

Product Data Sheet

Wave Solder Flux 3541 No-Clean

Features

- Eliminates the need for cleaning
- Reduces solder ball formation
- Excellent solderability on standard board finishes and alternative coating

Introduction

3541 No-Clean is a low-solids flux specially formulated to be used for wave soldering where the solder cleaning process has been eliminated. This flux contains a small amount of resin which enhances the wetting properties.

3541 No-Clean is activated by a multi-component, synergetic fluxing system, which improves solderability. Any post-soldering residues are considered non-corrosive.

3541 No-Clean leaves a “tack-free” surface and does not interfere with ATE testing.

Process Recommendations

3541 No-Clean should be applied by spray for best results. A thin uniform flux deposition of 500-1,000 micrograms per square inch (77.5-155 micrograms/sq. cm) of flux solids should be applied as a starting point. This flux can be used effectively in single or dual wave soldering systems. Assemblies with surface-mount, leaded components or mixed-technology can be soldered successfully.

3541 No-Clean can be used successfully with all solderability preservative coatings and organic solderability protective coatings.

Physical Properties

Test	Result	
	3541	16-3000
Color:	Straw	Clear
Specific Gravity: @25°C (77°F)	0.800	0.783
@15.5°C (60°F)	0.806	0.790
Acid Value	25.0	None
Solids Content	4.31	0
Flash Point (°F TCC)	54	54
J-STD-004 Flux Type	ORLO	N/A

All information is for reference only. Not to be used as incoming product specifications.

Packaging

- 5 gallon containers
- 55 gallon drums

Safety

Flammable liquids should always be stored in a dry, well-ventilated environment away from open flames, sparks or direct heat.

Technical Support

Indium Corporation’s internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Material Science as it applies to the electronics and semiconductor sectors, Technical Support Engineers provide expert advice in solder properties, alloy compatibility and selection of solder preforms, wire, ribbon and paste. Indium Corporation’s Technical Support engineers provide Rapid Response to all technical inquiries.

Material Safety Data Sheet

The MSDS for this product can be found online at <http://www.indium.com/techlibrary/msds.php>

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Bellcore Surface Insulation Resistance Test

Test Pattern	Boards	Initial Reading*	Final Reading*
Standard Bellcore	Control	2.68×10^{13}	1.88×10^{13}
	Pattern up	3.18×10^{12}	3.34×10^{12}
	Pattern down	3.27×10^{13}	3.48×10^{13}

All readings expressed in ohms

IPC Surface Insulation Resistance Test

Test Pattern	Boards	24 Hours*	96 Hours*	168 Hours*
IPC B25A	Control	1.74×10^{10}	5.60×10^9	3.76×10^9
	Pattern up	1.18×10^{10}	7.10×10^9	5.55×10^9
	Pattern down	8.50×10^9	3.49×10^9	3.21×10^9

All readings expressed in ohms

Bellcore Electromigration Insulation Resistance Test

Test Pattern	Boards	Initial Reading*	Final Reading*
IPC-B-25A	Control	6.51×10^{11}	3.01×10^{11}
	Pattern up	1.18×10^{10}	8.58×10^9
	Pattern down	1.14×10^{10}	7.39×10^9

All readings expressed in ohms

This product data sheet is provided for general information only. It is not intended, described which are sold subject exclusively to written warranties and limitations and shall not be construed, to warrant or guarantee the performance of the products thereon included in product packaging and invoices.

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