



SUPERIOR No. 325



ALCOHOL-BASED, NO-CLEAN FLUX

- Eliminates the need for cleaning soldered boards.
- Increased activity level.
- Can be used with lead free solder.
- Excellent for wire tinning in automated and manual wire tinning systems.
- A good flux for hand soldering PCB assemblies in touch-up or build-out processes.
- Low solids content.

DESCRIPTION

Superior No. 325 flux is formulated for spray fluxing application in wave soldering. It can also be used for wire tinning applications. **Superior No. 325** is an alcohol-based No-Clean flux that contains non-halide activators. The absence of halides and the very low solids content of the flux leaves parts with only negligible traces of low reactivity residues. The flux contains virtually no water and will not spatter on contact with molten solder. This flux contains no rosin or resins, and successfully replaces rosin fluxes.

APPLICATION

I. WAVE SOLDERING

Superior No. 325 may be applied by foam, spray, or wave application. The topside board preheat temperature recommendation is 93-115°C/200-240°F.

For optimum soldering results, use the following guidelines:

- ❶ Make certain that the PCB surfaces are free of any oil, grease, or other impurities.
- ❷ Maintain a consistent foam head by narrowing the flux chimney, or using dual flux stones.
- ❸ Add fresh flux to maintain proper flux level in flux tank.
- ❹ Replace the flux daily unless a sealed, self-contained system is used; such as in a spray fluxing system.
- ❺ Regularly clean the fluxing equipment. Never leave foaming stone in flux when pressure is not applied.
- ❻ Clean fluxing stone in **Superior No. 95T** flux thinner.
- ❼ When foam fluxing, flux properties can be maintained by monitoring the specific gravity. However, control by checking the acid value is recommended as the most accurate measure. Titration kits are available from Superior Flux.
- ❽ Add **Superior No. 95T** flux thinner when needed.

II. WIRE TINNING

Superior No. 325 is an excellent flux for automated or manual wire tinning processes.

For optimum soldering results, use the following guidelines:

- ❶ Make certain that wire surfaces are free of any oil, grease, or other impurities.
- ❷ Dip wire leads in flux
- ❸ If process allows, preheat the wires prior to immersion in solder.
- ❹ Dip wire leads in solder.

Superior manufactures quality fluxes. Our business is solving problems.



PHYSICAL PROPERTIES

Form	Clear Liquid
Specific Gravity	0.805 ± 0.01 @ 20-25°C/68-77°F
Density	6.93 lbs/gallon @ 20-25°C/68-77°F
Solids Content	<3.5%
Chloride/Halide Content	None
Flash Point	15.5°C (TCC)
Soldering Range	390-500°F/200-260°C
Water Content	Less than 1%
Boiling Point	78.3°C
Freezing Effects	None
Acid Number	25-30
Discoloration	None

THIS PRODUCT IS RoHS COMPLIANT.

SAFETY PRECAUTIONS

Superior No. 325 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. 325**, 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 of 18°C/64°F – 25°C/77°F.

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

Superior No. 325 has a two (2) year shelf life.

The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Superior Flux & Mfg. Co.'s control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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