



CitraFlor EG3 Solvent

Key Benefits

CitraFlor™ EG3 is the ultimate solvent product for bench top defluxing and stencil/misprint cleaning. This product eliminates many of the issues associated with isopropyl alcohol (IPA) cleaning including incomplete cleaning, white residue, and low flash point. Used as directed, CitraFlor EG3 will also reduce chemical emissions and lower use costs.

Product Contents

CitraFlor EG3 is a mixture of polar and non-polar solvents. CitraFlor EG3's key ingredient, high purity citrus terpene solvent, is derived from Florachem's proprietary refining process. CitraFlor EG3 is considered low in toxicity, readily biodegradable and contains no halogens or heavy metals.

Typical Properties

Appearance	Clear
Purity, Citrus Terpenes	>98%
Solubility in Water	Partial
Flash Point (PMCC)	105°F (41°C)
Specific Gravity	.81
Evaporate Rate (Butyl Acetate=1)	<1

Application Guidelines

CitraFlor EG3 is used full strength at ambient temperature. Apply by hand or dip (unheated) tank. Use CitraFlor EG3 in the following cleaning applications:

Application	Cleaning Function
Post solder assembly or component cleaning	Removes reflowed lead and lead free paste residues
Rework cleaning	Removes all types of flux residues
Stencil/misprint	Removes solder pastes and uncured SMD adhesives
Conformal coating	Removes silicone and acrylic conformal coatings
Pallets, Fixtures, Wave Solder Fingers	Removes baked – on flux residues (soaking may be necessary)

The drying process can be accelerated by following with a clean wipe or desiccated forced air.

CitraFlor EG3 can also be mixed with IPA for quicker drying and reduced citrus odor. CitraFlor EGX is a custom blend of CitraFlor EG3 and IPA.

For manual cleaning applications requiring greater non-polar solvency, CitraFlor EG or EGS are recommended.

Hand Wipe Chart

HMIS Properties Comparison

	HMIS			Flash Point
	Health	Flammability	Reactivity	(Closed Cup)
CitraFlor EG	1	2	1	115° F (46°C) Min
CitraFlor EGS	1	2	1	115° F (46°C) Min
CitraFlor EG3	1	2	1	105°F (41°C)
CitraFlor EGX	1	3	1	59° F (15°C)
Isopropyl alcohol	2	3	0	53° F (12°C)

Compatibility

CitraFlor EG3 is compatible with most materials of construction in circuit assembly and semiconductor packaging. The product is safe on common metal alloys including aluminum. The product is also compatible with certain plastics and composite materials during short exposure times.

Storage and Handling

CitraFlor EG3 is available in 55 gallon (166kg/365 lb) drums and 5 gallon (14kg/30lb) pails.

CitraFlor EG3 must be shipped according to IATA, US DOT and IMO transport standards (see MSDS/GHS for details).

In the USA, CitraFlor EG3 is classified as a “Class IIA Combustible Liquid” by NFPA standards. Shelf life is indefinite however quality should be checked after 36 months in unopened original containers.

Disposal

Contact your local waste management company regarding suitable disposal methods. Fuel blending is recommended where offered.

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