

**Date** 2021.08.18  
**Language** English  
**SDS** 950410



**Summary**

396-DRX-M+ is an ORL0 classified, water-based flux for wave soldering. It is based on organic acids and leaves hardly any visible residue. The 396-DRX-M+ prevents bridging.

Flux code	396-DRX-M+	
<b>PROCESS</b>		
No-Clean process	9	
Post-solder cleaning	8	

INDUSTRY APPLICATION		
Standard electronics	8	
Industrial electronics	9	
Hi-Rel electronics (automotive)	4	

PROCESS CAPABILITY		
Foam fluxing	4	
Spray fluxing	9	
Short preheat	6	
Short contact time	9	
Pb-free process Air	9	
Pb-free process N2 wave	9	
Pb-free process N2 tunnel	8	
Skipped joints	9	
Solderballing	8	
Bridging	9	
Promotes wicking	9	
PTH filling	9	
Cosmetic cleanliness	8	
Cosmetic cleanliness N2	9	
Shiny joint appearance	8	
Pin testability	9	
Conformal coating (see AN)	TBD	

Legend	
<i>Especially made for this purpose</i>	9 - 10
<i>Generally qualified for this purpose</i>	7 - 8
<i>Generally usable, but not the best choice</i>	5 - 6
<i>Generally not usable for this purpose</i>	3 - 4
<i>Wrong choice</i>	1 - 2

**Check material compatibility with every process change!**  
 Industrial chemical product.  
 Read SDS before use.

**Disclaimer:**  
 This information is intended as advice to the best of our knowledge. The provided data is based on our own measurements, they do not provide any guaranteed properties nor are these delivery specifications. Due to the versatility of materials, applications and taking in consideration the industrial property rights of third parties, Balver Zinn Josef Jost GmbH & Co. KG cannot take any liability.

CLASSIFICATION	
DIN EN ISO 9454-1: 2016	2131
IPC-J-STD-004-A: 2004	ORL0

PROPERTIES		
Density	@20°C [kg/dm³]	1.008
Solid content	[% w/w]	3.4
Acid number	[mg KOH/g]	27.7
Water content	[% w/w]	96
VOC content	[% w/w]	Remainder
Filmformer(s)		Organic
Color		Colorless
Odor		None
Flashpoint COC	[°C]	None
Thinners		Di-water

TEST REPORTS			
Certificate of Compliance			Website
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		Pass
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	Pass
Halide	IPC-TM-650 2.3.35.1	[Fluoride by Spot]	Pass
Copper Corrosion	IPC-TM-650 2.6.15		Pass
SIR	IPC-TM-650 2.6.3.3		Pass
ECM	IPC-TM-650 2.6.14.1		N/A

PACKAGING AND STORAGE		
Packaging can	(HDPE) [liter]	10
Packaging Drum	(HDPE) [liter]	200
Shelf-life in months		
Storage temperature	20-25 °C	24