

PRODUCT DATA SHEET

WS-446-BK

Water-Soluble Ball-Attach Flux

Introduction

WS-446-BK is a water-soluble ball-attach flux designed for use in pin transfer applications for ball-attachment to substrates (BGA manufacturing). Its rheology is specifically designed for use with even the smallest gravity-fed spheres. **WS-446-BK** has an activator system powerful enough to promote wetting on the most demanding substrate metallizations. **WS-446-BK** contains black dye, which aids pick and place equipment in detecting place locations on the die.

Features

- Designed for ball-attach pin transfer applications
- Flux rheology applicable for all sphere sizes
- Excellent solderability on a wide range of surfaces
- Water-soluble
- Contains black dye for ease of pick and place detection

Application

The amount of **WS-446-BK** flux deposited on the substrate can be optimized by changing equipment parameters. Key variables include pin shape, pin diameter, shear speed, dwell, and depth of immersion. The flux rheology can be optimized for desired application by shearing to achieve the desired viscosity.

Properties

| | Value | Test Method |
|----------------------------|--|--|
| Flux Type Classification | ORH1 | J-STD-004 (IPC-TM-650: 2.3.32 and 2.3.33) |
| Typical Viscosity | 11kcps (5min) | Brookfield Viscosity HBDVII+CP51 (5min) @ 5rpm, 25°C |
| SIR (Ohms, after cleaning) | Pass (>10 ⁹ after 7 days @ 85°C and 85% RH) | J-STD-004 (IPC-TM-650: 2.6.3.3 IPC-B-24) |
| Typical Acid Value | 72mg KOH/g | Titration |
| Typical Tack Strength | 170g | J-STD-005 (IPC-TM.650: 2.4.44) |
| Shelf Life | 6 months (-20–10°C) | Viscosity change/ microscope examination |

All information is for reference only.

Not to be used as incoming product specifications.

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All of Indium Corporation's solder paste and preform manufacturing facilities are IATF 16949:2016 certified. Indium Corporation is an ISO 9001:2015 registered company.

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Contact our engineers: askus@indium.com

Learn more: www.indium.com

ASIA +65 6268 8678 • CHINA +86 (0) 512 628 34900 • EUROPE +44 (0) 1908 580400 • USA +1 315 853 4900

Cleaning

WS-446-BK residue can be cleaned with DI water or water with an added cleaner. Ideal conditions for spray cleaning: 25°C (room temperature) or higher for >1 minute at >60psi.

Packaging

WS-446-BK is available in 150g (6 fl. oz.) and 300g (12 fl. oz.) cartridges. Other packaging can be provided to meet the customer's specific requirements.

Storage

For maximum shelf life, **WS-446-BK** syringes and cartridges should be stored tip down between –20°C and 10°C for maximum shelf life. Storage temperatures should not exceed 25°C for more than 4 days, and should never exceed 30°C. After removing from cold storage, **WS-446-BK** should be allowed to stand for at least 4 hours at room temperature before using.

Technical Support

Indium Corporation sets the industry standard in providing rapid response, onsite technical support for our customers worldwide. Indium Corporation's team of Technical Support Engineers can provide expertise in all aspects of materials science and semiconductor packaging process applications.

Safety Data Sheets

Please refer to the SDS document within the product shipment, or contact our local team to receive a copy.



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