

Product Data Sheet

Indium8.9 Pb-Free Solder Paste

Features

- High transfer efficiency through small apertures (≤ 0.66AR)
- Excellent wetting to all common finishes at high and low peak reflow temperatures
- Clear, probe testable flux residue

Introduction

Indium8.9 is an air reflow, no-clean solder paste specifically formulated to accommodate the higher processing temperatures required by the Sn/Ag/Cu, Sn/Ag, and other alloy systems favored by the electronics industry to replace conventional Pb-bearing solders. **Indium8.9** offers unprecedented stencil print transfer efficiency to work in the broadest range of processes. In addition, the high probe testability of **Indium8.9** minimizes false failures in ICT.

Alloys

Indium Corporation manufactures low-oxide spherical powder composed of a variety of Pb-Free alloys that cover a broad range of melting temperatures. Type 4 and Type 3 powder are standard offerings with SAC305 & SAC387 alloys. The metal percent is the weight percent of the solder powder in the solder paste and is dependant upon the powder type and application. Standard product offerings are detailed in the following table.

Standard Product Specifications

Alloy	Metal Load	IPN
96.5Sn/3.0Ag/0.5Cu (SAC305)	88.50% (Type 4)	800372
96.5Sn/3.0Ag/0.5Cu (SAC305)	88.75% (Type 3)	800373

Packaging

Indium8.9 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.

Storage and Handling Procedures

Refrigerated storage will prolong the shelf life of solder paste. The shelf life of **Indium8.9** is 6 months when stored at <10°C. Solder paste packaged in cartridges should be stored tip down.

Solder paste should be allowed to reach ambient working temperature prior to use. Generally, paste should be removed from refrigeration at least two 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.

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BELLCORE AND J-STD TESTS & RESULTS

Test	Result	Test	Result
J-STD-004A (IPC-TM-650)		J-STD-005 (IPC-TM-650)	
• Flux Type (per J-STD-004A)	ROL1	• Typical Solder Paste Viscosity	
• Flux Induced Corrosion (Copper Mirror)	Type L	Type 4	2050 poise*
• Presence of Halide		Type 3	2200 poise*
Silver Chromate	Pass	Malcom (10rpm)	
Fluoride Spot Test	Pass	• Slump Test	Pass
Ion Chromatography	<0.5% Cl ⁻ eq.	• Solder Ball Test	Pass
• Post Reflow Flux Residue (ICA Test)	35%	• Typical Tackiness	50g*
• SIR	Pass	• Wetting Test	Pass
		BELLCORE GR-78	
		• SIR	Pass
		• Electromigration	Pass

*Pending statistical validation

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

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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 20 mil 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:

The following are general recommendations for stencil printer optimization. Adjustments may be necessary based on specific process requirements:

- Solder Paste Bead Size: 20-25mm diameter
- Print Speed: 50-100mm/sec
- Squeegee Pressure: 0.018-0.027kg/mm of blade length
- Underside Stencil Wipe: Start at once every 5 prints then decrease frequency until an optimum value is determined.
- Solder Paste Stencil Life: >8 hrs. @ 30-60% RH & 22°-28°C

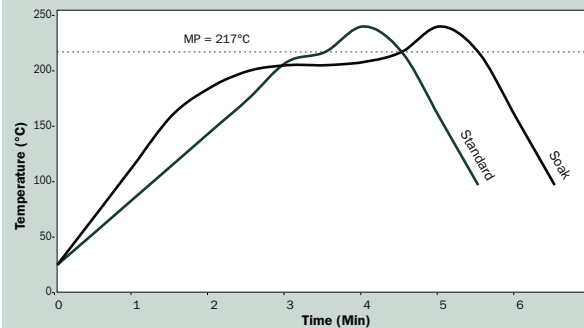
Cleaning

Indium8.9 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 stencil cleaners work well.

Reflow

Recommended Profile:



The stated profile recommendations apply to most Pb-Free alloys in the Sn/Ag/Cu (SAC) alloy system, including SAC 305 (96.5Sn/3.0Ag/0.5Cu). This can be used as a general guideline in establishing a reflow profile when using **Indium8.9** Solder Paste. Deviations from these recommendations are acceptable, and may be necessary, based on specific process requirements, including board size, thickness & density.

Heating Stage:

A linear ramp rate of 0.5°- 2.0°C/second allows gradual evaporation of volatile flux constituents and helps minimize defects such as solder balling and/or beading and bridging resulting from hot slump. It also prevents unnecessary depletion of fluxing capacity when a high peak temperature and extended time above liquidus is used. A profile with a soak between 200°-210°C for up to 2 minutes can be implemented to reduce void formation on BGA & CSP type devices. A short soak of 20-30 seconds just below the melting point of the solder can help minimize tombstoning.

Liquidus Stage:

A peak temperature of 12° to 43°C above the melting point of the solder alloy is recommended to achieve acceptable wetting and form a quality solder joint. The time above liquidus (TAL) should be 30–90 seconds. A peak temperature and TAL above these recommendations can result in excessive intermetallic formation that can decrease solder joint reliability.

Cooling Stage:

A rapid cool down of greater than 2°C/second is desired to form a fine grain structure which helps solder joint fatigue resistance.

This product data sheet is provided for general information only. It is not intended, and shall not be construed, to warrant or guarantee the performance of the

products described which are sold subject exclusively to written warranties and limitations thereon included in product packaging and invoices.

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