

# ALPHA<sup>®</sup> 3355-VF

## Water Soluble Organo-Flux

### DESCRIPTION

**ALPHA 3355-VF** flux is a VOC-free modification of ALPHA 3355-11 water soluble organic acid flux, used in the soldering of printed circuits and electronic hardware. This formulation produces exceptional solder wetting to a wide variety of metallic surfaces and is unsurpassed in water solubility for thorough removal of post soldering residues.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

### APPLICATION GUIDELINES

ALPHA 3355-VF flux can be wave, spray or dip applied. Flux applicators and reservoir should be plastic or titanium only. Flux coated surfaces should be preheated to provide optimum wicking and solder joint formation. The degree of preheat is dependent on many variables, such as conveyor speed, type of components and substrates. Entering the solder wave with a topside temperature in the 210 °F range is typical.

**Control:** When using recirculation type flux applicators, the specific gravity of the flux should be checked periodically with a hydrometer and restored to specified value by the addition of DI water.

In time, debris and contaminants will accumulate in the flux. For consistent soldering performance, dispose of spent flux in accordance with Federal, State and local laws, rules and regulations periodically. After emptying used flux, the reservoir should be thoroughly cleaned with DI water. Refill the reservoir with fresh flux and allow a few minutes to stabilize before resuming solder operation.

**Residue Removal:** After soldering, ALPHA 3355-VF residues must be removed. Removal can be accomplished in multi-zone conveyORIZED in-line spray systems, automated batch spray systems (dishwashers) or multi-stage batch tank cleaning. Multiple zone in-line systems equipped with quality tap or conditioned water, an effective air knife and drying capacity can produce MIL-P-28809 ionic cleanliness levels.

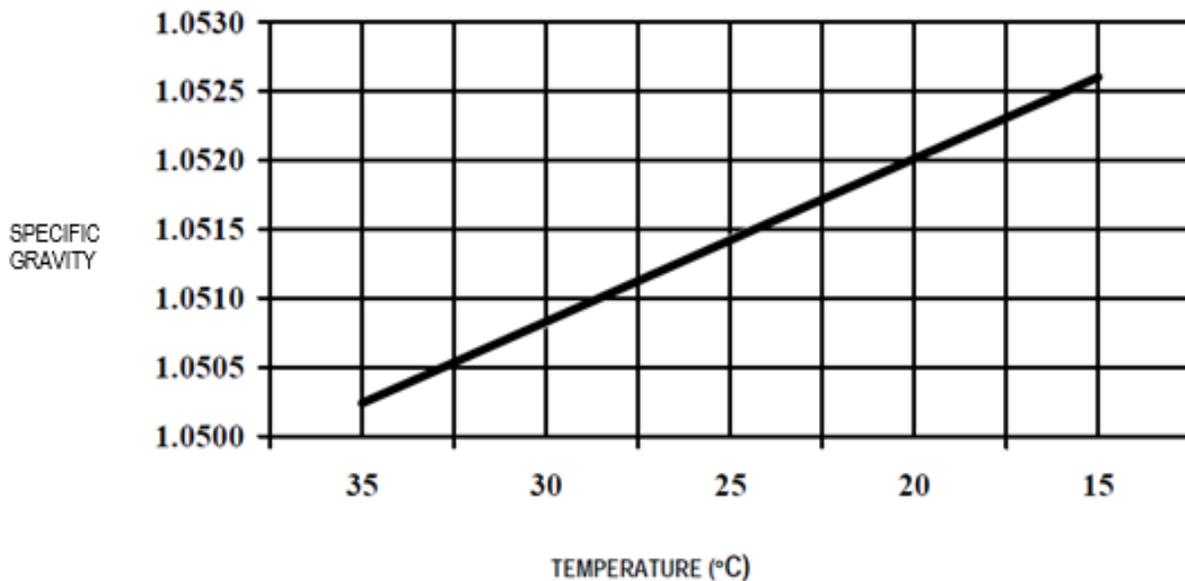
ALPHA 520 saponifier is recommended for improving cleanliness levels in batch and in-line systems with limited cleaning capabilities. Incorporating a saponifier or neutralizer will assist the removal of flux residues, aqueous spot mask and other contaminants.

To avoid the risk of corrosion, residues should be thoroughly cleaned, preferably, immediately or not beyond four hours after processing.

**TECHNICAL DATA**

Item	Typical Values	Item	Typical Values
Appearance	Clear reddish liquid	Flash Point	None
Solids Content, wt/wt	22.4%	Recommended Thinner	DI H <sub>2</sub> O
Specific Gravity @ 25 °C (77 °F)	1.052 ± 0.005	Shelf Life (from Date of Mfg.)	720 days
% Halide	3.0	IPC J-STD-004 Designation	ORH1
pH (5% solution)	1.2	Packaging Size	1, 5, 55 gallons
Pounds per Gallon	8.74		

**Specific Gravity VS Temperature (°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](http://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](http://www.macdermidalpha.com)

<p><b>North America</b> 109 Corporate Blvd. South Plainfield, NJ 07080, USA 1.800.367.5460</p>	<p><b>Europe</b> Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400</p>	<p><b>Asia</b> 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100</p>
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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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