

PRODUCT BULLETIN

IONOX® I3302

Broad Spectrum Electronics Cleaning Solvent

FEATURES & BENEFITS

- SUPERIOR STRENGTH
- HEAVY-DUTY
- MULTI-METAL SAFE
- SAFE ON COPPER AND ALUMINUM
- SAFE ON FERROUS AND PRECIOUS METALS
- NO HAP'S
- NO CFC'S
- NO SARA 313'S
- LOW ODOR
- USE IN MANUAL OR MECHANICAL

IONOX I3302 is a superior strength semi-aqueous solvent blend specially designed for removal of rosin, no-clean, tacky and lead-free flux, adhesives and assembly residues from through-hole, hybrid and surface mount electronics. Easy to use, IONOX I3302 is used as received and heated from 120 to 150°F. It can be applied by spray-under-immersion, immersion, ultrasonics and hand-wipe methods. A water rinse is used to remove all traces of soils and cleaner residues. Following rinsing, a hot air drying process is usually initiated.



TYPICAL SOILS

- WHITE GUM ROSIN FLUX
- SYNTHETIC ROSIN FLUX
- OILS
- GREASE AND WAX
- SOLDER PASTES
- FINGER PRINTS
- SHOP DIRT
- UNCURED ADHESIVES

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TYPICAL PHYSICAL AND CHEMICAL PROPERTIES:

Appearance	Clear straw liquid	pH 100%	9.6-10.4
Odor	Alcohol	pH 10%	Not applicable
Specific Gravity	1.04-1.06	VOC, 100%	1034.9 g/L
Weight/gallon	8.75#	Flash Point, °F	180 (COC)
Water Solubility	Complete	Boiling Point, °F/C	302/150
VP of VOC Comp.	0.19 mmHg at 20 °C		

SUGGESTED PROCESS PARAMETERS:

Process Type	Concentration Range	Temperature Range	Rinse/Dry
Spray; Stencil (SUI)	100%	100-120 °F	Optional/ Air
Immersion, Agitation	100%	ambient to 150 °F	IPA, Water/ Air
Immersion, Soak	100%	ambient to 150 °F	IPA, Water/ Air
Immersion, Ultrasonics	100%	ambient to 150 °F	IPA, Water/ Air
Manual Wipe	100%	ambient	Air

The above conditions are meant to be starting ranges. Process parameters may be increased or decreased as needed depending on the specific parts and soils involved. Your Kyzen Sales Representative can assist you in optimizing your process parameters.

IONOX I3302

BROAD SPECTRUM SEMI-AQUEOUS SOLVENT

COMPATIBILITY:

IONOX I3302 is safe for use on yellow metals including copper, bronze and brass, aluminum alloys, iron, steel and composites in addition to most precious metals, plastics and rubbers. It is safe to use with PVDF, Kalrez®, Teflon and ceramic elastomers and filters, while it is best used in polypropylene or stainless equipment.

HINTS FOR SUCCESSFUL USE:

- Effective at temperatures up to 150°F.
- Best results are obtained when parts are completely immersed in I3302.
- A water rinse is recommended to remove all traces of soil and cleaner residues.
- Dry parts with warm or circulating air.

RINSING AND DRYING:

- A water rinse will remove all traces of cleaner residues.
- If rinsing is desired, use deionized or reverse osmosis (RO) water.

BATH LIFE:

Bath life studies show high loading capacity. This equates to long tank life, low maintenance costs and reduced waste generation and chemical consumption.

MAINTENANCE METHODS:

IONOX I3302 is used as received. No further dilution is necessary. Most soils will be removed by dissolution. This will contaminate the bath. Once the bath becomes too dirty, it will stop cleaning. At that time it should be replaced with fresh product.

ENVIRONMENTAL, HEALTH AND SAFETY:

IONOX I3302 is a combustible, non-corrosive solvent with 1034.8 g/L VOC at 100%. It contains no CFC's or HAP's. Refer to the Material Safety Data Sheet for more information.

STORAGE AND HANDLING:

All ingredients in this product are TSCA listed. It is a combustible, non-corrosive liquid. Packaged in polyethylene containers, IONOX I3302, with the seal unbroken, has a suggested shelf-life of one year. Store out of direct sunlight at 40-100°F.

AVAILABILITY:

IONOX I3302 is available commercially in one (1) gallon, five (5) gallon and 55 gallon containers.

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