



SUPERIOR NO. 99HF



HALIDE-FREE ROSIN FLUX, TYPE RMA

- A mildly activated, halide-free rosin flux for general-purpose soldering of PCB's, wire, cable, and semiconductors, and hand soldering applications.
- Excellent for a variety of metals including copper, gold, nickel alloys, silver, and tin.
- Can be used for automated and manual soldering operations.

DESCRIPTION

Superior No. 99HF RMA Flux consists of a homogeneous solution of water-white rosin in a multi-component solvent system with a halide-free organic activator. The flux is used in electronic applications requiring excellent soldering activity and yielding residues with high water-extract resistivities. **Superior No. 99HF RMA Flux** becomes active above 175°C/340°F, attaining peak activity in the temperature range 200-300°C/390-572°F, where it promotes excellent solderability. It can also be used for high-temperature soldering applications, such as mag-wire tinning at temperatures in the 400-430°C/750-800°F range.

APPLICATIONS

Superior No. 99HF RMA Flux is an excellent choice for soldering printed circuit boards (PCBs), wire leads, cables, and component tinning. **Superior No. 99HF RMA Flux** can be used to solder many different metals and alloys including copper, gold, alloy 42, alloy 51, nickel alloys, and other metals commonly used in electronics applications.

PHYSICAL PROPERTIES

Form	Light Brown Liquid
Specific Gravity	0.90 ± 0.02 @ 20-25°C/68-77°F
Density	7.5 lbs./gallon @ 20-25°C/68-77°F
Solids Content	45.5 ± 2.0%
Free Acidity	None
Halide Content	None
Inorganic Cations	None
Soldering Range	200-300°C/390-572°F
Spread Factor	90 minimum
Flash Point (TCC.)	12°C/53°F
Boiling Point	82.3°C/180.1°F
Freezing Effects	None
Residue Characteristics	Non-Corrosive, Non-Conductive
This Product is RoHS Compliant	

Superior manufactures quality fluxes. Our business is solving problems.



**Superior Flux
& Mfg. Co.**

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SPECIFICATIONS

Superior No. 99HF RMA Flux meets all the requirements of Mil-F-14256, Type RMA.

DIRECTIONS

Superior No. 99HF RMA Flux can be applied by foaming, brushing, dipping, rolling and spraying. Soldering need not be carried out immediately after fluxing. The residues are completely non-corrosive, non-conductive and fungus-proof, and need not be removed. However, cleaning is easily accomplished by vapor-degreasing methods, using appropriate solvent systems.

The specific gravity of the flux increases with prolonged use as the solvents evaporate. It can be restored to the recommended value by adding **Superior No. 96T Flux Thinner** to the flux and mixing thoroughly.

SAFETY PRECAUTIONS

Superior No. 99HF RMA Flux is flammable and should be stored in plastic containers away from heat, sparks or an open flame. Use adequate ventilation to remove flux fumes, along with fumes from the soldering station. Avoid contact with skin and eyes and avoid breathing vapors. Flux has a two (2) year shelf life.

A Material Safety Data Sheet (MSDS) is available on request.

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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