



## SAFETY DATA SHEET

### 1. PRODUCT AND COMPANY IDENTIFICATION

**Product Identifier:** INDALLOY WITH INDIUM 8.9H FLUX

**SDS Number:** SDS-5812

**Revised Date:** 19 MARCH 2018

**Product Use:** Industrial Use (mixture) - solder paste consisting of a flux vehicle blended with **88-89** weight percent pre-alloyed metal powder.

#### MANUFACTURER:

##### In America:

The Indium Corporation of America®  
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##### In Asia:

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**2. HAZARDS IDENTIFICATION****PRIMARY ROUTES OF ENTRY:**

⊕Eye    ⊕Inhalation    ⊕Skin    ⊕Ingestion    NTP    IARC    OSHA    ⊕Not Listed

**Carcinogen listed in**

GHS:

Lead free products



Signal Word: Warning

Hazard statement(s)

H317            May cause an allergic skin reaction  
 H319            Causes serious eye irritation  
 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 + 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)

Lead containing products



Signal Word: Warning

Hazard statement(s)

H303            May be harmful if swallowed  
 H317            May cause an allergic skin reaction  
 H319            Causes serious eye irritation  
 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  
 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  
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P301 +P314 IF SWALLOWED: Get Medical advice/attention if you feel unwell  
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 P305 + P351 IF IN EYES: Rinse continuously with water for several minutes (15 mins)

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**Classification:**

Carcinogenicity (Category 2) (lead)

Reproductive toxicity (Category 2 ) (lead)

Skin sensitizer-Category 1B

Respiratory sensitizer-Category 1B

Eye irritation-Category 2A

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 serious eye irritation.

**Ingestion:** This product contains metal 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. May be harmful if inhaled. Inhalation of rosin fume may cause occupational asthma.

**Skin Contact:** May cause skin irritation. Rosin may cause dermatitis and skin sensitization.

**Chronic:**

**SILVER:** Chronic skin contact or ingestion of silver powder, 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 of copper may cause metal fume fever (chills, muscle aches, nausea, fever; dry throat, cough, weakness, lassitude); metallic or sweet taste; discoloration of skin and hair.

**LEAD:** Prolonged exposure to vapors or fumes at higher temperatures may cause respiratory irritation and systematic lead poisoning.

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

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



**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)

**3. COMPOSITION / INFORMATION ON INGREDIENTS**

| <b>Components</b> | <b>% wt</b> | <b>CAS Registry #/<br/>EINECS#</b> | <b>PEL<br/>mg/m<sup>3</sup></b> | <b>TLV-TWA<br/>mg/m<sup>3</sup></b> | <b>TLV-STEL<br/>mg/m<sup>3</sup></b> |
|-------------------|-------------|------------------------------------|---------------------------------|-------------------------------------|--------------------------------------|
| <b>TIN</b>        | *           | 7440-31-5/231-141-8                |                                 |                                     |                                      |
|                   |             | (US)                               | 2                               | 2                                   | -                                    |
|                   |             | (EU)                               | -                               | 2                                   | 4                                    |
|                   |             | (Canada)                           | -                               | 2                                   | 4                                    |
|                   |             | (Singapore)                        | 2                               | -                                   | -                                    |
| <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(fume)                           | 2                                    |
|                   |             | (Singapore)                        | 0.2                             | -                                   | -                                    |
|                   |             | (China)                            | -                               | 1(dust)                             | 2.5                                  |
|                   |             |                                    | 0.2(fume)                       | 0.6                                 |                                      |
| <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)<br>0.03(fume)            | -                                    |
| <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>                  | 5.0 – 6.0 | 65997-05-9  | N.E. | N.E. | N.E.              |
|                               |           | (EU)        | 0.05 | N.E. | 0.15 (sensitiser) |
| <b>POLYGLYCOL ETHER</b>       | 3.0 – 5.0 | 9038-95-3   | N.E. | N.E. | N.E.              |
| <b>PROPRIETARY ACTIVATORS</b> | 1.0 – 3.0 | -           | N.E. | N.E. | N.E.              |

N.E. = Not established

“\* See Alloy table

**ALLOY TABLE**

**88-89% metal load**

| INDALLOY Metal Mix                             | %TIN Sn   | %SILVER Ag | %COPPER Cu | %ANTIMONY Sb | %LEAD Pb  | RoHS 2/3 Compliance |
|--|-----------|------------|------------|--------------|-----------|---------------------|
| 121<br>(96.5Sn/3.5Ag)                          | 85-85.9   | 3.08-3.1   | -          | -            | -         | Yes                 |
| 233<br>(85Pb/10Sb/5Sn)                         | 4.4-4.45  | -          | -          | 8.8-8.9      | 74.8-75.7 | Yes*                |
| 241<br>(SAC387)<br>95.5Sn/3.8Ag/0.7Cu)         | 84-85     | 3.3-3.4    | 0.62-0.623 | -            | -         | Yes                 |
| 256<br>(SAC305)<br>96.5Sn/3Ag/0.5Cu)           | 85-85.9   | 2.6-2.67   | 0.44-0.445 | -            | -         | Yes                 |
| 268<br>(SACM0510)<br>(98.5Sn/0.5Ag/1Cu/0.05Mn) | 86.7-87.7 | 0.44-0.445 | 0.88-0.89  | -            | -         | Yes                 |

RoHS 2/3 = (2011/65/EU) \* Complies with high melting lead exemption

No 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.

#### 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 any permissible exposure limits 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. Latex gloves not recommended.

**Other:** Lab coat, eye-wash 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. When working with lead containing products use standard lead work procedures.

## 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> | 1 g/cc (flux)             | <b>pH:</b>                  | 4 – 8 (flux)      |
| <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.

Product not tested.

## 12. ECOLOGICAL INFORMATION

Product not tested.

## 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 regulations and requirements. Not regulated under US DOT (United States Department of Transportation).

Non - hazardous under all international shipping requirements.

UN – none

North American Emergency Guide Book 2012 – Not Classified

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

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



Canadian WHMIS: D2B – Materials Causing Other Toxic Effects – irritation/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 the hazard criteria of the Mexican regulations: NOM-018-STPS-2015 and NOM-010-STPS-2014.

### 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 30000.2-29-2013, Rules for classification and labeling of chemicals. (GHS)  
GB/T 16483-2008, GB/T 17517-2013

SARA 313 Listing - 40 CFR 372.65  
Silver Copper Lead Antimony

All ingredients are listed on the EPA TSCA Inventory.



Most of the ingredients are listed on the Canadian Domestic Substance List.

## 16. OTHER INFORMATION

**HMIS Hazard Rating:**

|                    |   |
|--------------------|---|
| <b>Health:</b>     | 1 |
| <b>Fire:</b>       | 1 |
| <b>Reactivity:</b> | 0 |

**Revised Date:** 19 MARCH 2018

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

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

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**Note: This SDS may be translated into an international language. If there is any misinterpretation or misunderstanding of any words or phrases that may occur within any translation the ENGLISH language shall always prevail.**