



Technical Data Sheet

Solder Paste F917 Sn63-90 A 30

Description	The solder pastes of the F 917 Series are ready-to-use homogeneous mixtures with low odour characteristics, consisting of metal powder, binders, solvents, fluxes and thixotropic agents.																																													
Key Benefits	<ul style="list-style-type: none"> - Exceptional print to print consistency - Outstanding wetting - Very long stencil life 			Compliant Products																																										
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	<small>Halogen Free-Tolerances from IEC 61249-2-21: Cl or Br <900ppm, total <1500ppm; measured according to BS EN 14582</small>		<small>Halogen Zero - Tolerance: Halogen < 50 ppm; measured according to BS EN 14582</small>																																											
Paste Conditioning	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. 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.																																													
Reflow	Peak temperature: 20-30°C above the melting temperature of the alloy. Time above melting temperature: 30 to 90 seconds.																																													
Cleaning	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.																																													
Storage	Store the solder paste in tightly-sealed containers and avoid exposure to sunlight and high humidity. 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.																																													
Contact	www.heraeus-contactmaterials.com			Version	TDS_Solder Paste F917 Series_25.Oct. 2013																																									

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