



QUALITEK®

737N Water Soluble Flux Neutral

DESCRIPTION

737N is a neutral, water removable liquid soldering flux designed for wave soldering of conventional and surface mount PCB assemblies. The organic activating system in 737N has a neutral pH at room temperature and becomes activated at soldering temperatures. 737N is formulated to be effective over a broad preheat range.

BENEFITS

- Excellent wetting on virtually all types of substrates
- Very bright shiny joints
- Neutral pH

APPLICATION METHODS

737N is designed for automatic soldering applications where rosin fluxes are not sufficiently active and inorganic acid fluxes are too corrosive to be used. This flux has excellent foaming characteristics and may also be applied by wave, spray, dip, or brush methods. The flux applicator should be plastic or titanium only. The optimum topside preheat temperature is 170-200°F (77-94°C) on the topside of the circuit board. Adjust the specific gravity with Qualitek 700 thinner as needed to ensure consistent performance.

PHYSICAL & CHEMICAL CHARACTERISTICS

Color and Appearance	Clear Liquid
Solids Content, % (By Wt.)	16.0 – 18.0
Specific Gravity	0.846 +/- 0.006
Flash Point	53°F
pH (as is)	6.8 – 7.8
Flux Classification per J-STD-004	ORH1
% Halides	2.2 +/- 0.3
Shelf life (un-opened)	2 years

RESIDUE REMOVAL

As with all water-soluble fluxes, post cleaning is required. Residues can be easily removed with both hot and cold water, thus; no neutralizer is needed. De-ionized water should be used in the final rinse for cleanliness results beyond MIL-28809A.

PACKAGING & STORAGE

737N flux is available in 1, 5 and 55 gallon containers. It should be stored in cool, dry place away from ignition sources.

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Consult MSDS for health and safety information