

ALPHA[®] RL5116 FLUX

No Clean Flux

DESCRIPTION

ALPHA RL5116 is an active, medium solids, no-clean flux.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

APPLICATION GUIDELINES

General Guidelines for Machine Settings

Flux Solids Control - If foam, wave, or rotary drum spray fluxing, the flux solids will need to be controlled via thinner addition to replace evaporative losses of the flux solvent. As with any flux with less than 5% solids content, specific gravity is not an effective measurement for assessing and controlling the solids content. Monitoring and controlling the acid number is recommended for maintaining the solids content. The acid number should be controlled to between 22 and 24. ALPHA's Flux Solids Control Kit #3, a digital titrator, is suggested. Request Alpha's Reference Bulletin for details on the kit and titration procedure.

When operating the foam fluxer continuously, the acid number should be checked every two to four hours. Over time, debris and contaminants will accumulate in recirculating type flux applicators. For consistent soldering performance, dispose of spent flux every 40 hours of operation. After emptying the flux, the reservoir and foam stone should be thoroughly cleaned with flux thinner.

TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Amber to colorless liquid	IPC J-STD-004 Designation	ROL0
Solids Content, wt/wt	17.1%	Recommended Thinner	425 Thinner
Acid Number (mg KOH/g)	34.8 to 38.8	Shelf Life	540 Days
Specific Gravity @ 25 °C (77 °F)	0.820 ± 0.005	Flash Point (T.C.C.)	53 °F (12 °C)

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



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 MacdermidAlpha.com/assembly-solutions/knowledge-base.**

CONTACT INFORMATION

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

www.macdermidalpha.com

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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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