

PROCIRC 9991

HOT OIL FLUX

INTRODUCTION

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

BENEFITS

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

Novel activation system for wider processing tolerance.

Mirror tin/lead finish.

Will aid the removal of etch residues and oxidation of plated tin lead.

Low viscosity for economical usage.

SOLUTION MAKE-UP

Procirc 9991 Hot Oil Flux - Ready for use.

OPERATING DATA

Specific Gravity 0.875 - 0.895 AT 20°C

EQUIPMENT

Can be used in dip or roller applications.

INSTALLATION

It is essential that the tanks to be used for Procirc 9991 Hot Oil Flux 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 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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