



# PRODUCT DATA SHEET

## Water Soluble Fluxes 425 Series

January, 2008

### DESCRIPTION

**425 series** of water-soluble fluxes were developed to **eliminate the problems** of odor, spattering, excess fumes and surface penetration caused by typical glycol bearing water soluble fluxes. These fluxes are formulated with a variety of activator systems to fulfill all soldering requirements, including products that contain surface mounted components. Because of their unique chemistry, all **425 series** fluxes can be processed **at lower** preheat temperatures.

- ◆ **425 SP** is a **fully halogenated flux** to solder the most difficult boards and surfaces. Can be washed with warm water or preferably with the aid of an alkaline neutralizer like our 600A aqueous cleaner.
- ◆ **425 RX** is both **halogenated** and **organic acid activated**. The **425 RX** can be cleaned with cold water without leaving residues even on the most demanding solder resists.
- ◆ **425 NH** is **organic acid activated**. The **425 NH** is halide free and is used in applications where halides have to be avoided.

PHYSICAL PROPERTIES	425 RX	425 SP	425 NH
Appearance	light amber liquid	light amber liquid	light amber liquid
Specific gravity @ 20 °C	0.861	0.857	0.875
Solids	23%	18 %	23 %
Activator	Halide & OA	Halide	OA (Halide Free)
Recommended thinner	<b>425-00</b>	<b>425-00</b>	<b>425-00</b>

**SAFETY** **425 series** fluxes are red label flammable materials. Avoid exposure to heat, sparks and open flames. OSHA Material Safety Data Sheets are available upon request.

**PACKAGING** **425 series** are available in 1, 5-gallon pails and 55-gallon drums.

**STORAGE** **425 series** fluxes have a shelf life of 12 months when stored in the original sealed container at ambient temperatures.

**“Our commitment to quality and customer service is our most valuable asset”**

The information contained herein is offered free of charge for use by technically qualified personnel at their discretion and risk. All information and recommendations contained herein are based on test and data which we believe to be reliable, but the accuracy or completeness is not guaranteed and no warranty of any kind is made with respect hereto.

Manufactured By:  
**Interflux USA, Inc.**  
2914 Ladybird Lane  
Dallas, TX 75220

Tel: 214-350-5565  
Toll Free: 800-843-3589  
Fax: 214-350-9713

[www.interfluxusa.com](http://www.interfluxusa.com)