



## **MRT-1078.2**

### **Nordson SELECT Recommended Selective Soldering Fluxes**

There are numerous types of flux available for board manufacturing, and nearly all of them promote the general ability to solder with a wider process window and with less defects. Seems an optimistic statement when the application the flux is being used with is unknown.

Selective soldering encompasses a style of process that does not conform to traditional wave soldering methods. The solder is hotter, thermal energy is focused, and the contact time is shorter. These are a few of the critical parameters that most flux performance is dependent on, and processing outside the designed ranges can exhibit poor results.

Nordson SELECT has investigated the real world working of virtually all available flux chemistries for our selective machines. We have qualified a few that perform consistently, when used with lead or lead free soldering and feel these truly do offer a wider process window for defect free soldering. The key features that are recognized here are thermal stability, maintaining lower surface tension and rapid preparation of the pins/pads to be soldered. Below are the fluxes Nordson SELECT has approved that work well and strongly recommend. Products used that have not been qualified by Nordson SELECT may exhibit lesser quality and difficulty with repeatability.

### **NO Clean Fluxes**

Used with Lead Alloy or Lead Free Alloy Processes

1. Kester Select 10
2. ALPHA EF-2210
3. AIM FX-16

### **Water Soluble Flux**

Used with Lead Alloy or Lead Free Alloy Processes

1. KESTER 2331-ZX (Preferred)

Do not use any flux less than 2.5 pH level. This will cause premature failure of the flux applicators!

### **Nozzle Tinning Flux**

Used with Lead Alloy or Lead Free Alloy Processes

1. SUPERIOR #75 (Preferred)

Superior #75 is the best qualified, and the recommended flux for nozzle tinning. This is a very aggressive water soluble type flux that is intended for use only with tinning nozzles. This flux should never be used on product!

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