

Co-Solvent Cleaning Agent

Product Highlights

- Compatible with all soldering flux chemistries and metal layers.
- The use of HMT-165CS as a co-solvent with HMT-55CS HFE highly increases its cleaning and drying performance.
- Removes fluxes, oils, and greases.
- Long Bath Life
- Effective Cleaning of densely populated assemblies

SPECIFICATIONS AND CHARACTERISTICS

Characteristic/Property	Unit	Value	Test Method
Flash Point (PMCC)	°C	82	ASTM D 93
Density at 20°C	Kg/m ³	1011	ASTM D 4052
Aspect		Colorless Liquid	Visual
Boiling Range	°C	150	ASTM D 1078
Water Content	% (weight)	< 0.1	ASTM E 1364
Aromatic Compounds	% (weight)	< 0.1	SMS 2728
NVR	g/100 ml	< 0.01	ASTM D 1353

PROCESS PARAMETERS

HMT-165CS is a broad-spectrum cleaning agent that has been designed as a waterless, non-flammable solvent for use in vapor phase equipment for defluxing of solder flux residues after die attach, flip chip or SMT reflow.

HMT-165CS can be applied via immersion, spray or ultrasonic methods.

Application guideline and recommendations for a SEPARATED CO SOLVENT PROCESS

Step 1: CLEANING	HMT-165CS (pure) 55°C
Step 2: RINSING	HMT-55CS HFE at 55°C
Step 3: RINSING	HMT-55CS HFE at 45-50°C
Step 4: DRYING	HMT-55CS HFE at 55°C (Vapor Phase)

PCBA defluxing is recommended prior to the application of Conformal Coatings. Boards are completely dried after co-solvent process with no additional needs for baking or curing. Cleaning performance complies with: IPC-A-610E Visual Cleanliness / J-STD-001 Ionic Cleanliness / Surface Insulation Resistance by IPC-TM 650 2.6.3.7 and DIN 32513

STORAGE AND SHELF LIFE

Product should be stored in original sealed containers between 10-50°C. Shelf life under stated conditions is 24 months.

PACKAGING

Container Sizes	1-gallon pail, 5-gallon pail, 55-gallon drum
-----------------	--

HEALTH AND SAFETY

HMT-165CS is RoHS compliant and Halogen-free in accordance with RoHS Directive (EU) 2015/863 and EN 14582:20126. **HMT-165CS** is not considered a flammable product, however it can burn. All relevant measures against fire risk should be implemented.

HMT-165CS has a low environmental impact and is not regulated as an Ozone Depleting Chemical in the United States and Canada and is not listed as a Hazardous Air Pollutant.

Please refer to the Safety Data Sheet (SDS) before use. Safety data sheets can be found at www.hmtsolder.com

This data is based on information that the manufacturer believes to be reliable and offered in good faith. In no event will HMT be responsible for special, incidental and consequential damages. The user is responsible to the Administrative Authorities (regulations for the protection of the Environment) for the conformity of his installation.

© 2020-2021 HMT Solder™ Inc.