



WS735



Water Soluble Flux

Features:

- Non-Spattering Formula
- High Activity and Excellent Wetting
- Wide Process Window
- Foam Resistant Residues

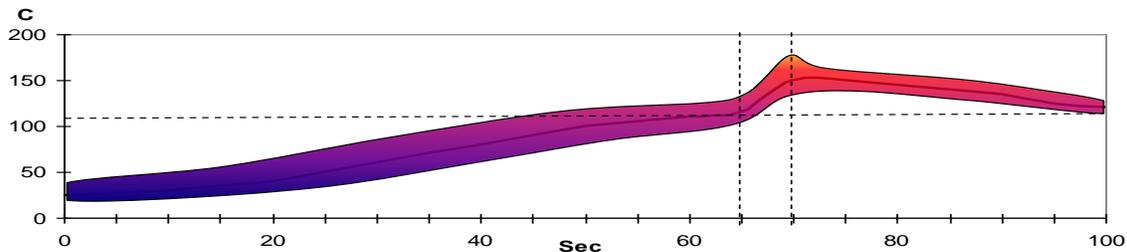
Description:

WS735 is an alcohol based, organically activated, water-soluble liquid flux designed specifically for wave solder applications. WS735 may be applied by automated flux sprayers, foamed, dipped, or brushed on with favorable results. WS735 is active at room temperature and maintains a wide activation range and exceptional wetting characteristics that produce bright shiny solder joints. WS 735 performs well with bare copper, solder coated, and organic coated pwbs. WS735 may be utilized with tin-lead and lead-free solder alloys. Since WS 735 flux is still active post-processing, all residues must be removed from PCBs.

Flux Application:

WS735 can be used in dipping, spraying, brushing, swabbing, and many other fluxing operations. For spraying, WS735 is ready to use directly from its container, no thinning required. When spray fluxing, it is imperative that proper flux coverage and uniformity be achieved and maintained. A dry flux coating of 500 to 1500 micrograms per square inch is recommended as a starting point. If thinning is necessary, AIM 735 Thinner should be used.

Typical Thermal Profile:



RATE of RISE 2-3 °C / SEC MAX	PROGRESS THROUGH 66°C - 77°C (150 - 170°F)	PCB TOP SIDE TEMP 87°C - 115°C (190°F - 240°F)	COOLDOWN ≤ 4°C
	≤ 40 SECONDS	JUST BEFORE WAVE	

Cleaning:

The residues and raw flux are completely water soluble and should be washed in an aqueous cleaning system using deionized or distilled water heated to a recommended temperature of at least 60° C.

Handling and Storage:

- WS735 has an unopened shelf life of 1 year when stored at room temperature. Do not freeze this product.
- WS735 is shipped ready-to-use, no mixing necessary.
- Do not mix used and unused chemical in the same container. Reseal any opened containers.

Safety:

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying **Material Safety Data Sheet** for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

Physical Properties:

Parameter	Value
J-STD-004	ORH1
Visual	Clear, Colorless
Odor	Aromatic (Slightly)
Solids Content	23.1 %

Parameter	Value
Specific Gravity	.9979 ± 0.005 (water = 1)
Flash Point	< 10°C
Boiling Point	82°C
pH (1% solution /water)	1.28

Corrosion Testing:

Parameter	Requirements	Results
Copper Mirror (24 hrs @ 25°C, 50%RH)	IPC-TM-650-2.3.32	High
Halide Test (Silver Chromate)	IPC-TM-650-2.2.33	Halides Present

Manufacturing and Distribution Worldwide

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AIM IS ISO9001:2008 & ISO14001:2004 CERTIFIED

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