ALPHA® OM-340 – Manual dispense solder paste for touch-up

ZERO HALOGEN, LEAD-FREE SOLDER PASTE

STORAGE and HANDLING

ALPHA® OM-340 solder paste in dispense syringes should be stored in a refrigerator upon receipt at 0-10°C (32-50°F). A typical syringe is found in Figure 1 below.

The shelf life of the refrigerated solder paste is 6 months from the date of manufacture.

ALPHA® OM-340 solder paste in dispense syringes should be permitted to reach room temperature (typically two hours) before unsealing tip and end closures. Paste must be ≥19°C (66°F) before processing.

ALPHA® OM-340 solder paste can be stored for two weeks up to 25°C (77°F) prior to use. The solder paste should be used within this two week window.

Best practice is to dispose of needles after 24 hours of use and replace with a new needle. A typical needle is found in Figure 2 below. An alternative method of ensuring the quality of the solder paste that will be dispensed is to purge the needle of any paste after 24 hours of the syringe sitting idle without use. If the needle is removed from the syringe, the original tip cap (see Figure 1) should be placed on the syringe to ensure there is no paste drying.

Refer to Table 1 below for estimates on the amount of paste that may be in the syringe needle. Needles that are compliant with Leur Lock connections should be used.

Table 1:

Estimates of Volume of Solder Pastes with Common Needle Gauges				
Needle Gauge	Inner Diameter (cm)	Length (cm)	Paste Volume in Needle (cc)	Grams of Solder paste
21	0.0584	1.27	0.003	0.014
21	0.0584	2.54	0.007	0.028
25	0.0305	1.27	0.001	0.004
25	0.0305	2.54	0.002	0.008

Any dry paste that accumulates at the tip of the needle during use should be removed with a dry, lint free cloth.

Care should be taken so that syringes are not stored near a heat source. This may cause the solder paste to increase above room temperature and will shorten the room temperature shelf life of the paste.

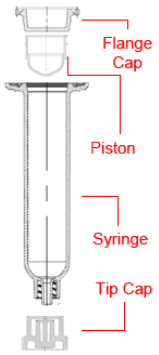

Figure 1: Typical syringe*

Figure 2: Typical needle*

"A" = length of the needle

*NOTE: Images not to scale