

# CASCADE

## WATER-SOLUBLE GEL "CASCADE 1"



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**CASCADE 1 water-soluble gel** is carefully formulated to confer high activity soldering. Its residues can be easily removed with deionised water.

- Halide-free
- Water-washable residues
- High activity
- Very good tack-life = 16 hours

**CASCADE 1 water-soluble gel** is made to strict quality assurance standards.

Alloy

**CASCADE 1 water-soluble gel is also available in solder paste with lead or lead free alloys.**

### Printing

#### **Stencil**

Stainless steel, brass or nickel. Chemical etched, laser cut or electroformed.

#### **Squeegee**

Stainless steel or 80-100 durometer polyurethane.

### Dispensing

Manual or automatic syringes available in different capacities.

Automatic operating pressure of 0.5 to 3 bars.

### Reflow

#### **Heating Methods**

Convection, infrared, vapour phase, hot plate, hot bar, induction, laser and others. Aerobic or inerted.

#### **Heating Profile**

See suggested reflow profile for specific alloy.

### Cleaning

The post-soldered residue of **CASCADE 1** is not particularly corrosive but is hygroscopic. Removal is necessary. This can be done by dishwasher, spray or immersion using cold or warm deionised water wash followed by rinsing with deionised water. Hot air dry.

#### **Temperature**

35-60°C

### Packaging

Jars of 250g, 500g

Cartridges of 700g

Manual syringes of 5cc or 10cc

Automatic syringes of 5cc, 10cc or 30cc

Other on request

### Storage

In original container between 2 and 10°C for up to 6 months. Wait until the pot has reached the ambient temperature before opening to avoid water condensation on the surface of the paste. Once opened, do not return to the fridge, then can be kept at ambient conditions for one week.

### Additional information

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in Europe).

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