



WS250 Re-Flow Oil

DESCRIPTION

WS250 Reflow Oil is a low viscosity completely water soluble fluid for oil fusing or leveling. WS250 Reflow Oil is stable at leveling and fusing temperatures thus minimizing carbonization. WS250 Reflow Oil is a stabilized oil and may require some initial break in. Alternatively, add some spent oil or some flux to hasten the break in period.

BENEFITS

1. Economical Re-flow Oil
2. Long life
3. Low VOC content (<0.5%)
4. Wide operating window. Excellent for ground planes.

APPLICATION

HO351 Fusing Flux is applied to clean solder-plated printed circuit boards and allowed to drain and dry for a few minutes. The boards are then allowed to immerse horizontally in a bath of WS250 Reflow Oil kept at 400-430F until the plated surface is fused. After attaining a bright fused surface, the board should be cleaned by washing in hot water. DI water is recommended for final rinsing to lower ionic contamination. Rinse aids can also aid in reducing ionic residues if necessary. Anti-foaming agents are available to control excessive foam in rinse water.

OPERATING PARAMETERS

Make-Up	100% WS250
Temperature	400 - 430F (204 - 221C)
Immersion Time	2 - 5 seconds. Depends on boards. Until the plated solder re-flows.
Process	Batch tank
Agitation	Not necessary
Ventilation	Advised
Tanks	Stainless Steel
Racks, Baskets	Not applicable
Heater	Stainless Steel
Filtration	Not necessary



PHYSICAL PROPERTIES

Property	
Specific gravity	1.05 – 1.08
Appearance	Clear – Amber liquid
Odor	Mild
pH	Neutral
Flash Point	550F

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 low pH (from the Hot Oil Flux) degrade re-flow oils.

SAFETY AND STORAGE

WS250 should be handled with care. Avoid open flames. Do not store in direct sunlight, high temperature or below freezing.

Reference the SDS sheets for detailed information.

WASTE TREATMENT

Spent re-flow oils should not be bled into waste treatment systems, especially resin column 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 products. Do not hesitate to call for additional help or if more information is desired.

MISCELLANEOUS

Available in 5-gallon pails and 55-gallon drums. Consult SDS sheet for additional information.