



Heraeus

# Technical Data Sheet

## Solder Paste F10 Series

<b>Description</b>	<b>F 10 Series solder paste is a ready to use homogenous mixture, consisting of fully alloyed metal powders, binders, solvents and thixotropic agents for surface mount assembly applications. This paste provides excellent wetting. It can be reflowed in air or nitrogen and feature an ultra low odor level. The printing capabilities of these pastes are unsurpassed. The residues may be left on the board.</b>																																																													
<b>Key Benefits</b>	<ul style="list-style-type: none"> <li>- Outstanding wetting</li> <li>- Exceptional print to print consistency</li> <li>- Min. 8 hours tack and work life</li> </ul>			<b>Compliant Products</b>																																																										
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<b>Paste Conditioning</b>	<p>Remove paste from fridge: Before opening the package leave paste 2 hours at room temperature so that paste warms up. Do not open jar/cartridge while paste is cold to prevent condensation of moisture on the paste - this causes defects, e.g. solder balling etc. Do not heat the paste.</p> <p>Before use of paste jar: To obtain uniform, stable viscosity stir paste for 1 to 2 min, using stainless steel or chemically resistive plastic spatula.</p>																																																													
<b>Reflow</b>	<p>Temperature profile adjustment according IPC/JEDEC J-STD-020.</p>																																																													
<b>Cleaning</b>	<p>After reflow flux residues may remain on the circuit and do not need to be washed. For cleaning of wet paste or if desired for cleaning of flux residues Zestron and Vigon cleaners can be used – see separate cleaning recommendations.</p>																																																													
<b>Storage</b>	<p>Store the solder paste in tightly-sealed containers and avoid exposure to sunlight and high humidity.</p> <p>Max expiration date : please refer to the expiry date on the label of the packaged product. Storage conditions in the refrigerator at 2-10°C.</p>																																																													
<b>Contact</b>	<p>www.heraeus-contactmaterials.com</p>			<b>Version</b>	<p>TDS_Solder Paste F10 Series_18.March 2015</p>																																																									

The descriptions and engineering data shown here have been compiled by Heraeus using commonly-accepted procedures, in conjunction with modern testing equipment, and have been compiled as according to the latest factual knowledge in our possession. The information was up-to date on the date this document was printed (latest versions can always be supplied upon request). Although the data is considered accurate, we cannot guarantee accuracy, the results obtained from its use, or any patent infringement resulting from its use (unless this is contractually and explicitly agreed in writing, in advance). The data is supplied on the condition that the user shall conduct tests to determine materials suitability for a particular application