

ALPHA[®] SM390 2,5

Special Foam and Spray Flux

(Type 2.2.3 Flux in Accordance with EN ISO 9454-2:2000)

DESCRIPTION

ALPHA SM390 2,5 is a highly effective no-clean flux with low solids content. **ALPHA SM390 2,5** can be applied by conventional foam or spray techniques. After soldering, the printed circuit boards are completely dry while leaving a minimal amount of hardly visible non-corrosive residues. **ALPHA SM390 2,5** Flux passes copper mirror and silver chromate paper tests and meets the requirements of Bellcore TR-TSY-00078.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

FEATURES & BENEFITS

- High surface resistance values due to low solids content, MIL cleanliness requirement is achieved
- Produces visually residue-free glossy surface
- Excellent soldering results with SMT devices
- No post reflow cleaning required
- Soldered assemblies can undergo “in-circuit test” immediately after soldering without an additional washing operation

APPLICATION GUIDELINES

ALPHA SM390 2,5 has been specially developed as a foam and spray flux for use with integrated circuits and electronic components. It can be used with all types of surface mounting techniques.

In order to achieve a good smooth head of foam (with fine bubble size), it is necessary to use a flux stone with as fine porosity as possible. The use of hot board carriers should be avoided as this may lead to the foam head collapsing or to a higher evaporation rate of the flux components. The outlet opening should be approximately 3 cm above the flux level to produce a good foam.

The recommended preheat temperature at the top of the board should be 90 to 120 °C (194 to 248 °F). This corresponds to a temperature of approximately 100 to 130 °C (212 to 266 °F) on the bottom side.

TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Clear, Colorless to Light Yellow Liquid	Flash Point (T.C.C.)	12 °C (53.6 °F)
Solids Content, wt/wt %	2.5	Shelf Life (from Date of Mfg.)	540 days
Density @ 20 °C (68 °F), g/ml	0.792 ± 0.003	IPC J-STD-004 Designation	ORL0
Acid Number, mg KOH/g	17.0 ± 1.0	Packaging Size	25 liters

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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