



MetaFlux™ RMA-600

Product Bulletin

Mildly Activated RMA Rosin

Metallic Resources' MetaFlux RMA-600 is a chloride-free mildly activated RMA rosin soldering flux specially formulated for wave soldering applications. It exhibits a homogeneous solution of white water rosin in a multi-component solvent system with a bromide organic activator. The product becomes active above 340°F (175°C) and attains peak activity between 390-500°F (200-260°C); it thus promotes excellent solderability. It is available in 1-gal. containers, 5-gal. pails, and 55-gal. drums.

Ideal for Demanding Applications

MetaFlux RMA-600 is specially designed for wave soldering applications requiring excellent soldering activity which yields residues with high water-extract resistivity. It is ideal for soldering difficult printed circuit boards where demanding conditions exist.

High Production Rates Obtained

MetaFlux RMA-600 solder flux can be used over a wide variety of electronics applications, thus creating versatility and economy. The high activity makes it ideal for high production rates for greater cost-effectiveness.

Application Directions

MetaFlux RMA-600 can be applied by foaming, brushing, dipping, rolling, and

spraying for wave soldering applications. Soldering need not be immediately carried out after application of the flux, although it is recommended. Residues are non-corrosive, non-conductive, and fungus proof; they need not be removed. If cleaning is desired, use a vapor degreasing method with appropriate solvent systems (alcohol or halogenated solvents) to remove residues. The specific gravity increases with prolonged use as the solvents evaporate. Maintain specific gravity in 0.90 to 0.92 range. Proper specific gravity can be restored to its original value by adding the proper amount of 600-T thinner and thoroughly mixing. Preheating of boards reduces spattering.

Physical Properties

Form	Light liquid
Color	Brown
Specific Gravity	0.85 ± 0.03 g/cc @ 68°F (20°C)
Density	7.1 lb./gal.
Solids Content	20%
Flash Point	53°F (12°C)
Chloride Content	None
Free Acidity	None
Inorganic Cations	None
Spread Factor	90 (minimum)
Boiling Point	180°F (85°C)
Freezing Effects	None
Optimum Soldering Range	390-500°F (200-260°C)
Residue Characteristics	Non-Corrosive
Non-Conductive Water Extract Resistivity	150,000 ohm/cm



METALLIC RESOURCES, INC.

2368 East Enterprise Parkway • Twinsburg, Ohio 44087 • Phone: 330.425.3155 • Fax: 330.425.2180

Safety Precautions

MetaFlux RMA-600 is flammable and should be stored in plastic containers away from heat, sparks, open flame, and other sources of ignition in temperatures between 60°F to 80°F. Use adequate ventilation to remove flux fumes. Avoid contact with skin and eyes. Do not inhale vapors or fumes. This product has a shelf life of two (2) years. Consult MSDS sheet for additional information.

Standards Met

MIL SPEC MIL-F-14256F, Type RMA.

RMA600-1-697

Recommendations made by this company and its representatives are based upon test data, experiments, and experience believed to be reliable. No guarantee of accuracy is made, however. All products are sold upon the condition that the buyer will make his own tests and assume the responsibility for the suitability of the product under his application and service conditions. Statements made herein will vary according to the nature of the surfaces to which the product is applied, application technique, and service condition. We in no event assume liability beyond the purchase price of our products involved and make as a condition of sale that we will refund the purchase price or replace materials proven to be defective and reported in a timely fashion, but no later than six (6) months after shipment. No representative of the manufacturer and/or seller has the authority to alter or extend these conditions.