

# QUALITEK®

## PF440 Rosin Paste Flux

### DESCRIPTION

Qualitek PF440 is a modified petrolatum/rosin paste where higher activity is required to wet oxidized metal surfaces. It is generally recommended for touch up and repair of electronic assemblies.

### FEATURES AND BENEFITS

- Excellent tack
- Excellent activity
- Minimal odor
- Creamy for ease of handling & dispensing
- Soft post soldering residues

### APPLICATION METHODS

Paste fluxes may be brushed or dispensed on the appropriate areas, then heated using conventional methods.

### RESIDUE REMOVAL

Post soldering residues from PF440 may be removed with CFC substitutes or Qualitek #1005 Everkleen buffered saponifier.

### PHYSICAL & CHEMICAL CHARACTERISTICS

#### PHYSICAL PROPERTIES

Color & Appearance	Amber, Semi-Solid (Paste)
Tack (Malcom)	Over 150
Viscosity at 25 °C	25 – 35 kcps

#### CHEMICAL PROPERTIES

Activity Level	ROL1	IPC-J-STD-004
Halide Content	< 0.50%	IPC-J-STD-004
Copper Corrosion Test	Slight Etch	IPC-J-STD-004
pH (5% Solution)	2.5-3.5	IPC-TM-650

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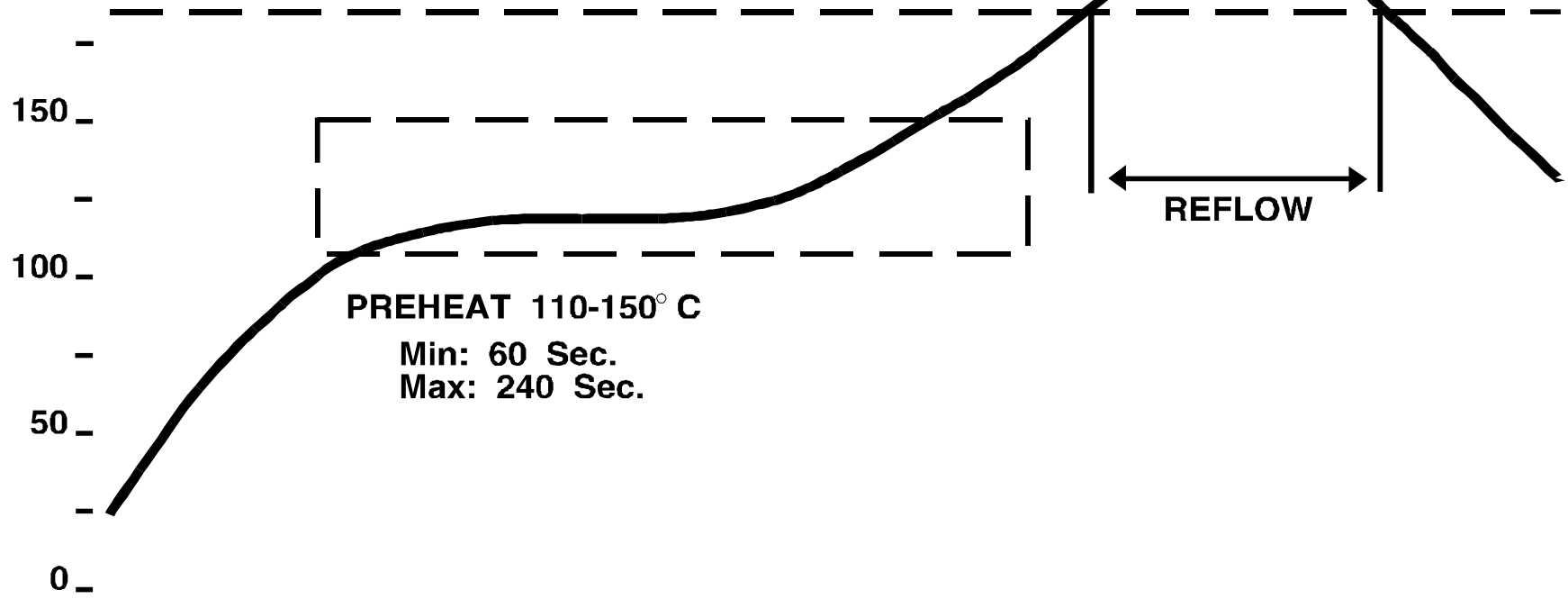
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TEMP.: IN °C

ALLOY: SN62 or SN63

PEAK TEMPERATURE

300 -  
-  
250 -  
-  
200 -  
-  
150 -  
-  
100 -  
-  
50 -  
-  
0 -



PREHEAT 110-150° C

Min: 60 Sec.

Max: 240 Sec.

REFLOW