



# LF318

June 2012

## PRODUCT DESCRIPTION

LF318 provides the following product characteristics:

<b>Technology</b>	Solder paste
<b>Application</b>	Pb-free soldering

LF318 solder paste is a halide-free, no clean, pin testable Pb-free solder paste, formulated to have excellent humidity resistance and a broad process window, both for reflow and printing. This product has high tack force to resist component movement during high speed placement and long printer abandon times. LF318 shows excellent solderability over a wide range of reflow profiles in both air and nitrogen across a wide range of surface finishes including Ni/Au, Immersion Sn, Immersion Ag and OSP copper.

## FEATURES AND BENEFITS

- Good humidity resistance. Gives excellent coalescence even after 72 hours exposure to 27°C/80% RH, reducing process variation due to environmental factors.
- Colorless residues for easy post-reflow inspection.
- Soft, non-stick, pin testable residues allow easy in-circuit testing.
- Suitable for fine pitch, high speed printing up to 150mm/s (6"/s).
- Extended open time and tack-life leading to low wastage.
- Halide free flux classification: ROL0 to ANSI/J-STD-004.

## TYPICAL PROPERTIES

Based on type 3 powder.

### Solder Paste Typical Properties

Alloys	96SC, 97SC
Powder Particle Size, $\mu\text{m}$	25-45
Multicore Powder Size Coding	AGS
Metal Loading (Weight %)	88.5
Slump, J-STD-005, mm <i>RT, 15 minutes</i>	IPC A21 Pattern
0.33 x 2.03 mm pads	0.06
0.63 x 2.03 mm pads	0.33
<i>150°C, 15 minutes</i>	
0.33 x 2.03 mm pads	0.25
0.63 x 2.03 mm pads	0.41
Brookfield Viscosity TF spindle, 25°C, 5rpm after 2 minutes, mPa-s	765,000
Thixotropic Index (Ti), 25°C ( $T_i = \log(\text{viscosity @ } 1.8\text{s}^{-1} / \text{viscosity @ } 18\text{s}^{-1})$ )	0.54
Malcom Rheology, 10rpm, 25°C, Rate $6\text{s}^{-1}$	1,961
Initial tack force, g $\text{mm}^{-2}$	2.0
Useful open time, hours	>24

## Solder Powder:

Careful control of the atomisation process for production of solder powders for LF318 solder pastes ensures that the solder powder is produced to a quality level that exceeds IPC/J-STD-006 & EN29453 requirements for sphericity, size distribution, impurities and oxide levels. Minimum order requirements may apply to certain alloys and powder sizes. For availability contact your local technical service helpdesk.

## DIRECTIONS FOR USE

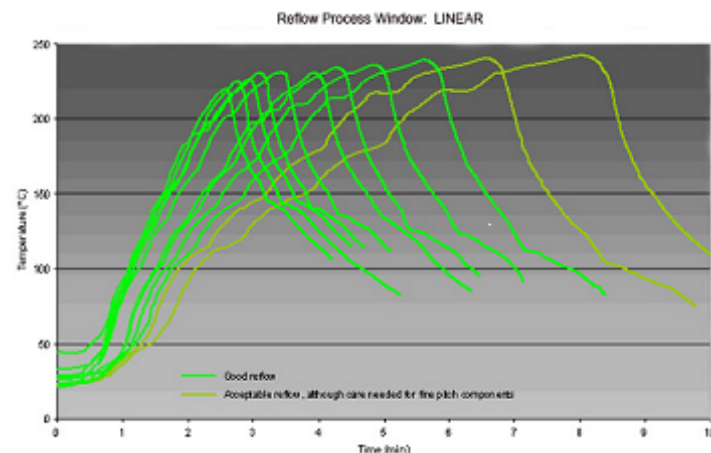
### Printing:

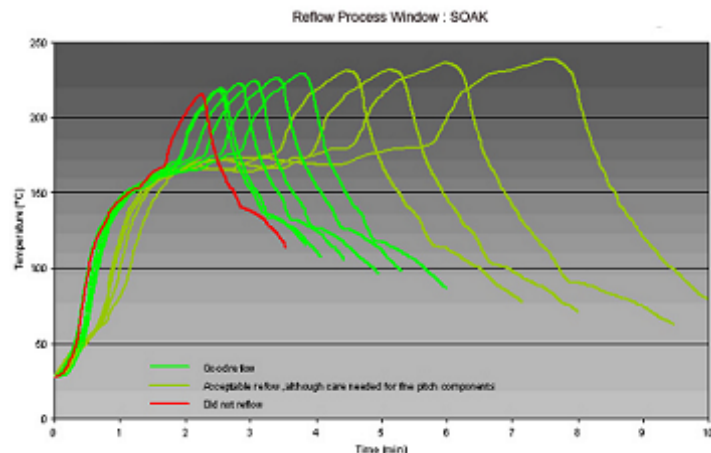
1. LF318 is available for stencil printing down to 0.4mm (0.016") pitch devices, with type Type 3 (AGS) powder.
2. Printing at speeds between 25mm/s (1.0"/s) and 150mm/s (6"/s) can be achieved using laser cut and electro-polished, electroformed stencils, metal squeegees (preferably 60°).
3. Acceptable first prints have been achieved at 0.4mm (0.016") pitch after printer down times of 240 minutes without requiring a knead cycle.

### Reflow:

- Any of the available methods of heating to cause reflow may be used including IR, convection, hot belt, vapor phase and laser soldering.
- LF318 is not particularly sensitive to reflow profile type.
- No single reflow profile is deemed suitable for all processes and applications, but the following graph shows example profiles that have given good results in practice.

### Profile 1:



**Profile 2:****Cleaning:**

1. LF318 solder pastes are no-clean and are designed to be left on the PCB in many applications post assembly, since they do not pose a hazard to long term reliability.
2. Residue removal can be achieved using conventional cleaning processes based on solvents such as MCF800 or suitable saponifying agents.
3. For stencil cleaning and cleaning board misprints, SC-01 Solvent cleaner is recommended.

**RELIABILITY PROPERTIES****Solder Paste Medium:**

LF318 medium contains a stable resin system, slow evaporating solvents and with minimal odour. The formulation has been tested to the requirements of the Telcordia (formerly known as Bellcore) GR-78-CORE and ANSI/J-STD-004 for a type ROL0 classification specifications.

Test	Specification	Results
Copper Plate Corrosion	ANSI/J-STD-004	Pass
Copper Mirror Corrosion	ANSI/J-STD-004	Pass
Chlorides & Bromides	ANSI/J-STD-004	Pass
Surface Insulation	ANSI/J-STD-004	Pass
Resistance (without cleaning)	Telcordia GR-78-Core JIS-Z-3248	Pass Pass
Flux Activity Classification (without cleaning)	ANSI/J-STD-004	ROL0

**PACKAGING**

**Containers:** LF318 is supplied in:

- 500g plastic jars with an air seal insert
- 600g Semco cartridges

Other packaging types may be available on request; please contact your local technical service helpdesk for assistance.

**Storage:**

It is recommended to store LF318 at 0 to 10°C. (NB cartridges should be stored tip down to prevent the formation of air pockets). The paste should be removed from cold storage a minimum of 8 hours before use. Do not use forced heating methods to bring solder paste up to temperature. Multicore LF318 has been formulated to minimize flux separation on storage but should this occur, gentle stirring for 15 seconds will return the product to its correct rheological performance. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact your local Technical Service Center.

**Shelf Life:**

Provided Multicore LF318 is stored tightly sealed in its original container at 0 to 10°C, a minimum shelf life of 6 months can be expected. Air shipment is recommended to minimize the time the containers are exposed to higher temperatures.

**DATA RANGES**

The data contained herein may be reported as a typical value and/or a range. Values are based on actual test data and are verified on a periodic basis.

**GENERAL INFORMATION**

**For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**

**Not for Product Specifications**

The technical information contained herein is intended for reference only. Please contact Henkel Technologies Technical Service for assistance and recommendations on specifications for this product.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{inches}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

**Note**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, Henkel Corporation and its affiliates ("Henkel") specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel products. Henkel specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

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Reference 0.0