



ELECTRONIC SOLDERS

BOW WS-1240 Water Soluble Solder Paste

Product Description

- Synthetic materials
- Long stencil life
- Wide reflow process window
- Compatible with most board finishes
- Designed for high temperature alloys with easy to clean residues
- Excellent wetting
- IPC Flux Designation REM0

Alloys

Manufactured with low-oxide, spherical and uniformly sized powder. Bow WS-1240 is available in the following alloys: Sn5/Pb92.5/Ag2.5, Sn95/Sb5, Sn10/Pb88/Ag2, and Sn5/Pb95.

Powder Distribution

Micron Size	Type	Pitch Requirements
75 – 45	Type 2	24 mil & above
45 – 25	Type 3	16 mil to 24 mil
38 – 20	Type 4	12 mil to 16 mil

Micron Size	Type	Pitch Requirements
25 – 15	Type 5	< 12 mil
15 - 5	Type 6	< 8 mil

Available Packaging

The following packaging options are available for stencil printing and dispensing applications: 250g and 500g jars; 250g and 700g cartridges; 750g ProFlow® cassettes, 35g and 100g syringes.

Stencil Life

- > 8 hrs. @ 30-45% RH & 22-25°C
- ≈ 4 hrs. @ 45-70% PH & 22-25° C

Viscosity

Printing applications: 500 to 700 Kcps +/- 10%

Dispensing applications: 400 Kcps +/- 10%

Tested according to IPC-TM-650

Tack Value

Typical tackiness 37g force

Printing

The print definition of Bow WS-1240 is ideal for fine pitch applications. The stencil life of this water soluble product virtually eliminates the waste of solder paste. Consult the powder distribution chart to determine your mesh size requirements.

Printer Operation

The following are general guidelines for stencil printer optimization with Bow WS-1240. Some adjustments may be necessary based on your process requirements.

- Print Speed: 25-100 mm/sec
- Squeegee Pressure: 0.2-0.7 kg/inch of blade
- Under Stencil Wipe: Once every 10-25 prints or as necessary.

Stencil Cleaning

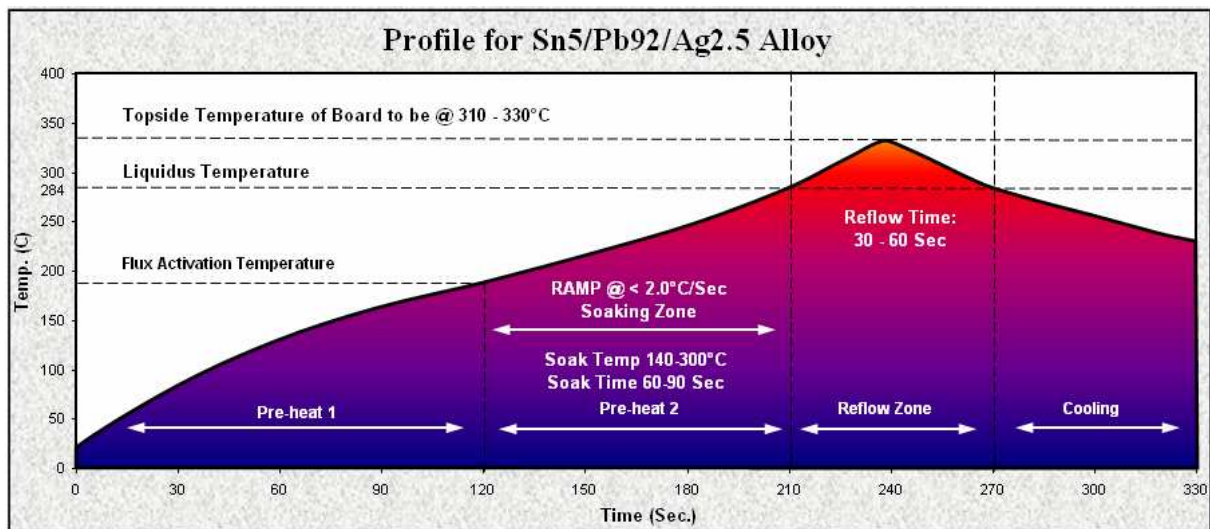
Automated stencil cleaning systems for both stencil and misprinted boards. Manual cleaning using water at 60°C or 99% isopropyl alcohol (IPA). Post-reflow cleaning using water at 60°C with 50 PSI pressure.

Storage and Handling Procedures

Refrigerated storage at 42-47° F will prolong the solder paste shelf life to no longer than 6 months. Syringes & cartridges should be stored vertically with the dispensing tip down. Solder paste should be allowed to reach ambient temperature naturally, prior to use (about 6-8 hours). NEVER FREEZE SOLDER PASTE.

Recommended Profiles:

The profile was designed to serve as a starting position for process optimization using Bow WS-1240. A cool down rate of (-) 2-4 C°/second is ideal for the formation of a fine grain structure without risking damage to thermally sensitive components.



Refer to the MSDS for additional safety information.

The information contained herein is based on data consideration to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Bow Electronics control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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