



INTERFLUX[®] Total Solution TS 33

DESCRIPTION:

TS33 is a synthetic no-clean flux. TS33 is developed to allow a wide-open process window for the no-clean soldering process. Since no-clean fluxes are not developed to be cleaned, TS33 is especially made to be compatible with solvent based cleaners for those who still want or need to clean (part of) their production for specific reasons. The excellent soldering performance reduces the process costs and improves the quality. TS33 meets Bell-core and IPC requirements.

APPLICATION:

TS33 can be applied by foam, spray, wave or dipping. Use an airknife after foamfluxing. On the preheating the PCB should reach between 80°C and 120°C on topside. A solderwave set-up where oxides are pushed over the backplate when the PCB reaches the solderwave, is recommended.

The solderability of TS33 on pretinned or OSP coated bare copper boards is excellent. For soldering on bare copper, please consult also the Interflux⁷ publications on this issue.

Any residues (transparent!) that would occur, can easily be removed with Isopropanol or with solvent based cleaners.

PHYSICAL AND CHEMICAL PROPERTIES:

Density (20°C)	: 0.807 g/ml ±0.002	Halide content	: 0 %
Solid Content (activ.)	: 3.3% ± 0.2	Water content	: < 0.1%
Total Acid Number	: 27 mg KOH/g ± 2	Colour	: colourless
Flash point (T.O.C.)	: +13°C	Odour	: Aliphatic alcohol
Recommended thinner	: T1000 conditioner		

HEALTH & SAFETY:

Material Safety Datasheets available upon request.

PACKAGING:

10L, 25L and 200 Liter high density polyethylene drums.

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