- **Low residues, leaving the board and joints shiny and bright**
- **Excellent wettability**
- **Usable for both lead free and leaded alloys**
- **Rosin/Resin Free**
- **RoHS Compliant**

Flux Paste Properties

<i>Physical Properties</i>	<i>Method</i>	<i>Value</i>
Flux Classification	J-STD-004	ORL0
Appearance		Colorless
Specific Gravity	J-STD-004B	0.815 ±0.006
Surface insulation resistance (SIR)		
SIR, JSTD-004	IPC-TM-650 2.6.3.3	2.1 × 10 ⁹ Ω
Copper Mirror	IPC-TM-650 2.3.32	Low
Acid Number (mg KOH/g)	titration	14–16
Solids		1.8–2.4%
Cleaning requirements	—	None

Storage and Shelf Life

Store at around room temperature and protect from direct heat or sunlight.

<i>Properties</i>	<i>Value</i>
Shelf Life after DOM	2 years
Storage Temperature	18 to 27 °C [65 to 80 °F]

Cleaning

The no-clean residue does not need to be removed for typical applications.

If removal is desired, a solvent system like the *MG 4140* or *MG 413B* can be used.

Health and Safety

Please see the 8351 **Material Safety Data Sheet** (SDS) for more details on transportation, storage, handling and other security guidelines.

Environmental Impact: The volatile organic content is 95% by EPA and WHMIS standards.



This product meets the European Directive 2011/65/EU Annex II (ROHS); recasting 2002/95/EC.

Health and Safety: Avoid breathing fumes. Wash hands thoroughly after use. Do not ingest.

HMIS® RATING

HEALTH:	2
FLAMMABILITY:	3
PHYSICAL HAZARD:	0
PERSONAL PROTECTION:	

Approximate HMIS and NFPA Risk Ratings Legend:

0 (Low or none); 1 (Slight); 2 (Moderate); 3 (Serious); 4 (Severe)

Application Instructions

This product is suitable for spray, foam, or wave fluxing application. Spray applications typically deliver 750–1500 µg/in². In order to keep the foam density and uniformity special attention should be paid to the air supply and tank. Compressed air supply should be free of water or oil. The flux tank should be kept full at all times. The following table lists ideal operational parameters.

Fluxing Operational Parameters

<i>Parameters</i>	<i>Typical</i>
Amount of flux for Foam, Wave	1000–2000 µg/in ² solids
Foam Stone Pore Size	20–50 µm
Flux Level Above Stone	25–40 mm [1–1.5 inch]
Chimney Opening	10–13 mm [3/8–1/2 inch]
Air Pressure ^{a)}	1–2 lb/in ²

a) Adjust the air pressure to achieve the optimum foam height.

After fluxing, use an air knife to remove excess foam for the printed circuit board assembly.

Wave Operational Parameters

Parameters	Typical
Top Side Preheat Temperature	85–110 °C [190–230 °F]
Bottom Side Preheat Temperature	35 °C [65 °F]
Conveyor Speed	1.2–2.8 m/min[4–5 ft/min]
Contact Time in the Solder (including Chip & Lambda)	2.5–4.5 s

Solder Pot Temperatures

Solder Type	Typical
Sn96.5/Ag3.5	260–276 °C [500–530 °F]
Sn95/Ag5	280–296 °C [536–565 °F]
Sn99.3/Cu0.7	265–276 °C [510–530 °F]
Sn96.5Ag3Cu0.5	271–276 °C [520–530 °F]
Sn95Sb5	280–296 °C [536–565 °F]

Process Control

Due to the low solids content, the density cannot be used to accurately provide a measure of the solids content. Instead, titration is the preferred method of monitoring. To measure the flux content being deposited, perform a titration. If needed, the flux number activity can be reduced by thinning with the MG 824—99.9% Isopropyl Alcohol.

TIP! If debris accumulates in reservoir, purge and clean the reservoir.

Packaging and Supporting Products

Product Availability

Cat. No.	Form	Net Volume		Net Weight	
8351-125ML	Liquid	125 mL	4.23 fl oz	101 g	3.25 oz
8351-1L	Liquid	1 L	1.1 qt	809 g	26.0 oz
8351-4L	Liquid	4 L	1.1 gal	3.2 kg	7.1 lb
8351-20L	Liquid	20 L	5.3 gal	16.2 kg	35.6 lb
8351-55G	Liquid	200 L	55 gal	161.8 kg	356.7 lb

Suitable Flux Cleaners

- *Heavy Duty Flux Remover*: Cat. No. 413B-1L, 413B-4L, 413B-20L, 413B-425G
- *Flux Remover for PC Boards*: Cat. No. 4140-P, 4140-400G, 4140-1L, 4140-4L, 4140-20L

Technical Support

Contact us regarding any questions, improvement suggestions, or problems with this product. Application notes, instructions, and FAQs are located at www.mgchemicals.com.

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Warranty

M.G. Chemicals Ltd. warrants this product for 12 months from the date of purchase by the end user. *M.G. Chemicals Ltd.* makes no claims as to shelf life of this product for the warranty. The liability of *M.G. Chemicals Ltd.* whether based on its warranty, contracts, or otherwise shall in no case include incidental or consequential damage.

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