



Ionox[®] I3302

Semi-Aqueous Broad Spectrum Immersion Electronics Cleaner

IONOX I3302 is used to remove difficult soldering fluxes, such as synthetic rosins and no-clean fluxes from through-hole, hybrid, and surface mount electronics in immersion agitation, spray-under-immersion, ultrasonic and recirculation cleaning systems. I3302 is effective on cleaning contaminants from multimetal and plastic parts.

Benefits & Features

- Worker safe and environmentally friendly
- Free rinsing and completely water soluble
- Tested under Kyzen's Solder Paste Evaluation Study on more than 100 different residues
- Proven effective on a broad spectrum of pastes, fluxes and adhesives
- Effective on RMA, NC, WS, MR, RO, SO, ROL0, ROL1, REH1, and ORL0 class soils
- Fully inhibited to leave the solder joints bright and shiny with no chemical etch or attack

Chemical Description

IONOX I3302 is formulated for cleaning difficult soldering fluxes, assembly residues, and misprinted adhesives. It is a blend of organic solvents, surfactants, inhibitors and rinse aides. NFPA ratings are Health 2, Flammability 2, and Reactivity 0.

Typical Properties

Flash Point (Cleveland OC)	180°F	Specific gravity	1.04-1.06
Volatile Organic Compound (VOC) EPA Method 24, g/L	1034.9	Appearance	Clear straw liquid
Cloud Point at 100%	>200°F	Odor	Alcohol
		Boiling Point (°C)	150

Typical Process

IONOX I3302 is added to the wash chamber at full concentration. It is then heated to an operating temperature between 120°- 150°F for electronics flux removal. Washing is usually accomplished through spray-under-immersion, ultrasonic agitation, or simple immersion. Following the washing process, an immersion or direct spray heated, de-ionized, electronic-grade water rinse is required. The rinse water should be heated prior to turning on tank pumps. A heated rinse will speed the rinsing and drying process. I3302 can also be used in a hand-wipe application, and rinsed with IPA or de-ionized water.