

# ALPHA<sup>®</sup> AQUALINE WS-619 Paste Flux

## BGA Flux

### APPLICATION GUIDELINES

**Viscometry (Spiral/Malcom)** ~300 Poise @ 30 RPM

#### Residue Removal

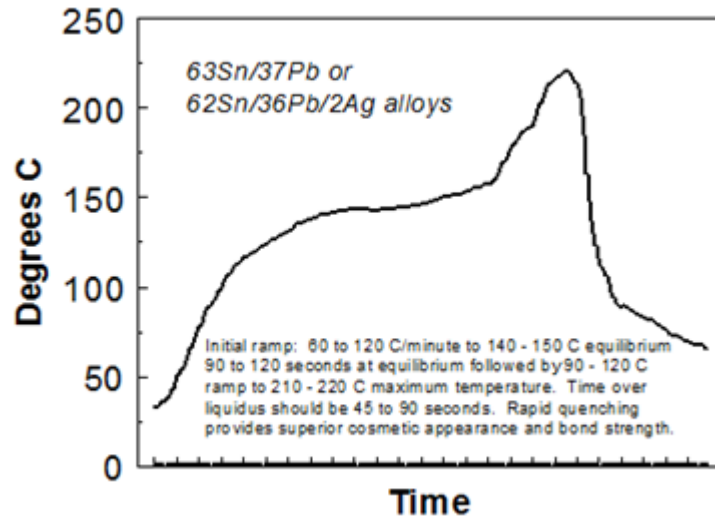
Water at less than 140 °F without saponifier is suitable to achieve excellent results. Spray pressures of 35 to 65 PSI are sufficient to remove all residues. Cleaning results using ALPHA WS-619 may exceed those achievable using traditional RMA materials. Ionic contamination readings as low as 2.0 µgrams per square inch are possible with this very cleanable flux.

### TECHNICAL DATA

Category	Results
<b>Physical &amp; Chemical Properties</b>	
Color	Deep Amber
Tack Strength	~ 15 grams/mm <sup>2</sup>
Stencil Life	~ 8 hours (@ 40-60% RH and 20-25°C)
Halide Content	Halide Free
pH, Flux Residues	6.8 Typical
SIR (ohms) 7 DAYS	>10 <sup>9</sup> , cleaned, 85°C/85% RH (pass >10 <sup>7</sup> )
Wetting Balance	Faster than traditional RMA's
Carrier Resin	Completely Water Soluble

**REFLOW PROFILES**

Sample Profile is indicated below for Convection Reflow Furnaces:



**RECYCLING SERVICES**

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



**SAFETY & WARNING**

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at [MacDermidAlpha.com/assembly-solutions/knowledge-base](http://MacDermidAlpha.com/assembly-solutions/knowledge-base).**

**STORAGE**

This flux should be stored in sealed containers and need not be refrigerated. Temperatures above 80 °F or 27 °C should be avoided. Shelf life of unopened containers is nominally 6 months. If refrigeration is used to store the flux, temperatures below 5 °C should be avoided. Upon removal from refrigeration, the container should be allowed to reach room temperature before opening in order to prevent moisture condensation from ambient air onto the flux.

**CONTACT INFORMATION**

**To confirm this document is the most recent version, please contact  
 Assembly@MacDermidAlpha.com**

[www.macdermidalpha.com](http://www.macdermidalpha.com)

<p><b>North America</b>          109 Corporate Blvd.          South Plainfield, NJ 07080, USA          1.800.367.5460</p>	<p><b>Europe</b>          Unit 2, Genesis Business Park          Albert Drive          Woking, Surrey, GU21 5RW, UK          44.01483.758400</p>	<p><b>Asia</b>          8/F., Paul Y. Centre          51 Hung To Road          Kwun Tong, Kowloon, Hong Kong          852.3190.3100</p>
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE . Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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