

SOLDER PASTE HANDLING

Here are the general guidelines applicable to **INVENTEC PERFORMANCE CHEMICALS** solder pastes. Please notice that requirements for jars and cartridges solder pastes may be different from syringes solder pastes.

Failure to follow these guidelines will result in reduced shelf life and diminished product performance and may make the product unsuitable for use.

SHIPPING

INVENTEC solder pastes, packaged in **jars and cartridges** are designed to be shipped **up to 30°C during 72h**.

Syringes solder pastes are designed to be shipped **up to 30°C for 24h**.

INVENTEC foam box packaging are used with **ice packs** to guarantee a product temperature **< 30°C for 3 days minimum**.

When receiving solder paste, check sealing of cartons with **INVENTEC** tape and temperature inside box above 30°C. **If temperature is exceeding 30°C, please contact your commercial contact.**



STORAGE

Solder paste must be stored at 0-10°C. Products must be stored in a cold room or fridge upon receipt.

Cartridges and syringes must be stored with the tip pointed down to avoid flux separation.

For specific storage conditions and shelf life, please consult the product data sheet.

HANDLING

Solder paste should be used on a FIFO (First in – First Out) basis. Use old batch first.

Date of production of a solder paste lot is printed on the label.

Prior to use, allow the solder paste to slowly be brought up to room temperature. It is highly recommended to **remove solder paste from storage 4 hours before use**.

Opening cold solder paste in a warmer environment can result in condensation and potential performance impact.

Apply on the stencil solder paste to form a roll of 1 to 2 cm of diameter all along the squeegee. This way, the solder paste will roll easily under the squeegees to offer excellent printing quality.

For specific process parameters, consult the product data sheet.

Replace lids on open jars to reduce the effects of oxidation and humidity.

It is not necessary to return solder paste to the refrigerator after opening. It is possible that refrigeration can cause condensation and compromise performance.

When paste is removed from stencil, it must be placed in a segregated container. **Do not mix it with unused paste.**

All opened jars or cartridges should be properly labeled with the time and date of opening.