

PROCIRC 9995

Hot Oil

INTRODUCTION

Procirc 9995 Hot Oil is formulated, for use with Procirc 9994 Hot Oil Flux for the fusing of plated tin/lead and tin alloys on Printed Circuit Boards.

BENEFITS

- Low viscosity for ease of storage and handling.
- Low smoke and high flash point for safety in use.
- Low foam.
- Water rinsable.

SOLUTION MAKE -UP

Procirc 9995 Hot Oil

Ready to use

OPERATING DATA

Preheat	150°C
Reflow	210 – 220°C
Quench	120°C
Time	10 – 30 seconds
Agitation	Not required
Extraction	Recommended

EQUIPMENT

For use in immersion only.

INSTALLATION

It is essential that the tanks to be used for Procirc 9995 Hot Oil 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 @ 120°C
8. Wash off and dry.

MAINTENANCE AND CONTROL

Under optimum processing 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

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