

Handling Guidelines

GC 3W Temperature Stable Solder Paste

November 2015

HANDLING

Storage: It is recommended that GC 3W solder paste paste is stored at temperatures below 25°C (77°F). Storage below this temperature down to a temperature of 0°C (32°F) will have no negative effect on the material.

Storage at temperatures above 25°C (77°F) may reduce the storage stability of the material. Exposure for one to seven days (transport time) up to 43°C (109°F) with no direct sunlight will have no negative impact to material shelf-life.

Before Use: If GC 3W solder paste is stored at 20-25°C (68-77°F) it can be used straight away without any requirement for equilibration at room temperature.

If stored below room temperature GC 3W solder paste should be allowed to equilibrate to room temperature before opening and use. Failure to do this may result in condensation forming on the paste which may adversely affect the performance during printing and/or reflow. If stored under refrigerated conditions (0-10°C, 32-50°F) a time of at least four hours should be allowed for paste to equilibrate at room temperature.

Working Environment: GC 3W solder paste performs best when used in a controlled environment. Maintaining an ambient temperature of between 20 and 25°C (68-77°F) at a relative humidity of 30 – 60% RH will ensure consistent performance and maximum life of the paste.

Stirring: To restore GC 3W solder paste to its specified rheology, it can be stirred using a non-metallic or round-edged spatula for 1 – 2 minutes before being applied to the printer. Solder paste dispensed from a cartridge does not require stirring as the rheology is restored during the dispensing and printing (knead) process.

GC 3W solder paste packed in jars may show some separation after storage at higher temperatures, if this is observed the paste can be restored by stirring until it appears homogeneous.

For print and reflow guidelines refer to local procedures and/or the Technical Data Sheet or Engineer's Manual for GC 3W solder paste.

Thinning: The addition of any additional material to GC 3W solder paste is not recommended.

Past Life: As a general rule GC 3W solder paste can be used on the stencil at least 8 hours. Paste which has been on the printer can be stored at room temperature for up to 72 hours before being re-used. It is preferable to store used paste in a separate container. Do not mix fresh paste with used paste unless adding more to the printer itself.

Disposal: Used solder paste should be stored in a sealed container and disposed of in accordance with local authority requirements, refer to the Material Safety Data Sheet (MSDS).

Cleaning: For stencil cleaning GC 3W solder paste can be cleaned using typical solvent cleaners used for solder paste. As GC 3W flux is water-soluble it is also acceptable to clean stencils with water. It is recommended that all equipment is cleaned and dried thoroughly immediately after use. For best results, scrubbing in the solution by either ultrasonic action or brush will ensure all solder particles are completely removed.

SHIPPING

GC 3W solder paste is packed in standard cases, cartridges are packed and shipped tip-down to minimize the risk of separation.

Shipping method: Unless specifically requested, all material is shipped on overnight service in domestic market and by courier for international market in an unrefrigerated state.

Shipping temperatures: In an uncontrolled external environment the temperature should not exceed 43°C (109°F). GC 3W solder paste is packed in standard cases, cartridges are packed and shipped tip-down to minimize the risk of separation.

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RECEIVING

Goods inwards temperature: Should not exceed 43°C (109°F). Should the temperature indicator label show that the temperature during transit exceeded 43°C (109°F) then follow local guidelines for CCMS (customer complaints management system).

Time to transfer to controlled storage: Immediately on receipt transfer the paste to a cool area for storage in accordance with the storage conditions recommended on the Technical Data Sheet.

STORAGE ON SITE

Storage: Cartridges to GC 3W solder paste should be stored tip down to avoid flux separation.

Storage temperature:

0-25°C (±1.5°C)

32-77°F (±2.5°F)

Shelf life: 6 months at above conditions.

Stock control: It is recommended that solder paste from different batches is segregated and that a first-in, first-out stock control system is maintained.

GENERAL INFORMATION

For safe handling information, consult the Material Safety Data Sheet (MSDS).