

PRODUCT DATA SHEET

Indalloy[®]302 with Indium9.9TF

High-Reliability Solder Paste

Introduction

Indium9.9TF is a no-clean, halogen-free solder paste specifically formulated to accommodate fine-feature printing, as seen with 01005 and 008004 components. **Indium9.9TF** offers unprecedented stencil print transfer efficiency to work in the broadest range of processes to boost SPI yields. This flux offers best in class voiding performance on OSP and ENIG. In addition, it demonstrates high oxidation resistance with little to no graping or solder balling on pads as small as 175 microns in size.

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 Type 4 and Type 5-MC powders as standard product offerings with the high-reliability Indalloy[®]302. 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

Composition	Metal Load	
	Type 4	Type 5-MC
91.25Sn/2.25Ag/0.5Cu/6Bi	88.25–88.75%	88.0–88.5%

Industry Standard Test Results and Classification			
Flux Classification	ROLO	Typical Solder Paste Viscosity for T4 Pb-Free Solder (poise)	1,650
Based on the testing required by IPC J-STD-004D.		Conforms with all requirements from IPC J-STD-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.

Complementary Products

- **Rework Flux:** TACFlux[®] 089HF, TACFlux[®] 020B-RC, TACFlux[®] 129HF
- **Cored Wire:** CW-807RS, CW-818
- **Wave Flux:** WF-9945, WF-9958, WF-9948

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

Packaging

Indium9.9TF 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 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

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.

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	Up to 12 hours (at 30–60% RH and 22–28°C)

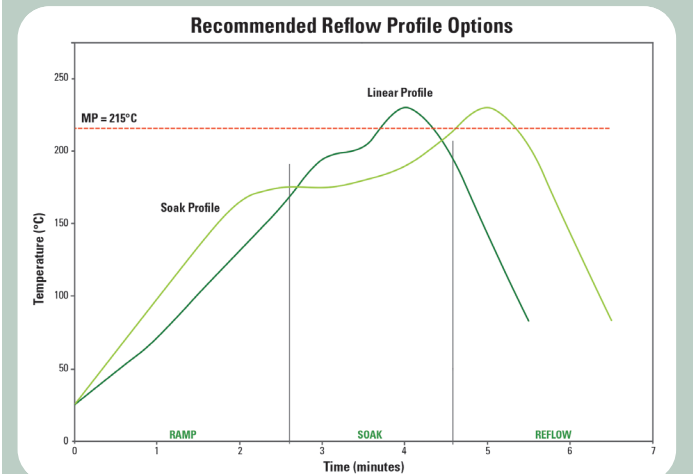
Cleaning

Indium9.9TF 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, including Indalloy®302. Indalloy®302 is compatible with most SAC alloy system reflow profiles. This can be used as a general guideline in establishing a reflow profile when using Indium9.9TF 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®302 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)	30–90 seconds	30–120 seconds	May minimize BGA/CSP voiding Eliminating/reducing the soak zone <u>may</u> 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	230–260°C	223–262°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

Note: 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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