



# SUPERIOR No. 334



## NO-CLEAN SOLDERING FLUX

- ◆ Formulated for wire tinning, component tinning, and wave soldering/spray flux applications.
- ◆ Excellent for tinning of insulated and braided wire and solder coating of printed circuit boards.
- ◆ Contains no rosins or resins.
- ◆ Meets all of the requirements of Bellcore TR-NWT-000078, Issue 3, December 1991.
- ◆ IPC, ANSI J-STD-004, Type ORL0

### DESCRIPTION

**Superior No. 334** No-Clean flux is specially formulated for automated and manual wire tinning applications, and for spray flux application in wave soldering. **Superior No. 334** is an alcohol-based No-Clean flux that has excellent activity levels and affords a wide process window for a No-Clean flux. The post-solder residue exceeds the minimum Bellcore and IPC requirements for cleanliness and provides long-term reliability for critical connections and components.

### APPLICATION

**Superior No. 334** flux is formulated for all applications as supplied, and may be applied to parts in waterfall, dipping, or spraying processes. With extended use, the flux solids level increases causing the acid number to increase. Flux activity levels should be monitored and maintained using a titration kit. Add **Superior No. 95T** thinner to maintain proper acid number.

Flux solids are designed to be washed off by the solder bath. Hot de-ionized water (60°C/140°F) will remove any remaining residues where cleaning is necessary.

**Superior No. 334** is an excellent flux for automated or manual wire tinning processes. For optimum soldering results, use the following guidelines:

- ① Make certain that wire surfaces are free of any oil, grease, or other impurities.
- ② Dip wire leads in flux
- ③ If process allows, preheat the wires prior to immersion in solder.
- ④ Dip wire leads in solder.

### SAFETY PRECAUTIONS

**Superior No. 334** is a flammable product and should be handled with care and the normal precautions taken when working with chemical products.

When soldering with **Superior No. 334**, adequate exhaust ventilation should be provided. Avoid contact with eyes, skin, and mucous membranes. Always wear NIOSH approved safety equipment when working with chemicals. Store in plastic containers away from heat.

Store flux in an area with controlled temperature between 18°C/64°F – 25°C/77°F. Exposure to light will discolor flux and turn it dark.

Refer to Material Safety Data Sheet (MSDS) for additional safety information.

*Superior manufactures quality fluxes. Our business is solving problems.*



