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## Contact us

Tel: +86-755-8981 8866 Fax: +86-755-8427 6832

Email & Skype: info@chipsmall.com Web: www.chipsmall.com

Address: A1208, Overseas Decoration Building, #122 Zhenhua RD., Futian, Shenzhen, China



# LOCTITE LF 318D

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## PRODUCT DESCRIPTION

LOCTITE LF 318D provides the following product characteristics:

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

LOCTITE LF 318D is a halide-free, no clean, low voiding Pb-free solder paste, which has excellent humidity resistance and a broad process window both for printing and reflow. This product has a high tack force to resist component movement during high speed placement and long printer abandon times. LOCTITE LF 318D 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

- Long print abandon time even on small CSP apertures
- Colorless residues for easy post-reflow inspection
- Suitable for fine pitch, high speed printing up to 150mm/s (6"/s)
- Suitable for enclosed head printing
- Halide-free flux classification: ROL0 to ANSI/J-STD-004

## TYPICAL PROPERTIES

Based on Type 3 powder

### Solder Paste Typical Properties

Alloys	97SC
Powder Particle Size, $\mu\text{m}$	20 to 45
Powder Size Coding	AGS
IPC Equivalent	Type 3
Metal Loading (Weight %)	89.0
Slump, J-STD-005, mm	
<i>RT, 15 minutes</i>	
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	0.2
0.63 x 2.03 mm pads	0.33
Brookfield Viscosity TF spindle, 25°C, 5rpm after 2 minutes, mPa·s	855,000
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 $6\text{s}^{-1}$	2,020
Initial tack force, g $\text{mm}^{-2}$	1.5
Useful open time, hours	>24

## Solder Powder:

Careful control of the atomisation process for production of solder powders for LOCTITE LF 318D solder pastes ensures that the solder powder is produced to a quality level that exceeds J-STD-006 and EN 29453 requirements for sphericity, size distribution, impurities and oxide levels.

## DIRECTIONS FOR USE

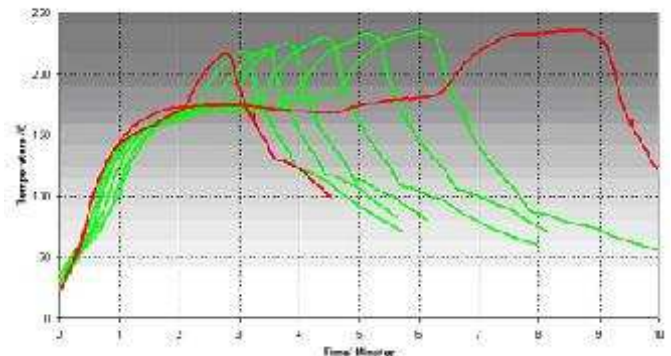
### Printing:

1. LOCTITE LF 318D is available for stencil printing down to 0.4mm (0.016") pitch QFP devices, with type 3 (AGS) powder.
2. Printing at speeds between 25mm/s (1.0"/s) and 150mm/s (6"/s) can be achieved by using laser cut and electro-polished, electro-formed stencils, metal squeegees (preferably 60°).
3. LOCTITE LF 318D is suitable for use in enclosed head printing systems.

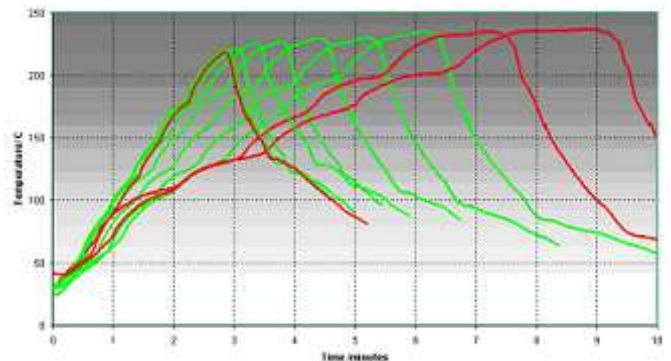
### Reflow:

1. Any of the available methods of heating to cause reflow may be used including IR, convection, hot belt, vapor phase and laser soldering.
2. LOCTITE LF 318D is not sensitive to reflow profile type.
3. No single reflow profile is deemed suitable for all processes and applications, but the following example profiles have given good results in practice.

### Profile 1:



### Profile 2:





**Cleaning:**

1. LOCTITE LF 318D 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, LOCTITE MSC 01 solvent cleaner is recommended.

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

LOCTITE LF 318D medium includes a stable resin system with slow evaporating solvents and minimal odor. 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 specification.

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 Resistance (without cleaning)	ANSI/J-STD-004 Telcordia GR-78-Core JIS-Z-3248	Pass Pass
Flux Activity Classification (without cleaning)	ANSI/J-STD-004	ROL0

**STORAGE AND SHELF LIFE****Storage:**

It is recommended to store LOCTITE LF 318D 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 4 hours before use. Do not use forced heating methods to bring solder paste up to temperature. LOCTITE LF 318D 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.

**Shelf Life:**

Provided LOCTITE LF 318D is stored tightly sealed in its original container at 0 to 10°C, a minimum shelf life of 183 days 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**

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

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The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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Americas  
+1.888.943.6535

Europe  
+32.1457.5611

Asia  
+86.21.3898.4800

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