

## SHIPPING

LOCTITE GC 18 solder paste is packed in standard cases in jars or cartridges. Cartridges are packed and shipped tip-down to minimize the risk of separation.

### Shipping Temperature

In an uncontrolled external environment, the temperature should not exceed 43°C (109°F). LOCTITE GC 18 solder paste is shipped with a temperature indicator label to record the maximum temperature experienced during transit.

Exposure up to 43°C (109°F) for up to 1 week (transit time) with no direct sunlight will have no negative impact on the product.

If external temperature conditions are expected to exceed 43°C (109°F) during transit, it is recommended to use cold packs to ensure the product temperature remains below 43°C (109°F).

Unless specifically requested LOCTITE GC 18 is shipped without cold packs. If shipment with cold packs is preferred, advise the customer service representative at the point of order.

## RECEIVING

**Goods Inwards Temperature:** Should not exceed 43°C (109°F). Should the temperature indicator label show that the temperature during transit exceeded 43°C then follow local guidelines for CCMS (Customer Complaints Management system)

**Transfer to Controlled Storage:** Immediately on receipt, transfer the paste to a storage area in accordance with the recommended storage conditions.

## STORAGE

**Storage on Site:** Jars of LOCTITE GC 18 solder paste should be stored unopened

Cartridges of LOCTITE GC 18 solder paste should be stored tip down to reduce the risk of flux separation.

### Storage Temperature:

As package label instruction: 5-25°C (41-77°F)  
Additional information is below:

Storage time	Storage temperature (no impact on product)
12 months	<5°C (<41°F)
6 months	5-25°C (41 - 77°F)
≤1 month	>25 - <43°C (>77 - <109°F)

Shelf life is 6 months at 5-25°C.

**Stock Control:** It is recommended that solder paste from different batches is segregated and that a first-in, first-out stock control system is maintained.

## HANDLING

**Storage:** It is recommended that LOCTITE GC 18 solder paste is stored below 25°C (77°F) to guarantee minimum 6 months shelf life. Storage below this temperature will have no negative effect on the material properties and performance.

Storage above 25°C (77°F) may reduce the storage stability of the material.

**Before Use:** If refrigerated, the LOCTITE GC 18 should always be allowed to return to 20-25°C (68-77°F) naturally before use (or removal of tip cap). Failure to do this may adversely affect the performance during dispensing and/or reflow.

If LOCTITE GC 18 solder paste is stored at temperatures of:

- 20-25°C (68-77°F), it can be used immediately.
- <20°C (68°F), it should be allowed to return to 20-25°C (68-77°F) before use
- >25°C (77°F) and <43°C (109°F), it should be allowed to return to 20-25°C (68-77°F) before use
- Under refrigerated conditions (0-10°C, 32-50°F), a minimum of four hours should be allowed for paste to stabilise to 20-25°C (68-77°F).

**Working Environment:** Maintaining an ambient temperature of between 20 and 25°C (68-77°F) at a relative humidity of 30 – 60% RH will ensure consistent performance and maximum life of the paste.

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# Handling Guidelines

## Temperature Stable Solder Paste

**Stirring:** LOCTITE GC 18 solder paste packed in jars can be restored to its specified rheology by stirring using a non-metallic or round-edged spatula for 1 – 2 minutes before being applied to the printer. Solder paste dispensed from a cartridge does not require stirring as the rheology is restored during the dispensing and printing (knead) process.

In the case that flux separation is observed after storage at higher temperatures the paste can be restored by stirring until homogeneous.

For use guidelines refer to local procedures and/or the Technical Data Sheet or Engineer's Manual for LOCTITE GC 18 solder paste.

**Thinning:** The addition of any material to LOCTITE GC 18 solder paste is never recommended.

**Paste Life:** LOCTITE GC 18 solder paste can be used on the stencil at least 8 hours. Paste which has been on the printer can be stored in a sealed container at room temperature for up to 72 hours before being re-used. It is preferable to store used paste in a separate container.

**Cleaning:** Stencils used to print LOCTITE GC 18 solder paste can be cleaned using typical solvent cleaners used for solder paste. It is recommended that all equipment is cleaned and dried thoroughly immediately after use. For best results, scrubbing in the solution by either ultrasonic action or brush will ensure all solder particles are completely removed.

**Packaging Availability:** LOCTITE GC 18 solder paste is available in 500g jars and 600g Semco cartridges. Other suitable packaging may become available if requested.

**Disposal:** Used LOCTITE GC 18 solder paste should be stored in a sealed container and disposed of in accordance with local authority requirements, refer to the Safety Data Sheet (SDS).

### GENERAL INFORMATION

For safe handling information, consult the Safety Data Sheet (SDS).