

Kester® 985M

Low-Solids, Alcohol Based, No-Clean Wave Soldering Flux

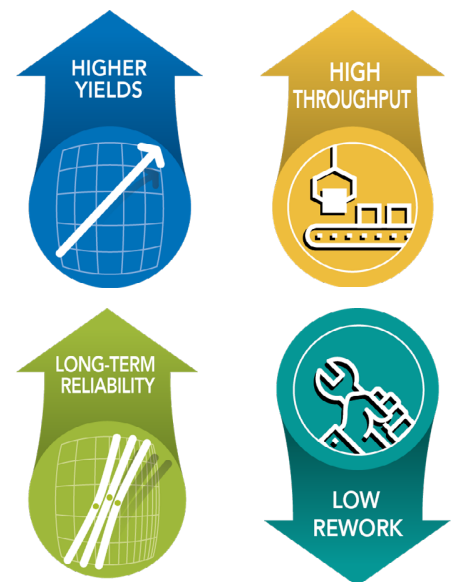
Best Broad Spectrum Wave Soldering Flux

Kester 985M is broad spectrum, halide free liquid flux, developed for use in both traditional tin-lead and lead-free solder alloys. The unique activation package of 985M makes it a wide process window flux suitable on both standard and high density assemblies. It exhibits excellent wetting properties to minimize solder bridges and solder ballings during all soldering operations. The residues are minimal and not apparent, excellent for pin testing.



Key Features

- Produces highly reliable assemblies meeting the toughest SIR/ECM requirements
- Exhibits excellent soldering with improved performance in bridging and hole-fill
- Leaves uniform, tack free and pin testable residues
- Broad spectrum liquid flux for standard and high density boards



 **kester**

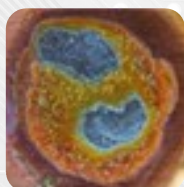
ASSEMBLY SOLUTIONS

Kester® 985M

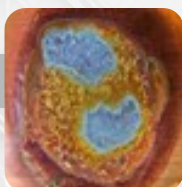
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COPPER CORROSION TEST (IPC-TM-650 2.6.15)

Initial



After Aging



985M

- Initial and after 10 days of exposure to 40 °C and 93% RH
- There was minor discoloration without pitting of the copper for 985M, classified under "M" category of corrosion as per J-STD-004B

COPPER MIRROR TEST (IPC-TM-650 2.3.32)

Control



985M



- No copper film was removed from the copper mirror
- "L" category corrosion per J-STD-004B

TECHNICAL DATA	KESTER 985M	PROCESS CONTROL	KESTER 985M
Solids Content, wt/wt	3.6%	Flux Application	Spray
Acid Number (mg KOH/gm)	20.0	Amount of Flux Applied	600-1200 µg/in ² solids
Specific Gravity @ 25 °C	0.805	Top-Side Preheat Temperature	80-115 °C
IPC J-STD-004(B) Designation	ORM0	Bottom-Side Preheat Temperature	0 to +32 °C vs. Topside
Halogen-Free	None	Solder Pot	260-270 °C for SnCu or SAC alloy 245-260 °C for Sn63Pb37 alloy
SIR, PC J-STD-004(B)	Passed	Contact Time	2-5 s



macdermidalpha.com
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Kester is a product brand of MacDermid Alpha Electronics Solutions.

For more information, contact us at
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