

PROCIRC 986

SOLDER CONDITIONER

INTRODUCTION

Procirc 986 Solder Conditioner is a high performance conditioner for tin-lead, designed to prepare the surface of the tin-lead for complete effective IR reflow or Hot Oil Fusing.

BENEFITS

Removes etch residues and oxidation completely ensuring bright even fusing.

Cleans exposed copper, lead rich residues are eliminated and the copper is activated.

Long life ensures high area throughput.

Chemistry compatible with Procirc Fluxes to give perfect fusing.

Non Fluoborate.

Supplied as a concentrate and economical to use.

Spray or immersion applications.

SOLUTION MAKE-UP

Procirc 986 Solder Conditioner - 25 - 75% v/v
Optimum 50% v/v

OPERATING DATA

Temperature	25 - 40 Deg. C
Time	0.5 - 5 minutes
Agitation	Recommended
Extraction	Recommended

EQUIPMENT

Tanks	Polypropylene, polyethylene or PVC
Heaters	PTFE immersion, Teflon coated all with thermostatic control.

If in any doubt as to the compatibility of equipment contact PMD (U.K.) Ltd. Technical Department.

INSTALLATION

It is essential that the tanks to be used for Procirc 986 Solder Conditioner are cleaned thoroughly before any product is added.

If in any doubt as to the cleaning procedure contact PMD (U.K.) Limited Technical Department.

1. Add the required volume of Procirc 986 Solder Conditioner to the clean empty tank.
2. Add the required volume of water.
3. Mix well
4. Heat to operating temperature.

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PROCESS SEQUENCE

1. Condition using Procirc 986 Solder Conditioner.
2. Rinse.
3. Rinse.
4. Dry.
5. IR reflow, using Procirc 9902 IR Fusing Flux
or
Hot Oil Fuse using Procirc 9990 Hot Oil
Procirc 9991 Hot Oil Flux

MAINTENANCE AND CONTROL

Regular analysis should be carried out to maintain the concentration of the solution.

Concentration losses should be replaced using Procirc 986 Solder Conditioner.

Evaporation losses should be replaced using water.

ANALYSIS METHODS

Procirc 986 Solder Conditioner Concentration

Reagents

1.0 N Sodium Hydroxide
Methyl Red Indicator (0.25 g in 250 ml of 50% methanol)

Method

1. Pipette a 10 ml sample of working solution into a 250 ml conical flask.
2. Add approximately 50 ml of water and mix.
3. Add 2-3 ml of methyl red indicator and mix.
4. Titrate with 1.0 N Sodium Hydroxide to a yellow end point.
5. Record Titre = t mls

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Calculation

t x 4.83 = % concentration of Procirc 986

Replenishment

For every 1% drop in concentration, add 10ml/l Procirc 986 Solder Conditioner.

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products or product families are referred to in this data sheet.

<u>Product Name</u>	<u>Product Number</u>
Procirc 986 Solder Conditioner	987012
Procirc 9902 IR Reflow Flux	994006
Procirc 9990 Hot Oil	994004
Procirc 9991 Hot Oil Flux	994003

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