

PROCIRC 9994

Hot Oil Flux

INTRODUCTION

Procirc 9994 Hot Oil Flux is formulated, for activating tin lead and tin alloys prior to fusing on Printed Circuit Boards.

BENEFITS

- Mirror finish.
- Will aid the removal of etch residues and oxidation of plated tin lead.
- Low viscosity for economical usage.

SOLUTION MAKE -UP

Procirc 9994 Hot Oil Flux Ready for use.

OPERATING DATA

Specific Gravity	0.96 – 0.98 AT 20°C
------------------	---------------------

EQUIPMENT

Can be used in dip or roller applications.

INSTALLATION

It is essential that the tanks to be used for Procirc 9994 Hot Oil Flux are thoroughly cleaned before any chemistry is introduced.

Contact PMD Technical Department for appropriate procedure.

PROCESS SEQUENCE

1. Condition in Procirc 9870 Solder Conditioner.
2. Rinse.
3. Dry (Preferable).
4. Procirc 9994 Hot Oil Flux application (roller or dip).
5. Pre heat Procirc 9995 Hot Oil, 10 - 15 seconds at 150°C
6. Main Reflow Procirc 9995 Hot Oil, 15 - 30 seconds at 210 - 220°C.
7. Quench Procirc 9995 Hot Oil, 10 - 15 seconds at 120°C.
8. Wash off and dry.

MAINTENANCE AND CONTROL

Under optimum conditions it is not necessary to carry out analytical maintenance and control in order to maintain the performance of this product.

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products are referred to in this data sheet.

PRODUCT NAME	PRODUCT NUMBER
Procirc 9870 Solder Conditioner	987014
Procirc 9994 Hot Oil Flux	997046
Procirc 9995 Hot Oil	994013

Whilst every endeavour has been made to ensure that the information given in this data sheet is correct, PMD Chemicals Limited gives no warranty, express or implied, relating to the use or performance of this product.