kester®
CONNECTING INNOVATION™

985M
Low-Solids No-Clean Flux Pen®

Product Description

Kester 985M is a low solids, halide-free, no clean Flux Pen® that is specifically designed for rework of conventional and surface mount circuit board assemblies. 985M was developed for use with both traditional tin-lead and lead-free solder alloys. Kester 985M exhibits improved soldering performance to minimize solder bridges (shorts) during rework operations. This flux is suitable for automotive, computer, telecommunications and other applications where reliability considerations are critical. The surface insulation resistance on soldered boards is higher than that provided by typical organic water-soluble fluxes.

Performance Characteristics:

- Improves soldering performance
- Eliminates the need and expense of cleaning
- Non-corrosive tack-free residues
- Classified as ROL0 per J-STD-004
- Compliant to Bellcore GR-78

Physical Properties

Specific Gravity: 0.805 ± 0.005
Antoine Paar DMA 35 @ 25°C

Percent Solids (theoretical): 3.60

Acid Number (typical): 20.0 mg KOH/g of flux
Tested by potentiometric titration

Reliability Properties

Copper Mirror Corrosion: Low
Tested to J-STD-004, IPC-TM-650, Method 2.3.32

Corrosion Test: Low
Tested to J-STD-004, IPC-TM-650, Method 2.6.15

Silver Chromate: Pass
Tested to J-STD-004, IPC-TM-650, Method 2.3.33

Chloride and Bromides: None Detected
Tested to J-STD-004, IPC-TM-650, Method 2.3.35

Fluorides by Spot Test: Pass
Tested to J-STD-004, IPC-TM-650, Method 2.3.35.1

SIR, IPC (typical): Pass
Tested to J-STD-004, IPC-TM-650, Method 2.6.3.3

	Blank	951
Day 1	$1.3 \times 10^{10}\ \Omega$	$7.3 \times 10^{9}\ \Omega$
Day 4	$9.7 \times 10^{9}\ \Omega$	$1.1 \times 10^{10}\ \Omega$
Day 7	$8.2 \times 10^{9}\ \Omega$	$1.1 \times 10^{10}\ \Omega$

Application Notes

Flux Application:

Kester 985M is applied to circuit boards via Flux Pen® for rework of printed wire assemblies.

Process Considerations:

Kester 985M should only be applied to areas that will be fully heated by the soldering iron or other reflow tool. Care should be taken to avoid flooding the assembly. The surface tension has been adjusted to help the flux form a thin film on the board surface allowing rapid solvent evaporation.

Cleaning:

Kester 985M flux residues are non-conductive, non-corrosive and do not require removal in most applications.

Storage and Shelf Life:

Kester 951 is flammable. Store away from sources of ignition. Shelf life is 2 years from date of manufacture when handled properly and held at 10-25°C (50-77°F).

Health & Safety:

This product, during handling or use, may be hazardous to health or the environment. Read the Material Safety Data Sheet and warning label before using this product.

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