

# **PROCIRC 9902**

## **IR FLUX**

### **INTRODUCTION**

Procirc 9902 IR Flux has been specially formulated to provide effective activation of the tin/lead deposits and the exposed copper of boards during the infra-red fusing process and gives exceptional multi-layer protection against drying residues.

It produces mirror bright, flat solder coatings with good edge coverage in all makes of infra-red fusing machines.

### **BENEFITS**

Ideal for multi-layer and double sided boards.

Mirror finish with good edge coverage.

Low ionic contamination of the surface retains high insulation properties.

Low smoke characteristics.

Water soluble residues ensure clean boards even with cold water wash.

Biodegradable for environmental safety.

Excellent wetting prevents post reflow hazes caused by atmospheric oxidation.

Non foaming.

### **SOLUTION MAKE-UP**

Procirc 9902 IR Flux - Ready for use.

### **OPERATING DATA**

Specific Gravity                      0.96 - 0.98 @ 20 deg C

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### **EQUIPMENT**

Flux application by standard squeegee rollers as associated with most IR machines.

Alternative application by hand brushing.

### **INSTALLATION**

It is essential that the equipment to be used for Procirc 9902 IR Flux is cleaned thoroughly before any product is introduced. It is usual to drain the sump and wash the rollers, pipework and sump with IPA.

Fill the clean sump with Procirc 9902 IR Flux.

### **PROCESS SEQUENCE**

1. Solder condition panels using a Procirc Solder Conditioner 984 - 987.  
This is particularly applicable with oxidised tin/lead deposits.
2. Rinse.
3. Dry.
4. Procirc 9902 IR Flux squeegee application - or brush.
5. IR Flux at correct temperature.
6. Rinse.  
Cold water rinses are acceptable and soft brushes advisable.
7. Dry.

### **MAINTENANCE AND CONTROL**

The solution should be regularly checked for S.G. and maintained at the appropriate S.G. with IPA (iso-propyl alcohol) (Propan - 2 - ol).

S.G. of flux should be kept within the range of 0.96 - 0.98.

Thick multilayer boards - Procirc 9902 IR Flux should be maintained at the higher S.G. end of the range.

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### **DISPOSAL**

Dispose of in accordance with local authority requirements.

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### **PRODUCT FAMILIES**

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

<u>Product Name</u>	<u>Product Number</u>
Procirc 9902 IR Flux	994006
Procirc 984 Solder Conditioner	987006
Procirc 985 Solder Conditioner	987010
Procirc 986 Solder Conditioner	987012
Procirc 987 Solder Conditioner	987013

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