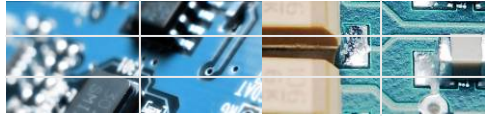




CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL



The parameters below are from actual cleaning trials using Kyzen cleaning materials with specified INTERFLUX solder paste and process parameters.

AQUEOUS INLINE PROCESS PARAMETERS: Recommended Kyzen Solutions

Aquanox A4520	Material Form	Wash Conc.	Wash Time	Wash Temp.	Rinse	Drying
Interflux Pacific 2009M	Wave Flux	12-15%	2-5 minutes	140-150°F	DI-Water	Circulating Air

Aquanox A4625	Material Form	Wash Conc.	Wash Time	Wash Temp.	Rinse	Drying
Interflux Pacific 2009M	Wave Flux	8-13%	2-5 minutes	130-150°F	DI-Water	Circulating Air

AQUEOUS BATCH SPRAY-IN-AIR (DISHWASHER STYLE):

Aquanox A4625B	Material Form	Wash Conc.	Wash Time	Wash Temp.	Rinse	Drying
Interflux Pacific 2009M	Wave Flux	12-15%	8-15 minutes	130-150°F	DI-Water	Circulating Air

Booster 20 is a sump side additive designed for batch cleaning processes. When cleaning in batch systems, longer wash times are needed. Booster 20 improves cleaning efficacy and provides added protection to the solder, aluminum, copper and all other alloys. The recommended usage level is 100-200 ml or 2-5 ounces when charging a common batch dishwasher style cleaning system.

ULTRASONIC CLEANING PROCESS PARAMETERS: Recommended Kyzen Solutions

Aquanox A4651US	Material Form	Wash Conc.	Wash Time	Wash Temp.
Interflux Pacific 2009M	Wave Flux	30%	30 minutes	145°F

Data generated using 40 kHz ultrasonic energy.

- ◆ ALL APPLICATION RECOMMENDATIONS ARE INTENDED FOR GUIDELINE USE ONLY



CLEANING PROCESSES FOR FLUX & SOLDER PASTE REMOVAL

SPRAY UNDER IMMERSION PROCESS: Recommended Kyzen Solutions

Micronox MX2302	Material Form	Wash Conc.	Wash Time	Wash Temp.	Rinse	Drying
Interflux Pacific 2009M	Wave Flux	100%	5-10 minutes	130-150°F	DI-Water	Circulating Air

VAPOR DEGREASING PROCESS:

Micronox MX2501	Material Form	Boil Sump	Rinse Sump	Vapor	Drying
Interflux Pacific 2009M	Wave Flux	5-10 minutes	3 minutes	2 minutes	Vapor Blanket

Ionox 3955	Material Form	Boil Sump	Rinse Sump	Vapor	Drying
Interflux Pacific 2009M	Wave Flux	5 minutes	3 minutes	2 minutes	Vapor Blanket

Application recommendations are intended to serve as only a guideline. To request a free-of-charge cleaning trial, expert cleaning process optimization or additional cleaning material information, please contact Kyzen Corporation.



Testing performed in Kyzen's fully staffed and equipped applications laboratory located in Nashville, TN.



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