



Product 6381

June 2006

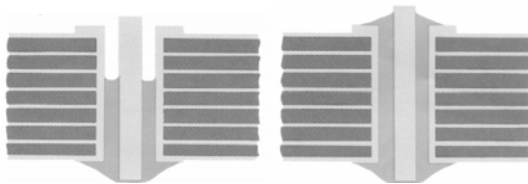
RMA SUSTAINED ACTIVITY LIQUID FLUX

Multiprint 6381 Liquid Flux is a RMA flux with a proprietary formulation that combines superior mobility and spread with faster initial wetting action. It is more effective and will maintain operating activity longer than conventional RMA type fluxes.

- Results in faster throughput, fewer defects and less touch-up
- Eliminates solder build-up
- Flux residues are easily removed where required
- Ideal for single and double sided PTH boards as well as multilayer and bottom-side SMD applications

APPLICATIONS

Multicore 6381 can be reliably and cost-effectively used where the solderability of an assembly needs an active flux formulation approaching an RA type but specifications mandate an RMA flux. As a result, it is ideal for use with multilayer, surface mount, densely populated and complex boards. Solder spread is up to 50% greater than conventional RMA fluxes assuring excellent penetration of plated through holes.



Limited through-hole penetration by solder of multilayer board achieved with conventional RMA flux.

Using Multicore 6381, solder penetrates to the top of the board.

CLEANING

Multicore 6381 Liquid Flux is more stable than conventional RMA fluxes. As a result, polymerisation of the rosin during wavesoldering is minimised, leaving a residue that is more soluble and thus more easily removed from process equipment.

The flux residue is non-corrosive and non-conductive under normal conditions of use and may not need to be removed.

If cleaning is required, MCF800 is recommended.

PERFORMANCE PROFILE

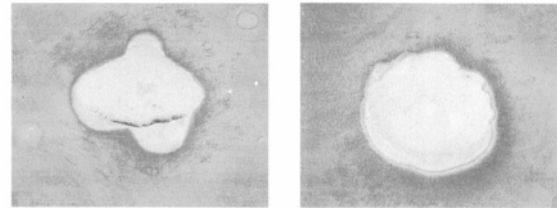


Fig. 1

Fig. 2

A 0.01ml drop of standard 35% w/w liquid flux was applied to a 0.7g pellet of 60/40 solder on a standard copper coupon (Fig. 1). The test was repeated using a drop of 6381 RMA flux (Fig.2). The 6381 RMA flux permits the solder to spread almost to the perimeter of the flux – up to 50% greater area compared to the conventional RMA flux.

TECHNICAL SPECIFICATION

Multicore 6381 RMA Liquid Flux is available with 15, 25 and 35% w/w solids content. Typical data are as follows:

	6381-35	6381-25	6381-15
Solids Content, (%)	35	25	15
Halide Content, (%)	0.015	0.011	0.006
Acid Value	54	38	24
Specific Gravity (25°C)	0.897	0.876	0.850
Flash Point	17°C (63°F)	17°C (63°F)	17°C (63°F)
Colour	Amber	Amber	Amber
Resistivity of Water Extract	>100,000	>100,000	>100,000
Copper Mirror	Pass	Pass	Pass
Spread Factor	94%	94%	94%
Silver Chromate	Pass	Pass	Pass
Classification	1.1.3		
EN 29454-1	ROL1		
JSTD 004			

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Americas
Henkel Corporation
15350 Barranca Parkway
Irvine, CA 92618 U.S.A.
949.789.2500

Europe
Henkel Loctite Adhesives Ltd
Technologies House, Wood Lane End
Hemel Hempstead
Hertfordshire HP2 4RQ, United Kingdom
+44 (0) 1442 278 000

Asia
Henkel Loctite (China) Co. Ltd
No. 90 Zhujiang Road
Yantai Development Zone
Shandong, China 264006
+86 535 6399820

