



# WS210 Re-flow Oil

## DESCRIPTION

WS 210 REFLOW OIL is a low viscosity, non-foaming and completely water-soluble fluid for oil fusing or leveling. WS210 REFLOW OIL is stable at leveling and fusing temperatures thus minimizing carbonization. WS210 REFLOW OIL has no break-in period. Just heat to temperature and use.

### Benefits

1. Economical Re-flow Oil
2. No break-in period required.
3. Excellent rinse-ability

### Application

HO 351 or RF450 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 WS210 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.

## OPERATING PARAMETERS

Make-Up	100% WS210
Temperature	400 to 430°F (204-221°C)
Immersion Time	2-5 seconds. Depends on boards. Until the plated solder re-flows
Process	Batch
Agitation	Not necessary
Ventilation	Advised
Tanks	Stainless Steel
Racks and Baskets	Not applicable.
Heaters	Stainless Steel
Filtration	Not necessary



## PHYSICAL PROPERTIES

Specific gravity	1.14-1.16
Appearance	Clear-Amber liquid
pH	Neutral
Odor	Mild
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 pH (from the Hot Oil Flux) degrade re-low oils.

## ANALYSIS

Not applicable.

## SAFETY AND STORAGE

WS210 should be handled with care. Avoid open flames. Do not store in direct sunlight, high temperature or below freezing.

## 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.

## MISCELLANEOUS

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