



OS473 Hard Water Tolerant Developer

DESCRIPTION

OS473 is a concentrated liquid alkaline product used to develop semi-aqueous and aqueous dry films as well as liquid or dry film photoimageable solder masks. OS473 contains ingredients that soften water. Unlike many competitive products, OS473 does not contain strong chelating agents such as EDTA. Water with hardness in excess of 300 ppm (as CaCO_3) can be used with OS473 without the formation of water scale. This greatly reduces the need for maintenance of the spray equipment.

OPERATING PARAMETERS

Concentration	1.61 to 2.68% by volume OS473 (equivalent to 0.75 to 1.25% potassium carbonate)
Temperature	80° to 105° F (see technical bulletin for dry film)
Time	As required for complete development

PHYSICAL PROPERTIES

Fill the sump of freshly cleaned spray equipment to about 90% of capacity with tap water. Add the required amount of OS473. (Use the chart below to select the appropriate potassium carbonate equivalence for the dry film or solder mask to be developed.) Add about 1 ml per gallon of a suitable defoamer such as OS31R1 or OS419. Fill to final volume with tap water. Heat to desired temperature.

Technical Bulletin OS473

00:04

Page 2 of 3

Adjust the conveyer speed so that the unexposed dry film or solder mask is essentially completely removed by the time the parts are about 2/3 of the way through the developer spray zone. When development is complete, rinse thoroughly with clean water spray. Dry immediately to prevent water spotting.





POTASSIUM CARBONATE EQUIVALENCE CHART

	0.75% K₂CO₃	1.0% K₂CO₃	1.25% K₂CO₃
Gallons OS473 per 100-gallon bath	1.61	2.14	2.68
MI OS473 per liter bath	16.1	21.4	26.8

CONTROL PROCEDURES

ANALYSIS OF ACTIVE OS473 CONCENTRATION

1. Place a 25 ml sample of OS473 bath into a 250 ml beaker.
2. Add about 50 ml deionized or distilled water.
3. Using a pH meter recently standardized to pH 7, titrate with 0.1 N hydrochloric or sulfuric acid to pH 8.2.

Calculations:

Potassium Carbonate Equivalent:

ml acid x 0.056 = % by weight active potassium carbonate equivalent

Active OS473 Concentration:

ml acid x 0.119 = % by volume active OS473

Phenolphthalein indicator can be used to determine the endpoint of the titration (at pH 8.2) if a pH meter is not available.



ANALYSIS OF TOTAL OS473 CONCENTRATION

- Place a 25 ml sample of OS473 bath into a 250 ml beaker.
- Add about 50 ml deionized or distilled water.
- Using a pH meter recently standardized to pH 7, titrate with 0.1 N hydrochloric or sulfuric acid to pH 4.4.

Calculations:

Potassium Carbonate Equivalent:

ml acid x 0.028 = % by weight total potassium carbonate equivalent

Active OS473 Concentration:

ml acid x 0.059 = % by volume total OS473

Methyl Orange indicator can be used to determine the endpoint of the titration (at pH 4.4) if a pH meter is not available.

The pH of an OS473 bath is about 11.3 at makeup. As parts are processed, the pH will drop. When the pH drops below 10.4, dump and recharge the bath. If preferred, maintain the pH between 10.4 and 10.8 by feed and bleed replenishment using fresh OS473 solution at the original makeup concentration. Do not use OS473 concentrate to raise the pH of the bath.

Two percent by volume OS473 will effectively soften water with hardness in excess of 300 ppm (as CaCO₃). Tap water with substantially greater hardness may not be completely softened by OS473, but water scale formation will still be dramatically less than with ordinary developing products.

SAFETY AND STORAGE

PVC, polypropylene, stainless steel and titanium equipment may be used in contact with OS473 solutions. Heaters of stainless steel, quartz or titanium are acceptable.

OS473 is alkaline and may irritate skin and eyes. Wear safety glasses, rubber gloves, and protective clothing when handling these products. **STORE CONTAINERS OF OS473 AT 40° F OR HIGHER.** Prolonged exposure to temperatures below 40° F can cause crystallization of the ingredients.