SAFETY DATA SHEET

1. PRODUCT AND COMPANY IDENTIFICATION

Product Identifier: INDALLOY WITH 370.14 FLUX VEHICLE
SDS Number: SDS-6096
Revised Date: 23 JULY 2015
Product Use: Industrial Use - solder paste consisting of a flux vehicle blended with 83-92 weight percent pre-alloyed metal powder.

MANUFACTURER:

In America:
The Indium Corporation of America
1676 Lincoln Ave., Utica NY 13502
Information: (315) 853-4900
nswarts@indium.com

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

In Europe:
Indium Corporation of Europe
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
2. HAZARDS IDENTIFICATION

PRIMARY ROUTES OF ENTRY:
⊕ Eye  ⊗ Inhalation  ⊕ Skin  ⊗ Ingestion

Carcinogen listed in
NTP  IARC  OSHA  ⊗ Not Listed

GHS:

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

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)

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. 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.

WARNING: This product contains a chemical known to the State of California to cause cancer and/or birth defects (or other reproductive harm). (trace levels of lead)
### 3. COMPOSITION / INFORMATION ON INGREDIENTS

<table>
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<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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<td>SILVER</td>
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<td>(China) -</td>
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<td>0.2 (fume)</td>
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*Doped with 100-500 ppm Mn

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<th>ROSIN</th>
<th>4 - 6</th>
<th>65997-05-9</th>
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Product contains an additive that is not on the US TSCA Inventory but is filed under the LVE exemptions of TSCA.
N.E. = Not established

<table>
<thead>
<tr>
<th>Indalloy (Metal Mix)</th>
<th>% Tin</th>
<th>% Silver</th>
<th>% Copper</th>
<th>RoHS 2 Compliance</th>
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<tr>
<td>260(SACM105)*</td>
<td>81.8-90.6</td>
<td>0.83-0.92</td>
<td>0.42-0.46</td>
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<tr>
<td>268 (SACM0510)*</td>
<td>81.8-90.6</td>
<td>0.42-0.46</td>
<td>0.83-0.92</td>
<td>Yes</td>
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</table>

- Doped with Mn

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- nitrile.
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.

9. PHYSICAL AND CHEMICAL PROPERTIES

Appearance: Grey colored paste.
Odor: Mild characteristic odor.
Specific Gravity: 1 g/cc (flux)
Vapor Pressure: Not applicable.
Vapor Density: (air=1) Not applicable.
Boiling Point: Not applicable.
Melting Point: Not applicable
pH: 5 – 7 (flux)
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: No

LD50: Not established.  
LC50: Not established.

Other: Chronic Toxicity: Prolonged or repeated exposure to rosin flux fume may cause workers to develop occupational asthma.

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 shipping requirements, any mode.

UN – none


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).

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 Mexican guidelines, NOM-018-STPS-2000 and NOM-010-STPS-1999.

This product has been classified using the Chinese Occupational Limit for Hazardous Agents in the Workplace, GBZ2-2002.
California PROP 65 (Safe Drinking Water Standard):
This product contains a chemical known to the State of California to cause cancer and/or birth defects or other reproductive harm. (trace levels of lead)

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

Ingredients are listed under the US TSCA Inventory or are exempt under LVE.

EC Classification, Packaging and Labeling Requirements:
Symbol and Hazard Classification of Product

Risk Phrases:
R42/43 May cause sensitization by inhalation or by skin contact
R36/37/38 Irritating to eyes, respiratory system and skin

Safety Phrases:
S20/21 When using do not eat, drink or smoke
S23 Do not breathe fumes
S24/25 Avoid contact with skin and eyes
S27 Take off immediately all contaminated clothing
S28 After contact with skin wash immediately with plenty of soap and water
S36/37/39 Wear suitable protective clothing, gloves and eye/face protection
S62 If swallowed, do not induce vomiting seek medical advice immediately and show container or label
S7 Keep container tightly closed

16. OTHER INFORMATION
HMIS Hazard Rating:
Health: 2
Fire: 1
Reactivity: 0
<table>
<thead>
<tr>
<th>Revised Date:</th>
<th>23 JULY 2015</th>
</tr>
</thead>
<tbody>
<tr>
<td>Prepared by:</td>
<td>Nancy Swarts, Indium Corporation of America</td>
</tr>
<tr>
<td>Approved by:</td>
<td>Nancy Swarts, Indium Corporation of America</td>
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