



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

- Halide-free
- Good water clean-ability even after 24 hours.
- Resistant to moisture ingress.
- Long open time (>8 hours).
- Very good tack-life (>16 hours).
- Good slump resistance
- Long stencil-life (>4 hours).
- Fine-pitch (400µm) and ultra-fine pitch (<300µm) capabilities in grade5

SIRIUS™ 1 Di water-soluble solder paste is made to strict quality assurance standards.

Alloys	Metal content (%)	Viscosity (cP)
Sn95.5Ag3.8Cu0.7	89	600,000 – 700,000
Sn96.5Ag3Cu0.5	89	600,000 – 700,000

Dispensing

CASCADE™ LF Di has been designed for most types of solder paste dispensing systems 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, 30cc and 50cc. Others on request.

Ambient Conditions

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

Cleanup-Nozzles and Tools

Use MBO Easy-Purge 400 conditioning fluid.

Additional information:

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

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 Equipment

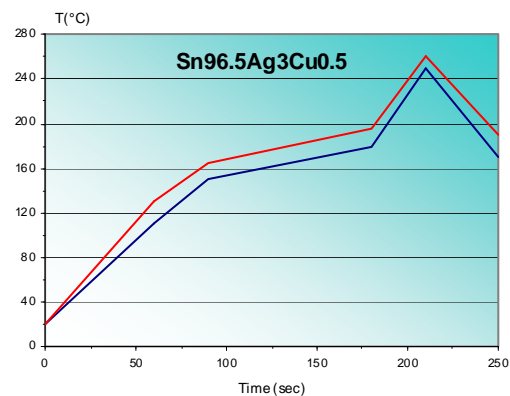
The post-soldered residue of **CASCADE™ LF Di** is not particularly corrosive but it is hygroscopic. Removal is necessary. This can be done by open or closed washer systems, spray or immersion using cold or warm water, preferred, wash followed by rinsing with deionised water. Hot air dry.

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 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..