

# alpha

## CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL



The parameters below are from actual cleaning trials using Kyzen cleaning materials with specified ALPHA solder paste and process parameters.

### AQUEOUS INLINE PROCESS PARAMETERS: Recommended Kyzen Solutions

| Aquanox A4520       | Material Form | Wash Conc. | Wash Time   | Wash Temp. | Rinse    |
|---------------------|---------------|------------|-------------|------------|----------|
| Alpha 102-1500      | Paste Flux    | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha 376           | Paste Flux    | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha 7LV           | Paste Flux    | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha 611           | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha 615           | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha 620           | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha EF2202        | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha EF3215        | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha EF4102        | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha EF9301        | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha EF-6000       | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha EF-8000       | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha EF-10000      | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha NR300A2       | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha NR310B        | Wave Flux     | 10-15%     | 2-5 minutes | 120-150°F  | DI-Water |
| Alpha NR330         | Wave Flux     | 10-15%     | 3-5 minutes | 120-150°F  | DI-Water |
| Alpha RF800         | Wave Flux     | 10-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha OM5002        | Solder Paste  | 12-15%     | 3-5 minutes | 140-150°F  | DI-Water |
| Alpha LR721         | Solder Paste  | 12-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha OM5100        | Solder Paste  | 12-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha OM6106        | Solder Paste  | 12-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha RMA390DH4     | Solder Paste  | 12-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha SAC350        | Solder Paste  | 15-20%     | 3-5 minutes | 140-160°F  | DI-Water |
| Alpha UP78M         | Solder Paste  | 12-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha OL 107E       | Solder Paste  | 15-20%     | 3-5 minutes | 140-160°F  | DI-Water |
| Alpha RMA-9086      | Solder Paste  | 12-15%     | 3-5 minutes | 140-160°F  | DI-Water |
| Alpha OM310 – LF    | Solder Paste  | 15-20%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha OM338 – LF    | Solder Paste  | 15-20%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha OM338-PT – LF | Solder Paste  | 15-20%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha OM350         | Solder Paste  | 15-20%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha PNC 0518N     | Solder Paste  | 15-20%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha PNC 0524N     | Solder Paste  | 15-20%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha RMA 9086      | Solder Paste  | 12-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha Telcor Plus   | Solder Wire   | 10-15%     | 3-5 minutes | 130-150°F  | DI-Water |
| Alpha NR310B        | Solder Wire   | 10-15%     | 3-5 minutes | 140-150°F  | DI-Water |
| Alpha Flutin 1532   | Solder Wire   | 10-15%     | 3-5 minutes | 130-150°F  | DI-Water |

Recommendations: Circulating air for drying.

◆ ALL APPLICATION RECOMMENDATIONS ARE INTENDED FOR GUIDELINE USE ONLY

PROCESS PARAMETERS GUIDELINES



# CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL

## AQUEOUS INLINE PROCESS PARAMETERS: Recommended Kyzen Solutions

| <b>Aquanox A4625</b> | Material Form | Wash Conc. | Wash Time   | Wash Temp. | Rinse    |
|----------------------|---------------|------------|-------------|------------|----------|
| Alpha 102-1500       | Paste Flux    | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha 376            | Paste Flux    | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha 7LV            | Paste Flux    | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha 611            | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha 615            | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha 620            | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha EF2202         | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha EF3215         | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha EF4102         | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha EF9301         | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha NR300A2        | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha NR330          | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha RF800          | Wave Flux     | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha OM5100         | Solder Paste  | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha LR721          | Solder Paste  | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha OM6106         | Solder Paste  | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha RMA390DH4      | Solder Paste  | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha OM5002         | Solder Paste  | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha SAC350         | Solder Paste  | 8-13%      | 3-5 minutes | 110-140°F  | DI-Water |
| Alpha UP78M          | Solder Paste  | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha OL 107E        | Solder Paste  | 12-15%     | 3-5 minutes | 140-160°F  | DI-Water |
| Alpha RMA-9086       | Solder Paste  | 8-13%      | 3-5 minutes | 140-160°F  | DI-Water |
| Alpha NR310B         | Solder Paste  | 8-13%      | 2-5 minutes | 110-140°F  | DI-Water |
| Alpha OM310 – LF     | Solder Paste  | 12-15%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha OM338 – LF     | Solder Paste  | 12-15%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha OM338-PT – LF  | Solder Paste  | 12-15%     | 3-8 minutes | 140-160°F  | DI-Water |
| Alpha OM350          | Solder Paste  | 10-13%     | 2-5 minutes | 140-160°F  | DI-Water |
| Alpha Telcor Plus    | Solder Wire   | 8-13%      | 3-5 minutes | 110-150°F  | DI-Water |
| Alpha Fluitin 1532   | Solder Wire   | 8-13%      | 3-5 minutes | 110-150°F  | DI-Water |

Recommendations: Circulating air for drying.



# CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL

## AQUEOUS BATCH SPRAY-IN-AIR (DISHWASHER STYLE): Recommended Kyzen Solutions

| <b>Aquanox A4625B</b> | Material Form | Wash Conc. | Wash Time    | Wash Temp. | Rinse    |
|-----------------------|---------------|------------|--------------|------------|----------|
| Alpha 102-1500        | Paste Flux    | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha 376             | Paste Flux    | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha 611             | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha 615             | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha 620             | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha EF2202          | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha EF3215          | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha EF4102          | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha EF9301          | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha NR300A2         | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha NR330           | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha RF800           | Wave Flux     | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha OM5002          | Solder Paste  | 12-15%     | 5-10 minutes | 120-140°F  | DI-Water |
| Alpha LR721           | Solder Paste  | 12-15%     | 5-10 minutes | 120-140°F  | DI-Water |
| Alpha OM5100          | Solder Paste  | 12-15%     | 5-10 minutes | 120-140°F  | DI-Water |
| Alpha OM6106          | Solder Paste  | 12-15%     | 5-10 minutes | 120-140°F  | DI-Water |
| Alpha RMA390DH4       | Solder Paste  | 10-12%     | 5-10 minutes | 120-140°F  | DI-Water |
| Alpha SAC350          | Solder Paste  | 12-15%     | 5-10 minutes | 120-150°F  | DI-Water |
| Alpha UP78M           | Solder Paste  | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha OL 107E         | Solder Paste  | 12-15%     | 5-15 minutes | 110-140°F  | DI-Water |
| Alpha RMA-9086        | Solder Paste  | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha NR310B          | Solder Paste  | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha OM310 – LF      | Solder Paste  | 12-15%     | 5-15 minutes | 130-150°F  | DI-Water |
| Alpha OM338 – LF      | Solder Paste  | 12-15%     | 5-15 minutes | 130-150°F  | DI-Water |
| Alpha OM338-PT – LF   | Solder Paste  | 12-15%     | 5-15 minutes | 130-150°F  | DI-Water |
| Alpha OM350           | Solder Paste  | 12-15%     | 5-15 minutes | 130-150°F  | DI-Water |
| Alpha Fluitin 1532    | Solder Wire   | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |
| Alpha Telcor Plus     | Solder Wire   | 10-12%     | 5-10 minutes | 110-140°F  | DI-Water |

Recommendations: Circulating air for drying.

Booster 20 is a sump side additive designed for batch cleaning processes. When cleaning in batch systems, longer wash times are needed. Booster 20 improves cleaning efficacy and provides added protection to the solder, aluminum, copper and all other alloys. The recommended usage level is 100-200 ml or 2-5 ounces when charging a common batch dishwasher style cleaning system.



# CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL

## ULTRASONIC PROCESS PARAMETERS: Recommended Kyzen Solutions

| <b>Aquanox A4651US</b> | Material Form | Wash Conc. | Wash Time  | Wash Temp. |
|------------------------|---------------|------------|------------|------------|
| Alpha 102-1500         | Paste Flux    | 15%        | 10 minutes | 145°F      |
| Alpha 7LV              | Paste Flux    | 15%        | 10 minutes | 145°F      |
| Alpha 615              | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha 620              | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha RF800            | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha EF2202           | Wave Flux     | 30%        | 10 minutes | 145°F      |
| Alpha EF3215           | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha EF4102           | Wave Flux     | 25%        | 10 minutes | 145°F      |
| Alpha EF9301           | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha EF6000           | Wave Flux     | 20%        | 10 minutes | 145°F      |
| Alpha EF8000           | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha EF10000          | Wave Flux     | 20%        | 10 minutes | 145°F      |
| Alpha NR300A2          | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha NR330            | Wave Flux     | 15%        | 10 minutes | 145°F      |
| Alpha OM5002           | Solder Paste  | 30%        | 30 minutes | 145°F      |
| Alpha UP78M            | Solder Paste  | 15%        | 10 minutes | 145°F      |
| Alpha RMA-9086         | Solder Paste  | 15%        | 30 minutes | 145°F      |
| Alpha OM310 – LF       | Solder Paste  | 30%        | 10 minutes | 145°F      |
| Alpha OM310B           | Solder Paste  | 15%        | 10 minutes | 145°F      |
| Alpha OM338 – LF       | Solder Paste  | 30%        | 30 minutes | 145°F      |
| Alpha OM338-PT – LF    | Solder Paste  | 30%        | 30 minutes | 145°F      |
| Alpha OM350            | Solder Paste  | 15%        | 10 minutes | 145°F      |

Data generated using 40 kHz ultrasonic energy.



# CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL

## SPRAY UNDER IMMERSION PROESS PARAMETERS: Recommended Kyzen Solutions

| <b>Ionox I3302</b>  | Material Form | Wash Conc. | Wash Time    | Wash Temp. | Rinse    |
|---------------------|---------------|------------|--------------|------------|----------|
| Alpha 102-1500      | Paste Flux    | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha 376           | Paste Flux    | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha 7LV           | Paste Flux    | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha 611           | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha 615           | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha 620           | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha EF2202        | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha EF3215        | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha EF4102        | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha EF9301        | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha RF800         | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha NR300A2       | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha NR330         | Wave Flux     | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha OM5002        | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha OM5100        | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha OM6106        | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha RMA390DH4     | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha LR721         | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha SAC350        | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha UP78M         | Solder Paste  | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha OL 107E       | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha RMA-9086      | Solder Paste  | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha NR310B        | Solder Paste  | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha OM310 – LF    | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha OM338 – LF    | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha OM338-PT – LF | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha OM350         | Solder Paste  | 100%       | 5-10 minutes | 140-150°F  | DI-Water |
| Alpha Fluitin 1532  | Solder Wire   | 100%       | 5-10 minutes | 130-150°F  | DI-Water |
| Alpha Telcor Plus   | Solder Wire   | 100%       | 5-10 minutes | 130-150°F  | DI-Water |

Recommendations: Circulating air for drying.



# CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL

## VAPOR DEGREASING(SOLVENT CLEANING): Recommended Kyzen Solutions

| Micronox MX2501     | Material Form | Boil Sump       | Rinse Sump | Vapor     | Drying        |
|---------------------|---------------|-----------------|------------|-----------|---------------|
| Alpha 102-1500      | Paste Flux    | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 376           | Paste Flux    | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 7LV           | Paste Flux    | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 611           | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 615           | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 620           | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF2202        | Wave Flux     | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF3215        | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF4102        | Wave Flux     | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF9301        | Wave Flux     | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha RF800         | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha NR300A2       | Wave Flux     | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha NR330         | Wave Flux     | Not Recommended |            |           |               |
| Alpha OM5002        | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM5100        | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM6106        | Solder Paste  | Not Recommended |            |           |               |
| Alpha RMA390DH4     | Solder Paste  | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha LR721         | Solder Paste  | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha SAC350        | Solder Paste  | Not Recommended |            |           |               |
| Alpha UP78M         | Solder Paste  | Not Recommended |            |           |               |
| Alpha OL 107E       | Solder Paste  | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha RMA-9086      | Solder Paste  | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha OM310 – LF    | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM338 – LF    | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM338-PT – LF | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM350         | Solder Paste  | Not Recommended |            |           |               |
| Alpha Telcor Plus   | Solder Wire   | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha Flutin 1532   | Solder Wire   | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |

### VAPOR DEGREASING (SOLVENT CLEANING): Recommended Kyzen Solutions

| Ionox I3955         | Material Form | Boil Sump       | Rinse Sump | Vapor     | Drying        |
|---------------------|---------------|-----------------|------------|-----------|---------------|
| Alpha 102-1500      | Paste Flux    | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 376           | Paste Flux    | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 7LV           | Paste Flux    | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 611           | Wave Flux     | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 615           | Wave Flux     | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha 620           | Wave Flux     | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF2202        | Wave Flux     | 5 minutes       | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF3215        | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF4102        | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha EF9301        | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha RF800         | Wave Flux     | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha NR300A2       | Wave Flux     | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha NR330         | Wave Flux     | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha OM5002        | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM5100        | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM6106        | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM350         | Solder Paste  | 10 minutes      | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha LR721         | Solder Paste  | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha RMA390DH4     | Solder Paste  | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha SAC350        | Solder Paste  | Not Recommended |            |           |               |
| Alpha UP78M         | Solder Paste  | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha OL 107E       | Solder Paste  | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha RMA-9086      | Solder Paste  | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha OM310 - LF    | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM338 - LF    | Solder Paste  | Not Recommended |            |           |               |
| Alpha OM338-PT - LF | Solder Paste  | Not Recommended |            |           |               |
| Alpha Flutit 1532   | Solder Wire   | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |
| Alpha Telcor Plus   | Solder Wire   | 5-10 minutes    | 3 minutes  | 2 minutes | Vapor Blanket |

Application recommendations are intended to serve as only a guideline. To request a free-of-charge cleaning trial, expert cleaning process optimization or additional cleaning material information, please contact Kyzen Corporation.



Testing performed in Kyzen's fully staffed and equipped applications laboratory located in Nashville, TN.