Product Data Sheet

BALVER ZINN®

396-DRX-M+

Rev: 14.1

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Language English
SDS 950411

BALVERZINN.COM

Summary

396-DRX-M+ is an ORL0 classified, water-based flux for wave soldering. It is based on organic acids and leaves hardly any visible residue. The 396-DRX-M+ prevents bridging.

Flux code	396-DRX-M+
PROCESS	
No-Clean process	9
Post-solder cleaning	8

INDUSTRY APPLICATION	
Standard electronics	8
Industrial electronics	9
Hi-Rel electronics (automotive)	4

PROCESS CAPABILITY	
Foam fluxing	4
Spray fluxing	9
Short preheat	6
Short contact time	9
Pb-free process Air	9
Pb-free process N2 wave	9
Pb-free process N2 tunnel	8
Skipped joints	9
Solderballing	8
Bridging	9
Promotes wicking	9
PTH filling	9
Cosmetic cleanliness	8
Cosmetic cleanliness N2	9
Shiny joint appearance	8
Pin testability	9
Conformal coating (see AN)	TBD

Legend	
Especially made for this purpose	9 - 10
Generally qualified for this purpose	7 - 8
Generally usable, but not the best choice	5 - 6
Generally not usable for this purpose	3 - 4
Wrong choice	1 - 2

CLASSIFICATION	
DIN EN ISO 9454-1: 2016	2131
IPC-J-STD-004-A: 2004	ORL0

PROPERTIES		
Density	@20°C [kg/dm³]	1.008
Solid content	[% w/w]	3.4
Acid number	[mg KOH/g]	27.7
Water content	[% w/w]	96
VOC content	[% w/w]	Remainder
Filmformer(s)		Organic
Color		Colorless
Odor		None
Flashpoint COC	[°C]	None
Thinners		Di-water

TEST REPORTS			
Certificate of Compliance			Website
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		Pass
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	Pass
Halide	IPC-TM-650 2.3.35.1	[Fluoride by Spot]	Pass
Copper Corrosion	IPC-TM-650 2.6.15		Pass
SIR	IPC-TM-650 2.6.3.3		Pass
ECM	IPC-TM-650 2.6.14.1		N/A

PACKAGING AND STORAGE		
Packaging can	(HDPE) [liter]	10
Packaging Drum	(HDPE) [liter]	200
Shelf-life in months	20-25 °C	24

Check material compatibility with every process change!
Industrial chemical product.
Read SDS before use.