

ALPHA[®] S-64 FLUX

Liquid Activated Rosin Flux

DESCRIPTION

ALPHA S-64 is a liquid activitated rosin flux, which can be used for dip-tinning of component leads, as well as for conventional wave and hand soldering. It is a clear solution of a modified rosin with a fast acting activator package which provides a rapid cleaning action and excellent wetting. As the activator is fully soluable in the solid rosin, the post solder residues are in the form of a solid, homogeneous coating which is free from corrosive or hygroscopic inclusions.

ALPHA S-64 is particularly suitable for high temperature dip-tinning where temperatures can be as high as 400 °C.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

APPLICATION GUIDELINES

ALPHA S-64 may be applied by manual dipping, brushing or alternatively, by the foam method in an automated wave soldering system.

The materials specific gravity should be monitored to ensure consistent performance, particularly when foaming is used as the application method. During use solvents in the material will not be lost due to their volatile nature, thus icnreasing the specific gravity. This can be adjusted with the addition of ALPHA 425 Thinner.

TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Clear Amber Liquid	Flash Point	11.7 °C
Specific Gravity @ 20 °C	0.905 ± 0.002	Recommended Thinner	ALPHA 425
Solids Content, %, wt/wt	45.5 ± 2.0	Shelf Life (from Date of Mfg.)	540 days
IPC J-STD-004 Designation	ROL1		

PROCESSING GUIDELINES

Cleaning

The residues from ALPHA S-64 do not need to be cleaned after soldering, as they are non-corrosive and non-hygroscopic. However, if removal of the residues is deemed necessary, then they can easily be removed in ALPHA Autoclean 40 fluid.

SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at AlphaAssembly.com**

STORAGE

The shelf life information is valid for Alpha products in factory-sealed containers kept at recommended storage temperatures of 10°C - 43°C. However, if the flux is stored at lower temperatures from (-15 to 5 °C), it should be allowed to reach a temperature of 25 to 30 °C for 24 hours prior to use.

CONTACT INFORMATION

**To confirm this document is the most recent version, please contact
Assembly@MacDermidAlpha.com**

www.macdermidalpha.com

North America 300 Atrium Drive Somerset, NJ 08873, USA 800.367.5460	Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 01483.758400	Asia 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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