

PRODUCT DATA SHEET

Indium8.9HFC

with Indalloy®249 Solder Paste

Introduction

Indium8.9HFC is an air reflow, no-clean solder offering unprecedented stencil print transfer efficiency to work in the broadest range of processes. The clear post-reflow flux residue provides an exceptional cosmetic appearance with no charring after multiple reflow processes.

Features

- Halogen-free per EN14582 test method
- Clear flux residue
- Low BGA, CSP, QFN voiding
- High transfer efficiency through small apertures ($\leq 0.66AR$)
- Eliminates hot and cold slump
- High oxidation resistance

Alloy

Indalloy®249 (91.8Sn/4.8Bi/3.4Ag) is a Pb-free alloy that reaches full liquidus at 213°C. The alloy was designed for applications requiring liquidus and reflow temperatures below those of SAC305.

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. 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

Flux	Mesh Size	Printing Metal Load
Indium8.9HFC	Type 3	89.5%
	Type 4	89.0%

Industry Standard Test Results and Classification

Flux Classification	ROLO	Typical Solder Paste Viscosity for Indalloy®249	2,200kcps
Based on the testing required by IPC J-Standard-004B		Conforms with all requirements from IPC J-Standard-005A	
Halogen-free per IEC 61249-2-21, Test Method EN14582	<900ppm Cl <900ppm Br <1,500ppm Total		

All information is for reference only.

Not to be used as incoming product specifications.

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

Indium8.9HFC Solder Paste 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.

Complementary Products

- **Rework Flux:** TACFlux® 020B-RC, TACFlux® 089HF
- **Wave Flux:** WF-9945, WF-9958

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

Technical Support

Indium Corporation's internationally experienced engineers provide in-depth technical assistance to our customers. Thoroughly knowledgeable in all facets of Materials 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

The SDS for this product is available by contacting askus@indium.com

From One Engineer To Another®



Form No. 99746 (A4) R0

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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.

Recommended Printer Operation

Solder Paste Bead Size	~20–25mm in diameter
Print Speed	25–150mm/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 or 60° squeegees are typically used
Separation Speed	5–20mm/second or per equipment manufacturer’s specifications
Solder Paste Stencil Life	>12 hours (at 30–60% RH and 22–28°C)

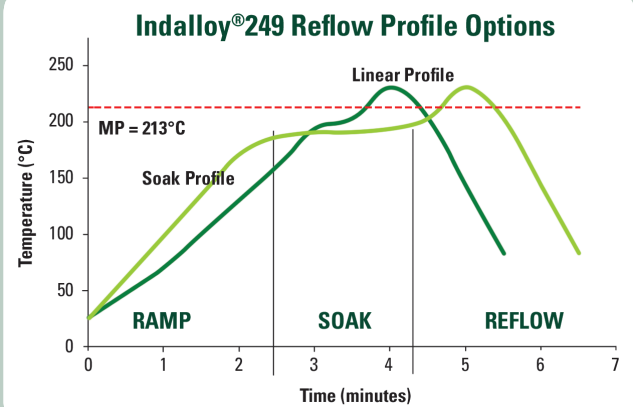
Cleaning

Indium8.9HFC 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 can be used as a general guideline in establishing a reflow profile when using **Indium8.9HFC 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	Indalloy®249		Comments
	Recommended	Acceptable	
Ramp Profile (Average Ambient to Peak)—Not the Same as Maximum Rising Slope	0.5–1°C/second	0.5–2.5°C/second	To minimize solder balling, beading, hot slump
Soak Zone Profile (Optional)	30–90 seconds	30–120 seconds	May minimize BGA/CSP voiding Eliminating/reducing the soak zone may help to reduce HIP and graping
	160–180°C	150–200°C	
Time Above Liquidus (TAL)	45–60 seconds	30–100 seconds	Needed for good wetting/reliable solder joint
Peak Temperature	225–245°C	225–245°C	As measured with thermocouple
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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