



Technical Bulletin

WS215 Re-flow Oil

I. Description:

WS 215 REFLOW OIL is a low viscosity, non-foaming and completely water-soluble fluid for quenching after hot air leveling. WS215 REFLOW OIL is used to cool the solder after Hal prior to rinsing.

Benefits

1. Economical Re-flow Oil
2. Excellent rinse-ability

Application

WS 215 is used in a quenching machine after hot air leveling to cool the Hal solder. The board after Hal is placed into a quenching machine then through convarized post cleaner and dried DI water is recommended for final rinsing to Ionic contamination. Rinse aids can also aid in reducing Ionic residues if necessary.

II. Operating Parameters

Make-Up	100% WS215
Temperature	RT
Immersion Time	2-5 seconds.
Process	Machine
Agitation	Not necessary
Ventilation	Not necessary
Tanks	Stainless Steel/plastic
Racks and Baskets	Not applicable.
Heaters	Not app
Filtration	Not necessary

III. Physical Properties

Specific gravity	1.12-1.14
Appearance	Clear-Amber liquid
pH	Neutral
Odor	Mild
Flash Point	<550F

IV. Control Procedures

Consumption of oil is normally limited by drag out. There is no other way of controlling or monitoring the quality of the re-flow oil. Temperature and pH (from the Hot Air Flux) degrade quenching oils.

V. Analysis

Not applicable.

VI. Safety and Storage

WS215 should be handled with care. Avoid open flames. Do not store in direct sunlight, high temperature or below freezing.

VII. Waste Treatment

Spent re-flow oils should not be bled into waste treatment systems-especially resin columns and filtration units. Normally, the spent oil is pH neutralized with caustic soda and sent to a hazardous materials waste handler for fuel blending. Consult with local officials for further waste disposal regulations

Please ask a Florida CirTech technical sales rep. for more information regarding waste treatment of this chemistry and our complete line of waste treatment line if additional help or information is desired.

VIII. Miscellaneous

Packaging comes in 5-gallon pails and 55-gallon drums. Consult MSDS sheet for additional information.

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