



AIMTERGE 6035



Aqueous Cleaner

Features:

- Works Hot or Cold
- Corrosion Inhibited
- For Cleaning Solder Paste, Flux, and Wire Residues
- Recommended for All Chemistries

Description:

AIMTERGE 6035 cleaner is a saponifier formulated to readily remove resin, rosin, no clean and water soluble flux residues from printed circuit boards, while preventing the attack of components and aluminum hardware common with many saponifiers. AIMTERGE 6035 cleaner works with the co-solvency action of alkaline saponification and solvent solubilization. The removal of water-soluble organic acid flux residues is facilitated with the use of this product's neutralizing and wetting properties. AIMTERGE 6035 is recommended especially for the removal of no-clean chemistries.

Application:

- AIMTERGE 6035 is suitable for in-line spray cleaning systems, batch soak tanks, and modified dishwashers.
- A thorough final rinse is vital (deionized water is recommended) for removing flux residues liquefied by the AIMTERGE wash. Levels of cleanliness are affected by the condition of the rinse water flow rate.
- Prior to drying assemblies, the use of an air knife to remove excess water will facilitate force drying and enhance the final ionic cleanliness.

TYPICAL WORKING SOLUTIONS BY VOLUME

RESIDUE	MACHINE	% AIMTERGE	TEMPERATURE
Rosin	In-Line Spray	10%	60° C (140° F)
Rosin	Batch	20%	60° C (140° F)
Organic Acid (OA)	Conveyorized	5-7%	60° C (140° F)
Rosin/OA	Soak Twin	25%	Ambient - 60° C (140° F)

Control:

- In automated systems, the concentration of AIMTERGE 6035 cleaner in the wash tank will be diminished by ongoing flux removal and will be diluted by automatic water additions replacing drag-out.
- Bath strength should be replenished with periodic additions or continuous metering of AIMTERGE 6035 cleaner into the wash tank. Monitoring of bath concentration can be done using a standard alkaline titration procedure. After 8-16 hours of continuous use in non-closed loop cleaning systems, the wash solution will become saturated with rosin soap and should be changed.
- AIMTERGE 6035 is not for use in closed-loop cleaning systems containing resin beds for filtration.

Titration:

This is a simple method to control the concentration of saponifier in cleaning equipment. The procedure utilizes the Hach Digital Titrator. This device uses pre-packaged cartridges of test solutions, making test results safe and accurate.

Procedure:

1. Attach a clean, straight-stem delivery tube to a 7.95 normal Hydrochloric Acid (HCl) cartridge. Twist cartridge onto Digital Titrator body.
2. Flush the delivery tube by turning the coarse delivery knob to eject a few drops of titrant (7.95 normal Hydrochloric Acid). Turn left hand knob clockwise until zero reading is present and wipe the tip.

3. Bath make-up control: Take a sample from a freshly made-up bath of AIMTERGE and water. Transfer 3.7 ml into a test tube or flask (be sure that this solution is below 100°F).
4. Add 1 drop of phenolphthalein indicator to the AIMTERGE sample and swirl to mix.
5. Place the stir-bar into the flask and set flask on the Titra-Stir. Turn on the stirrer and mix the solution until the AIMTERGE sample changes from a violet color to a uniform water-white, colorless condition (End Point). If the Titra-Stir is not available, the flask should be swirled by hand for 10-15 seconds.
6. Note the number in the Digital Titrator window. This number, divided by 10, is the control titration number and indicates the strength of a fresh solution.
7. Press the plunger release button and manually retract the plunger into the body of the titrator.
Remove the cartridge
Remove the delivery tube and reseal the cartridge with the cap.
8. Bath Maintenance: Bath maintenance can be monitored using the above procedure. Specific titration numbers are only of value when determined and correlated for the individual process and application. This control process is very effective since the titration number and the percentage of AIMTERGE in water is proportional to the solution strength.
9. Dumping Point: The bath will eventually become saturated and ineffective. The dumping point is related to a quantity of piece parts or batches processed. Consistent processing will require selecting a dumping point within the window of effective performance.

Example: If your starting point of a 10% solution of AIMTERGE has a titration number of 20 and falls to a titration number of 10, the amount of AIMTERGE needed to get back to your starting point would be 50% of AIMTERGE originally added to make the 10% solution.

Equipment Maintenance:

Aqueous cleaning equipment will accumulate mineral deposits, commonly known as “scale”, from the use of untreated tap water. Periodic de-scaling will assist in maintaining the washing systems effectiveness and efficiency.

Packaging:

AIMTERGE 6035 is available in 1, 5 and 55 gallon containers.

Handling:

- AIMTERGE 6035 has a sealed shelf life of 2 years when stored at room temperature.
- Do not store near fire or flame.
- Keep away from sunlight as it may degrade the product.
- Do not mix used and unused product in the same container.

**Please be aware that these fluxes are toxic and cannot be shipped via UPS or FedEx under any circumstances in any quantity. These can only be shipped via truck freight and cannot be expedited.*

Safety:

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying Material Safety Data Sheet for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

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AIM IS ISO9001:2008 & ISO14001:2004 CERTIFIED

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