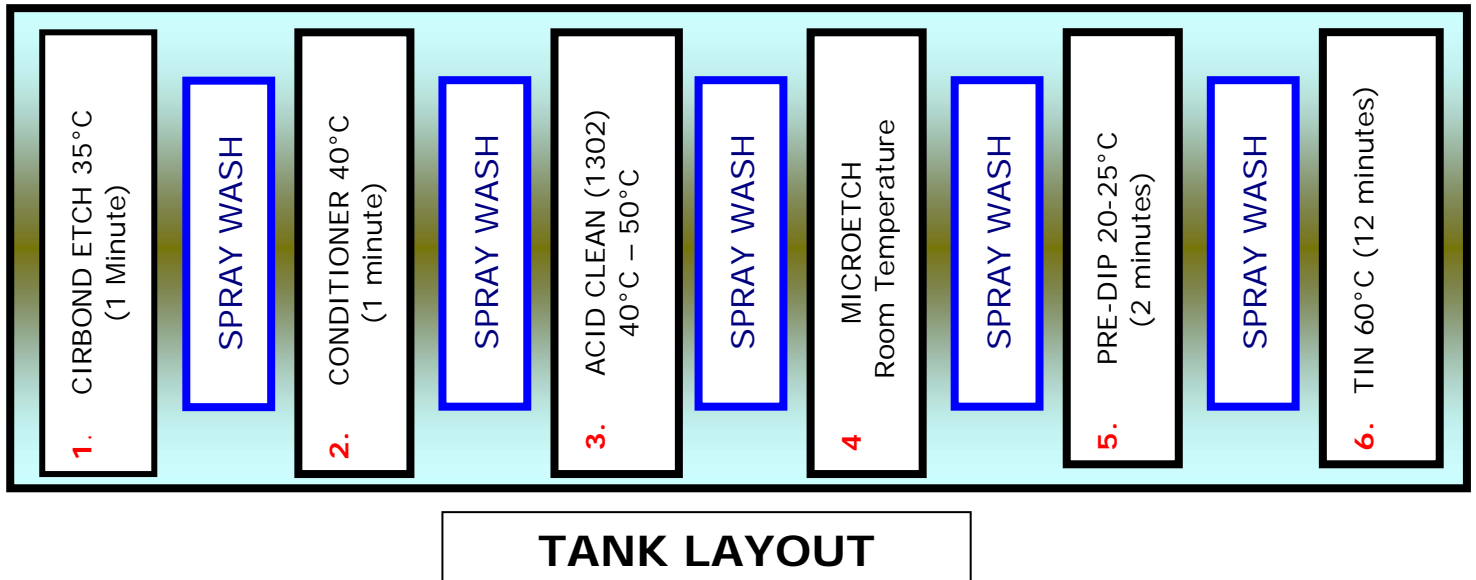




# Inner Layer Oxide Treatment and Tinning Line

*User Guide*

# INNER LAYER OXIDE TREATMENT AND TINNING LINE



## INNER LAYER OXIDE TREATMENT BATH MAKE-UP for 5 Litre Tank

### TANK 1 - CIRBOND 9550

**Operating Temperature:** 35°C  
**Immersion Time:** 1 Minute  
**Chemical Make-up:**

Add 2 litres of Cirbond 9550 (part A) to tank then 650ml Cirbond 9550 Part B. Finally make-up to 5 litres with De-ionised Water.

### TANK 2 - CONDITIONER

**Operating Temperature:** 40°C  
**Immersion Time:** 1 Minute  
**Chemical Make-up:**  
Use as supplied.

### TANK 3 - ACID CLEANER

**Operating Temperature:** 40°C - 50°C  
**Immersion Time:** 2 Minutes  
**Chemical Make-up:**  
Mix 4: 1 with deionised water.

## PROCESS

- 1) Place inner layout etched board in the 1302 Acid Cleaner Tank 3 at 40°C 50°C for 2 minutes. Remove and spray wash for 1 minute.

- 2) Place in 9028 Conditioner Tank 2 for 35-45°C for 1 minute. Remove and spray Rinse for 1 minute.
- 3) Place in the Cirbond 9550 Tank 1 at 35°C for 1 minute. Remove and spray wash for 1 minute.
- 4) Dry the board with paper towels and then with hair-dryer or place in oven at 60°C – 70°C for 1 minute.

## **IMMERSION TINNING PROCESS BATH MAKEUP for 5 Litre Tank**

### **TANK 4 - MICRO-ETCH (ABC)**

**Operating Temperature:** 30-35°C

**Immersion Time:** 2 Minutes

**Chemical Make-up:** Makeup with de-ionised water at 100 grams per Litre.

### **TANK 5 - PRE-DIP 7000**

**Operating Temperature:** 20 - 25°C

**Immersion Time:** 1 Minute

**Chemical Make-up:** Add 250ml of pre-dip 7000 to the tank then 125ml 7000 Buffer. Finally make-up to 5 litres with de-ionised water.

### **TANK 6 - TIN SOLUTION (CSN 7001)**

**Operating Temperature:** 60°C

**Immersion Time:** 12 Minutes

**Chemical Make-up:** Use as supplied.

## **PROCESS**

- 1) With oscillating frame running, place the board in the acid clean Tank 3 for 2 minutes. Remove and rinse for 1 minute.
- 2) Place Board in Micro-etch Tank 4 at 30-35°C for 2 minutes, remove and Spray Wash for 1 minute
- 3) Place in Pre-Dip Tank 5 at 20-25°C for 1 minute. Remove and Spray Wash for 1 minute.
- 4) Place in Tin Tank 6 at 60°C for 12 minutes. Remove Spray Wash with warm water and then cold water and Static De-ionised Rinse. Finally dry with paper towels and warm air.



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