



This safety data sheet represents a family grouping of all metal mixes that are blended with the same flux. A 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.

## SAFETY DATA SHEET

### 1. PRODUCT AND COMPANY IDENTIFICATION

**Product Identifier:** INDALLOY WITH INDIUM 9.52 FLUX VEHICLE

**SDS Number:** SDS-4100

**Revised Date:** 11 APRIL 2018

**Product Use:** Industrial Use: No-clean solder paste consisting of a flux vehicle blended with an 83-92 % pre-alloyed metal powder. Review alloy table.

#### MANUFACTURER:

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**2. HAZARDS IDENTIFICATION**

**PRIMARY ROUTES OF ENTRY:**

⊗ Eye    ⊗ Inhalation    ⊗ Skin    ⊗ Ingestion    NTP

**Carcinogen listed in**

IARC    OSHA    ⊗Not Listed  
See Section 11

GHS:

Lead free products



Signal Word: Warning

Hazard statement(s)

H317            May cause an allergic skin reaction  
 H320            Causes eye irritation  
 H334            May cause allergy or asthma symptoms or breathing difficulties if inhaled  
 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 + P341    IF INHALED: If breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing  
 P305 + P351    IF IN EYES: Rinse continuously with water for several minutes (15 mins)  
 P501            Dispose of content via approved waste handling or recycle if possible.

Lead containing products



Signal Word: Warning

Hazard statement(s)

H317            May cause an allergic skin reaction  
 H320            Causes eye irritation  
 H334            May cause allergy or asthma symptoms or breathing difficulties if inhaled  
 H332            Harmful if inhaled  
 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. 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  
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 P501 Dispose of content via approved waste handling or recycle if possible.

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**Classification:**

Eye Irritant - Category 2A  
 Specific target organ toxicity- single exposure- Category 3- respiratory system  
 Acute toxicity, Oral (Category 4) (lead)  
 Carcinogenicity (Category 2) (lead)  
 Reproductive toxicity (Category 2) (lead)  
 Acute aquatic toxicity (Category 1) (lead) (H400)  
 Chronic aquatic toxicity (Category 1) (lead) (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 may contain alloy powder 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. When heated rosin may be a respiratory sensitizer.

**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.

**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](http://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**

Components	% wt	CAS Registry #/EINECS#	PEL mg/m <sup>3</sup>	TLV-TWA mg/m <sup>3</sup>	TLV-STEL mg/m <sup>3</sup>
<b>TIN</b>	*	7440-31-5/231-141-8			
		(US)	2	2	-
		(EU)	-	2	4
		(Canada)	-	2	4
		(Singapore)	2	-	-
<b>LEAD</b>	*	7439-92-1/231-100-4			
		(US)	0.05	0.05	-
		(EU)	-	0.15	-
		(Canada)	0.05	0.05	-
		(Singapore)	0.15	-	-
		(Mexico)	N.E.	0.15	-
		(China)	-	0.05(dust) 0.03(fume)	-
<b>SILVER</b>	*	7440-22-4/231-131-3			
		(US)	0.01	0.1	-
		(EU)	-	0.1	-
		(Canada)	-	0.1	0.3
		(Mexico)	-	0.1	-
		(Singapore)	0.1	-	-
<b>COPPER</b>	*	7440-50-8/231-159-6			
		(US)	0.1 (fume)	0.2 (fume)	-
		(EU)	-	0.2 (fume)	-
		(Canada)	-	0.2 (fume)	0.6 (fume)
		(Mexico)	-	0.2 (fog)	2 (powder)
		(Singapore)	0.2(fume)	1(dust)	-
		(China)	-	1(dust) 0.2(fume)	2.5 0.6
<b>ANTIMONY</b>	*	7440-36-0/231-146-5			
		(US)	0.5	0.5	-
		(EU)	0.5	-	-
		(Canada)	-	0.5	1.5

		(Mexico)	N.E.	0.5	-
		(Singapore)	0.5	-	-
		(China)	-	0.5	-
<b>ROSIN</b>	2.5-3.5	65997-05-9 (US)	N.E.	N.E.	N.E.
		(EU)	0.05	N.E.	0.15 (sensitiser)
<b>PROPRIETARY</b>	5.5-13.5	-	N.E.	N.E.	N.E.

N.E. = Not established      \*See Alloy Table

**ALLOY TABLE**

%Metal in flux

Indalloy (Metal)	%TIN Sn	%SILVER Ag	%LEAD Pb	%ANTIMONY Sb	RoHS 2/3 Compliance
<b>104(Sn62)</b> (62.5Sn/36.1Pb/ 1.4Ag)	51.9-57.5	1.2-1.8	29.9-33.2	-	NO
<b>106(Sn63)</b> (63Sn/37Pb)	52.3-58	-	30.7-34	-	NO
<b>121</b> (96.5Sn/3.5Ag)	80.1-88.8	2.9-3.2	-	-	YES
<b>151</b> (92.5Pb/5Sn/2.5 Ag)	4.15-4.6	2.08-2.3	76.8-85.1	-	YES*
<b>228</b> (88Pb/10Sn/ 2Ag)	8.3-9.2	1.7-1.8	73.-81	-	YES*
<b>259</b> (90Sn/10Sb)	74.7-82.8	-	-	8.3-9.2	YES

**+RoHS 2 = Restriction of Hazardous Substances (review list of applicable exemptions) (2011/65/EU)**  
**RoHS 3- product does not contain any 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.

#### 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. Consult Product Data Sheet for additional information.

#### 8. EXPOSURE CONTROLS / PERSONAL PROTECTION

**Engineering Controls:** Use only with production equipment such as 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 the exposure levels are not exceeded.

**Personal protection:**

**Eyes:** Chemical safety glasses/goggles. Face shield for splash hazards.

**Respirator:** A NIOSH approved or EU compliant CE 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.

**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

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

## 10. STABILITY AND REACTIVITY

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

## 11. TOXICOLOGICAL INFORMATION

<b>Carcinogenicity:</b>	<b>NTP:</b> No	
	<b>OSHA:</b> No	
	<b>IARC:</b> Yes	Lead and lead compounds are listed as possible carcinogens.
<b>LD50:</b>	Not established.	<b>LC50:</b> 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.

RTECS: OF7525000 (lead)

Lead  
reproductive toxicity – rat –inhalation  
reproductive toxicity – rat – oral  
reproductive toxicity – mouse-oral

Teratogenicity  
Developmental toxicity – rat- inhalation  
Developmental toxicity- rat- oral  
Suspected human reproductive toxicant

GHS- Specific target organ toxicity- repeated exposure  
May cause damage to organs through prolonged or repeated exposure

Lead- OSHA Hazards- carcinogen/target organ effect/harmful by ingestion/teratogen.

## 12. ECOLOGICAL INFORMATION

Product not tested.

Lead:

Toxicity to fish:

Rainbow trout- 1.19mg/l-96h

LC50 micropterus dolomieu- 2.2 mg/l-96h

Mortality NOEC-salvelinus fontinalis-1.7 mg/l-10d

Toxicity to algae

Mortality EC50-skeletonema costatum-7.94mg/l-10d

An environmental hazard cannot be excluded in the event of unprofessional handling, use and or disposal of this product.

Contains a substance (lead) that is very toxic to aquatic life with long lasting effects.

### 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 Special Waste Regulations.

### 14. TRANSPORT INFORMATION

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

Non-hazardous for shipping (ground/IATA/Ocean).

UN- None

Marine Pollutant: No.

RQ (LEAD) =10 LBS (powder form)

### 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.).

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

WHMIS: D2A-Materials Causing Other Toxic Effects-Very Toxic Material (Chronic). Otherwise insufficient information.

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.

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



Regulatory Information China:  
GB/T 16483-2008, GB/T 17519-2013, Safety Data Sheets for Chemical Products  
GB 30000.2-29-2013, Rules for classification and labeling of chemicals (GHS)  
Decree No. 591: Regulations on the Control Over Safety of Hazardous Chemicals.  
This product has been classified using the Chinese Occupational Limit for Hazardous Agents in the Workplace, GBZ2-2007.



**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](http://www.P65Warnings.ca.gov)

SARA 313 Listing - 40 CFR 372.65

Lead CAS# 7439-92-1

Silver CAS# 7440-22-4

Antimony CAS# 7440-36-0

EPA Genetic Toxicology Program – Lead CAS# 7439-92-1

All ingredients are listed on the EPA TSCA Inventory.

## 16. OTHER INFORMATION

<b>HMIS Hazard Rating:</b>	<b>Health:</b>	2
	<b>Fire:</b>	1
	<b>Reactivity:</b>	0

**Revised Date:** 11 APRIL 2018

**Prepared by:** Nancy Swarts, Indium Corporation of America

**Approved by:** Nancy Swarts, Indium Corporation of America

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