

PRODUCT DATA SHEET

# Indium3.2 Pb-Free Water-Soluble Solder Paste

## Features

- Consistent fine-pitch printing performance with high transfer efficiency from stencil apertures
- Superior fine-pitch soldering ability
- Wide reflow profile window
- Excellent response-to-pause printing performance
- Outstanding slump resistance
- Low voiding
- Minimal foaming during the cleaning process
- Excellent wetting

## Standard Product Specifications

| Alloy                       | Metal Load     |
|-----------------------------|----------------|
| 96.5Sn 3.0Ag 0.5Cu (SAC305) | 88.5% Printing |
| 95.5Sn 3.8Ag 0.7Cu (SAC387) | 88.5% Printing |

## Packaging

Indium3.2 is 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 Indium3.2 is no less than 4 months when stored at <5°C. Solder paste packaged in cartridges and syringes should be stored tip down.

When refrigerated, solder paste should be allowed to reach ambient working temperatures 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 the container size and the solder paste temperature should be verified before use. Jars and cartridges should be labeled with the date and time of opening. It is not recommended to remove worked paste from the stencil and mix it with the unused paste in the jar because this may alter the rheology of the unused paste.

## Introduction

Indium3.2 is an air or nitrogen reflow, water-soluble solder paste specifically formulated to accommodate the higher processing temperatures required by the SnAgCu, SnAg, SnSb, and other Pb-free alloy systems. This product formulation offers consistent, repeatable printing performance combined with a long stencil life and sufficient tack strength to handle the challenges of today's high-speed as well as high-mix surface mount lines. In addition to consistent printing and reflow requirements, this solder paste offers superb wetting to the various Pb-free metallizations and has exceptional low voiding performance on fine-pitch components, including BGAs and CSPs.

## 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 3 powder is the standard offering with SnAgCu, SnAg and SnSb Pb-Free alloy systems. The metal percent is the weight percent of the solder powder in the solder paste and is dependent upon the powder type and application.

OVER→

## INDIUM3.2 TEST DATA SUMMARY

| Test   | Result            | Test  | Result  |
|--|-------------------|---|---|
| <b>J-STD-004* (IPC-TM-650)</b> <ul style="list-style-type: none"> <li>• Flux Type (per J-STD-004A)</li> <li>• Flux Induced Corrosion</li> <li>• SIR (cleaned)</li> </ul> | ORM1<br>M<br>Pass | <b>J-STD-005* (IPC-TM-650)</b> <ul style="list-style-type: none"> <li>• Typical Solder Paste Viscosity SAC305 (Sn96.5/Ag3/Cu0.5, Type 3, 88.5%) Malcom (10 rpm)</li> <li>• Typical Tackiness</li> <li>• Slump Test</li> <li>• Solder Ball Test</li> <li>• Thixotropic Index (ICA Test)</li> </ul> | 1750 poise**<br>50g**<br>Pass<br>Pass<br>-.60 |
| <small>**The reported value is a running average subject to periodic updates.</small>  |                   |   |   |
| <small>All information is for reference only. Not to be used as incoming product specifications.</small>   |                   |   |   |

\*The most current revision of the applicable IPC Joint Industry Standard shall always be referenced.

www.indium.com

askus@indium.com

ASIA: Singapore, Cheongju, Malaysia: +65 6268 8678  
 CHINA: Suzhou, Shenzhen: +86 (0)512 628 34900  
 EUROPE: Milton Keynes, Torino: +44 (0) 1908 580400  
 USA: Utica, Clinton, Chicago, Rome: +1 315 853 4900



# Indium3.2 Pb-Free Water-Soluble Solder Paste

## 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 requirement:

- Solder Paste Bead Size: 20-40mm diameter
- Print Speed: 12-150mm/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. <60% RH & 22-28°C

## Cleaning

### Residue Removal

Indium3.2 flux residues are water-soluble and best removed by an inline or batch type cleaning process using spray pressure and heated DI water. A spray pressure of 60 PSI and a DI water temperature of 55°C can be used as a starting point. The optimal spray pressure and temperature are a function of board size, complexity, and the efficiency of the cleaning equipment and should be optimized accordingly. We recommend cleaning the flux residue 12 hours (or sooner) after reflow for optimal test performance. Electrical testing should be completed after the flux residue is removed.

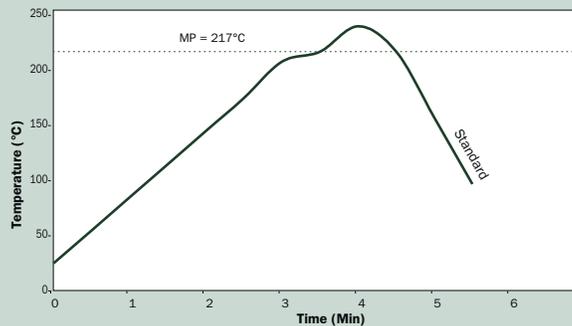
### Stencil Cleaning

This is best performed using an automated stencil cleaning system for both stencil and misprint cleaning to remove extraneous solder particles. Most commercially available stencil cleaners and isopropyl alcohol are acceptable.

## Reflow

### Recommended Profile:

Indium3.2 should be reflowed using a linear profile in an air or nitrogen atmosphere. The stated profile recommendations can be used as a general guideline in establishing a reflow profile for Indium3.2 with SnAgCu, SnAg, and SnSb alloy systems.



### 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.

### Liquidus Stage:

Indium3.2 can accommodate a peak temperature range of 235°C to 260°C. The actual peak temperature is determined by the board size, complexity, and component limitations. 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 is desired to form a fine grain structure. Slow cooling will form a large grain structure, which typically exhibits poor fatigue resistance. The acceptable cooling range is 0.5°C-6.0°C/second (2.0°-6.0°C/second is ideal).

## Compatible Products

- Rework Flux: **TACFlux® 025**
- Flux Pen: **FP-1095-NF**
- Cored Wire: **CW-301**
- Wave Flux: **1095-NF**

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. All Indium Corporation's products and solutions are designed to be commercially available unless specifically stated otherwise.

[www.indium.com](http://www.indium.com)

[askus@indium.com](mailto:askus@indium.com)

ASIA: Singapore, Cheongju, Malaysia: +65 6268 8678  
 CHINA: Suzhou, Shenzhen: +86 (0)512 628 34900  
 EUROPE: Milton Keynes, Torino: +44 (0) 1908 580400  
 USA: Utica, Clinton, Chicago, Rome: +1 315 853 4900



©2016 Indium Corporation

ISO 9001  
REGISTERED