

CASCADE

WATER - SOLUBLE SOLDER PASTE "CASCADE 1 LF Di"



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CASCADE 1 LF Di water-soluble solder paste is carefully formulated to confer high activity soldering. Its residue can be easily removed with town's water.

- Halide-free.
- Good water clean ability of residues.
- Very good tack-life (>16 hours).
- Good slump resistance
- Fine-pitch (400µm) and ultra-fine pitch (<300µm) capabilities in grade5

CASCADE 1 LF Di water-soluble solder paste is made to strict quality assurance standards.

| Alloys | Metal content (%) | Solidus - Liquidus |
|-------------|-------------------|--------------------|
| Sn43Bi57 | 86 | E138°C |
| Sn42Bi57Ag1 | 86 | E138°C |

Dispensing

CASCADE 1 LF Di has been designed for most types of solder paste dispensing machines equipped with needles down to 0.41mm (using 25-45µm powder). Finer dispensing needles require 15-30µm powder.

Packaging: Syringes and cartridges of 5cc, 10cc and 30cc. Other on request.

Ambient Conditions

18-22°C and 35% to 70% RH. Minimize exposure of paste direct to air flow.

Cleanup-Nozzles and Tools

Use MBO Easy-Purge conditioning fluid.
Tools are easily cleaned with town's water.

Reflow

Heating Methods

Convection, infrared, vapour phase, hot plate, hot bar, laser and others. Aerobic or inerted.

Heating Profile

See suggested reflow profile for specific alloy.

Cleaning

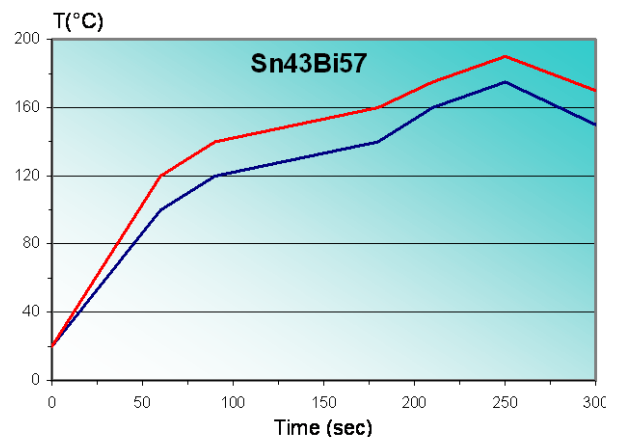
The post-soldered residue of **CASCADE LF Di** is not particularly corrosive but is hygroscopic. Removal is necessary. This can be done by dishwasher, spray or immersion using cold or warm town's water wash followed by rinsing with deionised water. Hot air dry.

Temperature

20-60°C.

Spray Pressure

20 to 40 psi.



Storage: in original container between 5 and 10°C for up to 6 months. Wait until the pot has reached the ambient temperature before opening to avoid water condensation on the surface of the paste. Once opened, do not return to the fridge. At ambient conditions should be used within two weeks.

Additional information:

Our manufacturing processes have been subjected to FMECA analysis (equivalent of AMDEC in Europe).

We cannot anticipate any and all conditions and situations under which the information and our products or the combination of both with others will be used. We do not assume any liability in the safety and suitability of our products alone or in combination with others. Users must make their own tests to determine the safety and suitability of each product used alone or with other products for their own use. Except any previous written agreement, our products are sold without guarantee and customers must assume all liability for any loss or damage suffered by themselves or by third parties, either from handling or use of our products alone or with others. In case of any difference or variation seen during the use of the products we request that you contact our technical department.