

PMD (UK) LTD PROCESS DATA 9990-02/00

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PROCIRC 9990

HOT OIL

INTRODUCTION

Procirc 9990 Hot Oil is formulated, for use with Procirc 9991 Hot Oil Flux for the fusing of plated Tin Lead on Printed Circuit Boards.

BENEFITS

Procirc 9990 Hot Oil - 100% compatible with Procirc 9991 Hot Oil Flux.

Mirror tin/lead finish.

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 9990 Hot Oil - Ready to use.

OPERATING DATA

Temperature

Preheat	150°C
Reflow	210-220°C
Quench	120°C
Time	10-30 Secs
Agitation	Not Required
Extraction	Recommended

EQUIPMENT

For use in immersion only.

INSTALLATION

It is essential that the tanks to be used for Procirc 9990 Hot Oil are thoroughly cleaned before any chemistry is introduced.

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

PROCESS SEQUENCE

1. Condition in Procirc solder conditioners.
2. Rinse.
3. Dry (Preferable).
4. Procirc 9991 Hot Oil Flux application (roller or dip).
5. Pre heat Procirc 9990 Hot Oil, 10 - 15 seconds @ 150 deg C.
6. Main reflow Procirc 9990 Hot Oil, 15 - 30 seconds @ 210-220 deg C.
7. Quench Procirc 9990 Hot Oil, 10 - 15 seconds @ 120 deg 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 or product families are referred to in this data sheet.

<u>Product Name</u>	<u>Product Number</u>
Procirc 986	987012
Procirc 9870 Solder Conditioner	987014
Procirc 985 Solder Conditioner	987010
Procirc 9990 Hot Oil	994004
Procirc 9991 Hot Oil Flux	994003

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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.