

# BLT 10-95-WS

*Water Soluble, neutral pH wave soldering flux  
for Lead Free and Tin Lead*



## PHYSICAL PROPERTIES

Colour	● Pale Yellow
SG @ 20°C	● 0.81
Solids content	● 14.0%
Flash point	● 12°C
Classification	● ORHI to IPC J-STD004

## PROCESS CONTROL

*Maintain the SG at 0.81 by the addition of Thinner 16-3000.  
Change flux every 40-50 hours of use.*

## APPLICATION

*BLT 10-95-WS should be applied by spray or foam and is  
supplied ready for use.*

*Following are guidelines for spray applications:*

Parameters	Recommendations
Spray nozzle	Coarse
Top side pre-heat	90 - 150°C
Conveyor speed	0.8 - 1.6m/minute
Conveyor angle	6 - 7 (optimum 6.5°)
Solder contact time	2-5 Seconds (optimum for Lead Free 2-4 secs)
Solder bath temperature	Lead Free 260-280°C Tin/Lead 63/37 240-250°C

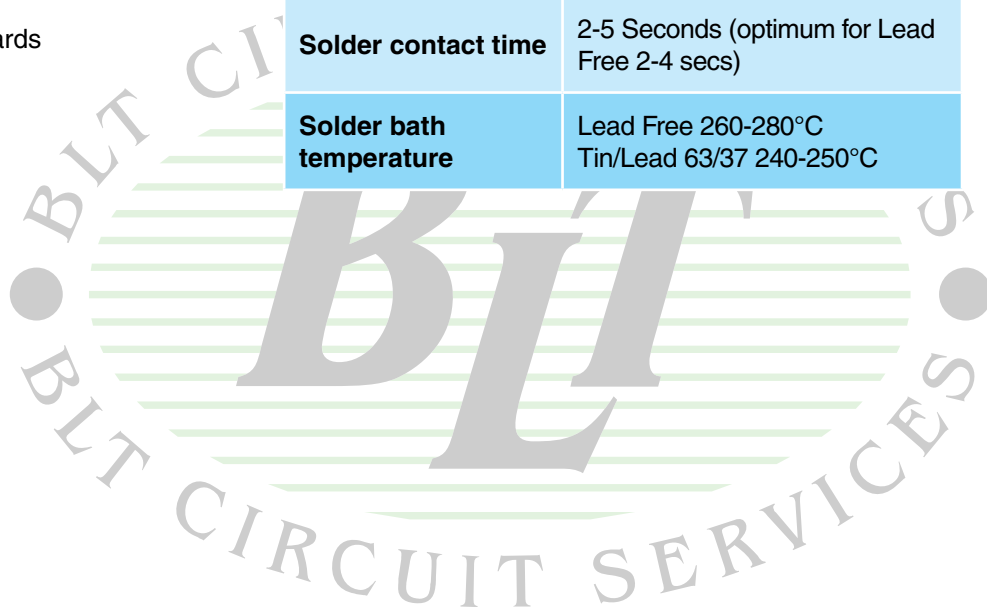
## DESCRIPTION

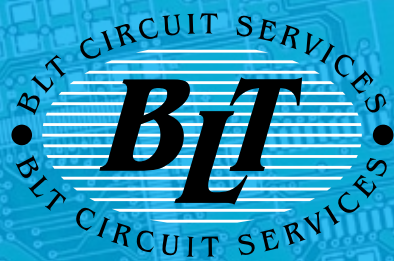
*BLT 10-95-WS is a neutral, buffered, organic activated, rosin free  
flux for wave soldering using Lead Free or Tin Lead alloys.*

*BLT 10-95-WS is suitable for foam or spray application and has a  
wide process window.*

## BENEFITS

- High activity level
- Neutral pH
- J-ST004 ORH1 Classification
- Wide process window
- Excellent wetting
- Rinses freely
- Suitable for spray & foam application
- For oxidised and difficult to solder boards
- No solder balling





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## CLEANING

*BLT 10-95-WS must be removed after soldering. Tap water at 35-60°C can be used but de-ionized water is recommended and necessary for the final rinse. In line conveyorised pressure rinsing is preferred but BLT 10-95-WS can be cleaned by immersion in warm water. For optimum efficiency use BLT Flux Saponifier 1990 followed by de-ionised water rinsing.*

Specification	Test Method	Result
Solids content	IPC-TM-6502.3.34	14%
pH	20°C	7.6
Copper mirror	IPCTM-6502.3.32	HI
Colour		Pale yellow

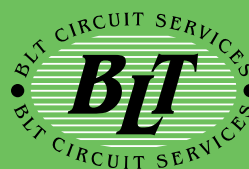
## HANDLING PRECAUTIONS

*BLT 10-95-WS contains Isopropyl Alcohol and is highly flammable. Use in a well ventilated area and keep away from heat and naked flames.*

*Take precautions to avoid static build up and discharge. Refer to separate Health & Safety data sheet.*

### Warranty

*All reasonable endeavours have been made to ensure that the information contained in this data sheet is accurate, but it is submitted on the express condition that BLT Circuit Services Ltd., shall be under no liability whatsoever in respect thereof or for any loss, injury, damage or liability of whatsoever nature arising, suffered or incurred as a consequence of its use.*



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