

PRODUCT DATA SHEET

Indium10.5HF

Pb-Free Solder Paste

Introduction

Indium10.5HF is no-clean solder paste, specifically formulated for today's Pb-free (Sn-based) alloys for PCB assembly in nitrogen or air reflow. Flux residues remain soft, pliable, yet non-tacky after reflow in order to provide the best in-circuit testing (ICT) performance. **Indium10.5HF** offers industry-leading stencil printing performance (excellent response-to-pause and consistent printing even at high print speeds). Oxidation barrier technology delivers superior solderability and wetting on many surface finishes.

Features

- Pliable post-reflow residue designed for in-circuit probe testing
- Non-tacky flux residue to avoid buildup on probes
- Excellent stencil printing and HIP performance
- Eliminates clogged apertures through advanced rheology
- Superior solderability and wetting on many surface finishes
- High oxidation resistance
- Halogen-free per EN14582 test method

Alloys

Indium Corporation manufactures low-oxide spherical powder composed of a variety of Pb-free alloys that cover a broad range of melting temperatures. This document covers Types 3 and 4 powders as standard offerings with SAC alloys. The metal percent is the weight percent of the solder powder in the solder paste and is dependent upon the powder type and application.

Standard Product Specifications

Alloy	Metal Load	
	Type 3	Type 4
95.5Sn/3.8Ag/0.7Cu (SAC387)	89%	88.75%
96.5Sn/3.0Ag/0.5Cu (SAC305)		
98.5Sn/1.0Ag/0.5Cu (SAC105)		
99Sn/0.3Ag/0.7Cu (SAC0307)		

J-STD Tests and Results

Test	Result	Test	Result
J-STD-004 (IPC-TM-650)		J-STD-005 (IPC-TM-650)	
Flux Type (per J-STD-004A)	ROLO	Typical Solder Paste Viscosity (SAC305, T4, 88.75%) Malcom (10rpm)	1,300 poise
Presence of Halide Oxygen Bomb followed by Ion Chromatography	<<500ppm Br- <<500ppm Cl-	Slump Test	Pass
SIR	Pass	Solder Ball Test	Pass
		Typical Tackiness	45g
		Wetting Test	Pass

All information is for reference only.
Not to be used as incoming product specifications.

Compatible Products

- **Rework Flux:** TACFlux® 089HF, TACFlux® 020B
- **Cored Wire:** CW-807
- **Wave Flux:** WF-9945, WF-9958

Note: Other products may be applicable. Please consult one of Indium Corporation's Technical Support Engineers.

Storage and Handling Procedures

Refrigerated storage will prolong the shelf life of solder paste. Solder paste packaged in cartridges should be stored tip down.

Storage Conditions (unopened containers)	Shelf Life
<10°C	6 months

Solder paste should be allowed to reach ambient working temperature prior to use. Generally, paste should be removed from refrigeration at least 2 hours before use. Actual time to reach thermal equilibrium will vary with container size. Paste temperature should be verified before use. Jars and cartridges should be labeled with date and time of opening.

Packaging

Indium10.5HF is currently available in 500g jars or 600g cartridges. Packaging for enclosed print head systems is also readily available. Alternate packaging options may be available upon request.

Technical Support

Indium Corporation's internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Material Science as it applies to the electronics and semiconductor sectors, Technical Support Engineers provide expert advice in solder preforms, wire, ribbon, and paste. Indium Corporation's Technical Support Engineers provide rapid response to all technical inquiries.

Safety Data Sheets

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

From One Engineer To Another®



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Printing

Stencil Design:

Electroformed and laser cut/electropolished stencils produce the best printing characteristics among stencil types. Stencil aperture design is a crucial step in optimizing the print process. The following are a few general recommendations:

- Discrete components—A 10–20% reduction of stencil aperture has significantly reduced or eliminated the occurrence of mid-chip solder beads. The “home plate” design is a common method for achieving this reduction.
- Fine-pitch components—A surface area reduction is recommended for apertures of 20mil pitch and finer. This reduction will help minimize solder balling and bridging that can lead to electrical shorts. The amount of reduction necessary is process-dependent (5–15% is common).
- For optimum transfer efficiency and release of the solder paste from the stencil apertures, industry standard aperture and aspect ratios should be adhered to.

Printer Operation

Solder Paste Bead Size	~20–25mm in diameter
Print Speed	25–100mm/second
Squeegee Pressure	0.018–0.027kg/mm of blade length
Underside Stencil Wipe	Start at once per every 5 prints and decrease frequency until optimum value is reached
Squeegee Type/Angle	Metal with appropriate length/~45 degrees
Separation Speed	5–20mm/second or per equipment manufacturer's specifications
Solder Paste Stencil Life	>8 hours (at 30–60% RH and 22–28°C)

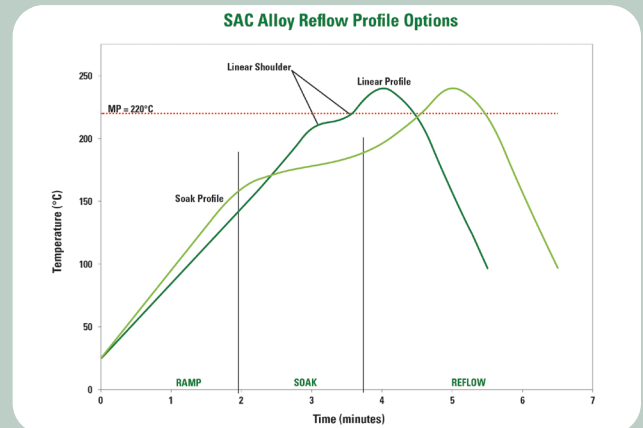
Cleaning

Indium10.5HF is designed for no-clean applications; however, the flux can be removed, if necessary, by using a commercially available flux residue remover.

Stencil Cleaning is best performed using isopropyl alcohol (IPA) as a solvent. Most commercially available non-water-based stencil cleaners work well.

Reflow

Recommended Profile:



The stated profile recommendations apply to most Pb-free alloys in the SnAgCu (SAC) alloy system, including SAC305 (96.5Sn/3.0Ag/0.5Cu). This can be used as a general guideline in establishing a reflow profile when using **Indium10.5HF Solder Paste**. Deviations from these recommendations are acceptable, and may be necessary, based on specific process requirements, including board size, thickness, and density. Start with the linear profile, then move to the optional soak profile, if needed. The flat soak portion of the linear profile (linear shoulder) may also be eliminated.

Reflow Profile Details	SAC305 Parameters		Comments
	Recommended	Acceptable	
Ramp Profile (Average Ambient to Peak)—Not the Same as Maximum Rising Slope	1.0–1.5°C/second	0.5–2.5°C/second	To minimize solder balling, beading, hot slump
Soak Zone Profile (optional)	20–60 seconds	30–120 seconds	May minimize BGA/CSP voiding Eliminating/reducing the soak zone <u>may</u> help to reduce HIP and graping
	140–160°C	140–170°C	
Time Above Liquidus (TAL)	45–60 seconds	30–100 seconds	Needed for good wetting/reliable solder joint As measured with thermocouple
Peak Temperature	230–260°C	230–262°C	
Cooling Ramp Rate	2–6°C/second	0.5–6°C/second	Rapid cooling promotes fine-grain structure
Reflow Atmosphere	Air or N ₂		N ₂ preferred for small components

All parameters are for reference only.

Modifications may be required to fit process and design.

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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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