SAFETY DATA SHEET

This safety data sheet represents a family grouping of all metal mixes that are blended with the same flux known as Indium 5.8LS. A product table is provided that lists all metal groupings. To better serve all of our customers Indium Corporation has generated one SDS, for this product, to be used within the United States as well as internationally. Some of the regulatory information contained within may not be applicable to the customer’s individual state or country. Unless otherwise stated the health and safety information provided within is applicable to all products.

1. PRODUCT AND COMPANY IDENTIFICATION

General Product Class Identifier: INDALLOY WITH INDIUM 5.8 LS FLUX VEHICLE
(View product table for individual product descriptions)

SDS Number: SDS-4010 Revised Date: 24 OCTOBER 2018

Product Use: Industrial Use - No-clean solder paste consisting of a flux vehicle blended with an 83-92 % pre-alloyed metal powder used for solder applications. Review alloy table for listing of metal mixes with the same family flux.

MANUFACTURER:

In America:
The Indium Corporation of America®.
34 Robinson Rd., Clinton, NY 13323
Information: (315) 853-4900
nswarts@indium.com

EMERGENCY PHONE:
CHEMTREC 24 hrs.
USA: 1 (800) 424-9300
Outside USA: +1 (703) 527-3887
China: Emergency 86+ 4008417580

In Europe:
The Indium Corporation of America® (European Operations)
7 Newmarket Ct
Kingston, Milton Keynes, UK, MK 10 OAG
Information: +44 [0] 1908 580400

In China:
Indium Corporation (Suzhou), Co., Ltd.
No. 428 Xinglong Street
Suzhou Industrial Park
Suchun Industrial Square
Unit No. 14-C
Jiangsu Province, China 215126
Information: (86) 512-6283-4900

In Asia:
Indium Corporation of America
Asia-Pacific Operations-Singapore
29 Kian Teck Avenue
Singapore 628908
Information: +65 6268-8678

In India:
Indium Solder Private Limited
Shed A, NP-7 Guindy Industrial Estate,
Ekkaduthangal, Chennai, Tamil Nadu, India 600032
Information: +91-044-46877888

http://www.indium.com
2. HAZARDS IDENTIFICATION

PRIMARY ROUTES OF ENTRY:  
- Eye  - Inhalation  - Skin  - Ingestion

CARCINOGEN LISTED IN:
- NTP  - IARC  - OSHA  - Not Listed

GHS:
Lead free products

<table>
<thead>
<tr>
<th>Signal Word: Warning</th>
</tr>
</thead>
</table>

Hazard statement(s)
- H317: May cause an allergic skin reaction
- H334: May cause allergy or asthma symptoms or breathing difficulties if inhaled
- H335: May cause respiratory irritation
- EUH208: Contains rosin. May produce an allergic reaction

Precautionary statement(s)
- P233: Keep container tightly closed
- P261: Avoid breathing dust/fume/gas/mist/vapors/spray
- P270: Do not eat, drink or smoke when using this product
- P273: Avoid release to the environment
- P280: Wear protective gloves/protective clothing/eye protection/face protection
- P362 + P364: Take off contaminated clothing and wash before reuse
- P301 + P314: IF SWALLOWED: Get medical advice/attention if you feel unwell
- P302 + P352: IF ON SKIN: Wash with plenty of soap and water
- P304 + 341: IF INHALED: If breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing
- P305 + 351: IF IN EYES: Rinse continuously with water for several minutes (15 mins)

Lead containing products

<table>
<thead>
<tr>
<th>Signal Word: Warning</th>
</tr>
</thead>
</table>

Hazard statement(s)
- H303: May be harmful if swallowed
- H317: May cause an allergic skin reaction
- H334: May cause allergy or asthma symptoms or breathing difficulties if inhaled
- H335: May cause respiratory irritation
- H351: Suspected of causing cancer
- H361: Suspected of damaging fertility or the unborn child
- H373: May cause damage to organs through prolonged or repeated exposure
H410  Very toxic to aquatic life with long lasting effects  
EUH201A  Warning! Contains lead (applicable only to the products listed that contain lead) Review listing.  
EUH208  Contains rosin. May produce an allergic reaction

Precautionary statement(s)
P233  Keep container tightly closed  
P261  Avoid breathing dust/fume/gas/mist/vapors/spray  
P270  Do not eat, drink or smoke when using this product  
P273  Avoid release to the environment  
P280  Wear protective gloves/protective clothing/eye protection/face protection  
P362 +P364  Take off contaminated clothing and wash before reuse  
P301 + P314  IF SWALLOWED: Get medical advice/attention if you feel unwell  
P302 +P352  IF ON SKIN: Wash with plenty of soap and water  
P304 + 341  IF INHALED: If breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing  
P305 + 351  IF IN EYES: Rinse continuously with water for several minutes (15 mins)

Classification:
Carcinogenicity (Category 2) (lead)  
Reproductive toxicity (Category 2 ) (lead)  
Skin sensitizer-Category 1B  
Respiratory sensitizer-Category 1B  
Acute toxicity, oral-Category 5 (lead)  
Acute toxicity, inhalation 4 (lead)  
Specific target organ toxicity single exposure, respiratory tract- Category 3  
Acute aquatic toxicity – Category 1 for lead containing products (H400)  
Chronic aquatic toxicity – Category 1 for lead containing products (H410)

POTENTIAL HEALTH EFFECTS:

Eye Contact:  Contact with material at room temperature or fume from material at typical re-flow temperatures over 100°C may cause eye irritation.  

Ingestion:  This product contains alloy powders and organic chemicals. May be harmful if swallowed  

Inhalation:  Vapors or fumes from this material at typical re-flow temperatures over 100°C may cause local irritation to the respiratory system. Rosin fume may cause occupational asthma.  

Skin Contact:  May cause skin irritation. Rosin may cause dermatitis.  

Chronic:  LEAD: Prolonged exposure to vapors or fumes at higher temperatures may cause respiratory irritation and systematic lead poisoning. Symptoms of lead poisoning include headache, nausea, abdominal pain, muscle and joint pain and damage to the nervous system, blood system and kidneys.  

SILVER: Chronic skin contact or ingestion of silver dust, salts, or fume can result in a condition known as Argyria, a condition with bluish pigmentation of the skin and eyes.  

TIN: Has been shown to increase incidence of sarcoma in animal tests. Chronic exposure to tin dusts and fume may result in “stannosis” a mild form of pneumoconiosis.  

COPPER: Overexposure to fumes may cause metal fume fever (chills, muscle aches, nausea, fever; dry throat, cough, weakness, lassitude); metallic or sweet taste; discoloration of skin and hair.  

WARNING: This product can expose you to chemicals including [lead] which is known to the State of California to cause cancer, and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov

NOTE: The Indium Corporation does not recommend, manufacture, market or endorse any of its
products for human consumption.

**WARNING:** This product may contain lead. Lead may be harmful to your health. US Federal law prohibits the use of leaded solders in making joints or fittings in any private or public water supply system. Keep out of the reach of children.

### 3. COMPOSITION / INFORMATION ON INGREDIENTS

<table>
<thead>
<tr>
<th>Components</th>
<th>% wt</th>
<th>CAS Registry #:EINECS#</th>
<th>PEL mg/m³</th>
<th>TLV-TWA mg/m³</th>
<th>TLV-STEL mg/m³</th>
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<tr>
<td>TIN</td>
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<td>7440-31-5/231-141-8</td>
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<tr>
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<td>(US) 2</td>
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<td>0.03(fume)</td>
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<td>(Mexico) 0.1</td>
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<td>COPPER</td>
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<td>0.6</td>
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<td>(Singapore) 0.2(fume)</td>
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<td>1(dust)</td>
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</table>
(Mexico) 0.2 - 2
(China) - 0.2(fume) 0.6(fume)

**BISMUTH** * 7440-69-9/231-177-4 N.E. N.E. N.E.

**ROSIN** 3.0-4.0 65997-05-9 (US) N.E. N.E. N.E.

(EU) 0.05 - 0.15 (sensitiser)

**POLYGLYCOL ETHER** 3 - 10 9038-95-3 N.E. N.E. N.E.

**CARBOXYLIC ACID** 3 – 6 68937-72-4 N.E. N.E. N.E.

N.E. = Not established  * See Alloy Table

### ALLOY TABLE (DATA)

<table>
<thead>
<tr>
<th>Indalloy Mixture Products (%Metal)</th>
<th>%TIN Sn</th>
<th>%SILVER Ag</th>
<th>%COPPER Cu</th>
<th>%BISMUTH Bi</th>
<th>%LEAD Pb</th>
<th>RoHS2/3* Compliance</th>
</tr>
</thead>
<tbody>
<tr>
<td>104 (Sn62/Pb36/2Ag)</td>
<td>51.9-57.5</td>
<td>1.2-1.8</td>
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<td>29.9-33.2</td>
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<tr>
<td>106 (Sn63/37Pb)</td>
<td>52.3-58</td>
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<td>30.7-34</td>
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</table>

**LEAD FREE PRODUCTS LISTED BELOW**

<table>
<thead>
<tr>
<th>Indalloy Product</th>
<th>%TIN Sn</th>
<th>%SILVER Ag</th>
<th>%COPPER Cu</th>
<th>%BISMUTH Bi</th>
<th>%LEAD Pb</th>
<th>RoHS2/3* Compliance</th>
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</thead>
<tbody>
<tr>
<td>121 (96.5 Sn/3.5Ag)</td>
<td>80.1-88.8</td>
<td>2.9-3.2</td>
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<tr>
<td>241 (SAC 387) (95.5Sn/3.8Ag/0.7Cu)</td>
<td>79.3-87.9</td>
<td>3.2-3.5</td>
<td>0.58-0.64</td>
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<tr>
<td>246 (95.5Sn/4Ag/0.5Cu)</td>
<td>79.3-87.9</td>
<td>3.3-3.7</td>
<td>0.42-0.46</td>
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<td>YES</td>
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<tr>
<td>249 (91.8Sn/4.8Bi/3.4Ag)</td>
<td>76.2-84.5</td>
<td>2.8-3.1</td>
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<td>4-4.4</td>
<td>-</td>
<td>YES</td>
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<tr>
<td>252 (95.5Sn/3.9Ag/0.6Cu)</td>
<td>79.3-87.9</td>
<td>3.2-3.6</td>
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<tr>
<td>256 (SAC 305) (96.5Sn/3Ag/0.5Cu)</td>
<td>80.1-88.8</td>
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<tr>
<td>Alloy</td>
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<td>Silver (Ag)</td>
<td>Copper (Cu)</td>
<td>Indium (In)</td>
<td>Lead-Free</td>
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<tr>
<td>263</td>
<td>99Sn/0.3Ag/0.7Cu</td>
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<tr>
<td>NS</td>
<td>90Sn/7.5Bi/2Ag/0.5Cu</td>
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<td>1.7-1.8</td>
<td>0.42-0.46</td>
<td>6.2-6.9</td>
<td>-</td>
</tr>
</tbody>
</table>

**NS = Non-standard alloy mixture**

*RoHS 2 = Restriction of Hazardous Substances*

*RoHS 3-products do not contain any of the listed phthalates*

### 4. FIRST AID MEASURES

**Eye Contact:**
Hold eyelids apart and flush eyes with plenty of tepid water for at least 15 minutes. Seek medical attention if irritation persists.

**Ingestion:**
If patient is conscious, ONLY induce vomiting as directed by trained personnel. NEVER give anything by mouth to an unconscious person. Seek medical attention immediately. **Inhalation:**
Remove to fresh air. If not breathing, give artificial respiration or oxygen by trained personnel. Seek immediate medical attention.

**Skin Contact:**
Remove contaminated clothing. Wash affected area with soap and water. Wash clothing before reuse. If irritation persists, obtain medical attention.

### 5. FIRE FIGHTING MEASURES

**Flash Point:** Not established.
**Method:** Not established.

**Auto-ignition Temperature:** Not established.

**Flammable Limits:** Limits not established.

**Extinguishing Media:** Use extinguishers appropriate for the surrounding fire conditions.

**Special Fire Fighting Procedures:** Firefighters must wear NIOSH approved self-contained breathing apparatus and full protective clothing.

### 6. ACCIDENTAL RELEASE MEASURES

**Spill or Leak Procedures:** Using a spatula, scoop up paste and place in a plastic or glass jar and tightly cap. Remove traces of paste residue using cloth rags or paper towels moistened with ethyl or isopropyl alcohol. Dispose contaminated cloth rags or paper towels following all Federal, State and Local regulations. In the EU refer to the Special Waste Regulations. Material may have reclaim value.

### 7. HANDLING AND STORAGE

**Handling Precautions:** Keep containers tightly closed when not in use. Use care to avoid spills. Use only with production equipment specifically designed for use with solder paste. Wear appropriate personal protective equipment when working or handling solder paste. Always thoroughly wash your hands after handling this product. DO NOT touch or rub eyes until hands are washed.

**Storage Precautions:** Store product in tightly capped original containers in a cool, dry area. Refer to product label for specific storage temperature requirements. Rotate stock to ensure use before expiration date on the label.
8. EXPOSURE CONTROLS / PERSONAL PROTECTION

Engineering Controls: Use only with production equipment (stencil printers and re-flow furnaces) with adequate ventilation and other safety features specifically designed for use with solder paste. Control concentration of all components so that exposure levels are not exceeded.

Personal protection:
Eyes: Chemical safety glasses/goggles. Face shield for splash hazards.
Respirator: An authority approved or compliant marked air-purifying respirator with a fume/organic chemical cartridge is recommended under certain circumstances (i.e. when re-flowing manually on a plate instead of a ventilated re-flow furnace) where airborne concentrations are expected to be elevated or exceed exposure limits.
Skin: Compatible chemical resistant gloves. Do not use latex gloves.
Other: Lab coat, eyewash fountain in work area. Avoid the use of contact lenses in high fume areas.
Work/Hygienic Practices: Maintain good housekeeping. Clean up spills immediately. DO NOT allow rags or paper towels contaminated with solder paste to accumulate in the work area. Good personal hygiene is essential. Avoid eating, smoking or drinking in the work area. Wash hands thoroughly with soap and water immediately upon leaving the work area.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance: Grey colored paste.
Odor: Mild characteristic odor.
Specific Gravity: Not applicable.
Vapor Pressure: Not applicable.
Vapor Density: (air=1) Not applicable.
Boiling Point: Not applicable.
Melting Point: Not applicable
pH: Not applicable
Solubility in Water: Insoluble (paste)

10. STABILITY AND REACTIVITY

General: Stable.
Conditions to Avoid: Not established.
Incompatible Materials: Avoid contact with acids, bases or oxidizing agents.
Hazardous Decomposition / Combustion: Harmful organic fumes and toxic oxide fumes may form at elevated temperatures.
Hazardous Polymerization: Will not occur.

11. TOXICOLOGICAL INFORMATION

Carcinogenicity: NTP: No
OSHA: No
IARC: Yes Lead and lead compounds are listed as possible carcinogens.
LD50: Not established.
LC50: Not established.
Other: Chronic Toxicity: Prolonged or repeated exposure to rosin flux fume may cause workers to develop occupational asthma. Lead can cause potential harm to the developing fetus.
12. ECOLOGICAL INFORMATION

Product not tested.

An environmental hazard cannot be excluded in the event of unprofessional handling. Some ingredients contained are harmful to the environment.

Copper – Toxicity to daphnia and other aquatic invertibrates mortality NOEC – Daphnia 0.004 mg/l – 24h.

Lead – Toxicity to fish – mortality LOEC – rainbow trout – 1.19 mg/l – 96h. Very toxic to aquatic organisms, may cause long-term adverse effects in the aquatic environment. Bioaccumulation – Oncorhynchus kisutch – 2 weeks Bioconcentration factor (BCF): 12. Fresh fish: 0.44 mg/l LC50 96h/ 1.32 mg/l LC50 96h/water Flea: 600 ug/l EC50 = 48h

13. DISPOSAL CONSIDERATION

Waste Disposal Method: Scrap metal alloy usually has value. Contact a commercial reclaimer for recycling. Otherwise, dispose of in accordance with all Federal, State and Local environmental regulations. In Europe follow the rules for waste assessments.

14. TRANSPORT INFORMATION

Transport in accordance with applicable international regulations and requirements. Not regulated (US Department of Transportation).

Not hazardous under shipping regulations, all modes.

Non-hazardous under IATA. Not regulated

UN – none    Marine Pollutant: No

North American Emergency Guide Book – Not applicable

15. REGULATORY INFORMATION

The information in this Safety Data Sheet meets the requirements of the United States Occupational Safety and Health Act and regulations promulgated hereunder (29 CFR 1910.1200 ET. SEQ.).

WARNING: This product can expose you to chemicals including [lead] which is known to the State of California to cause cancer, and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov

SARA 313 Listing - 40 CFR 372.65
Lead CAS# 7439-92-1    Silver CAS# 7440-22-4    Copper CAS# 7440-50-8

EPA Genetic Toxicology Program – Lead CAS# 7439-92-1
All ingredients are listed on the EPA TSCA Inventory.

This product has been classified in accordance with the hazard criteria of the Canadian Controlled Products Regulation (CPR).

Canadian WHMIS:  
D2A - Materials Causing Other Toxic Effects-Very Toxic Material (Chronic). (lead)  
D2B – Materials Causing Other Toxic Effects (skin irritation/skin sensitization)

This product has been classified in accordance with the guidelines set by the Dept. of Industrial Health of the Republic of Singapore.

This product has been classified in accordance with Mexican regulations NOM-018-STPS-2015 and NOM-010-STPS-2014.

For compliance with EU Directive 2002/95/EC, Restriction of Hazardous Substances (RoHS), see Alloy Table.

Malaysia:
This product has been classified in accordance with: Malaysian – OCCUPATIONAL SAFETY AND HEALTH (CLASSIFICATION, LABELING AND SAFETY DATA SHEET OF HAZARDOUS CHEMICALS) REGULATION OCTOBER 2013 – (CLASS). (GHS)

In China:
Decree No. 591: Regulations on the Control over Safety of Hazardous Chemicals
GB 30000.2-9-2013, Rules for classification and labeling of chemicals. (GHS)
GB/T 16483-2008, GB/T 17517-2013
This product has been classified using the Chinese Occupational Limit for Hazardous Agents in the Workplace, GBZ2-2007

All ingredients are listed on the China Chemical Inventory.

### 16. OTHER INFORMATION

<table>
<thead>
<tr>
<th>HMIS Hazard Rating:</th>
<th>Health:</th>
<th>2</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>Fire:</td>
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<tr>
<td></td>
<td>Reactivity:</td>
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</tbody>
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**Revised Date:** 24 OCTOBER 2018  
**Prepared by:** Nancy Swarts, Indium Corporation of America  
**Approved by:** Nancy Swarts, Indium Corporation of America

The information and recommendations contained herein are, to the best of The Indium Corporation of America's knowledge and belief, accurate and reliable as of the date issued. The Indium Corporation of America does not warrant or guarantee their accuracy or reliability, and The Indium Corporation of America shall not be liable for any loss or damage arising out of the user thereof. The information and recommendations are offered for the user's consideration and examination, and it is the user's responsibility to satisfy itself that they are suitable and complete for its particular use. If buyer repackages this product, legal counsel should be consulted to insure proper health, safety and other necessary information is included on the container. The Indium Corporation does not recommend, manufacture, market or endorse any of its products for human consumption.