

# PMD (UK) LTD PROCESS DATA

PMD (UK) Ltd, Broad Lane, Coventry, CV5 7AY, England. Telephone 024 7646 6691 Fax 024 7647 3034  
Web Site: www.pmdgroup.co.uk Email: sales@pmdgroup.co.uk

**9977-01/03**  
**ISSUE 2**  
**PREV 1**

# **PROCIRC 9977** **(MFS 1245)** **HOT AIR LEVELLING FLUX**

## **INTRODUCTION**

Procirc 9977 (MFS 1245) is a heat stable organic flux used in vertical hot air levelling.

It is water soluble, non-foaming and is easily removed by rinsing the printed circuit boards in water.

Procirc 9977 (MFS 1245) shows very little carbonisation.

## **BENEFITS**

Non-drying, therefore blanketing the molten solder to prevent re-oxidation as well as preventing solder balls sticking to the solder mask or laminate.

First time coverage of difficult SMD pads.

High SIR-values better than  $10^{10}$  Ohm can be obtained in vertical HAL.

Complete edge coverage.

Low copper dissolution.

## **SOLUTION CHARACTERISTICS**

Specific gravity (25°C)	1.1g/cm <sup>3</sup>
Viscosity (25°C)	280cps
Flash point (COC)	300°C

## **EQUIPMENT**

Can be used in dip or roller applications.

**9977-01/03  
ISSUE 2**

**INSTALLATION**

It is essential that the tanks to be used for Procirc 9977 (MFS 1245) HAL Flux are thoroughly cleaned before any chemistry is introduced.

Contact PMD (UK) Limited Technical Department for appropriate procedure.

**PROCESS SEQUENCE**

1. Microetch in Procirc 921, 923 or SP263 Microetch.
2. Rinse.
3. Dry (Preferable).
4. Procirc 9977 (MFS 1245) Hot Air Levelling Flux application (roller or dip).
5. Solder level.
6. Wash off.
7. 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.

<u>Product Name</u>	<u>Product Number</u>
Procirc 9977 (MFS 1245) Hot Air Levelling Flux	997025
Procirc 921 Microetch	923001
Procirc 923 Microetch	927001
Procirc SP263 Microetch	923003

---

Whilst every endeavour has been made to ensure that the information given in this Data Sheet is correct, PMD (UK) Limited gives no warranty, express or implied, relating to the use or performance of this product.