



Dispensing Handling Guidelines LOCTITE GC 50 Solder Paste

January 2020

SHIPPING

LOCTITE GC 50 solder paste is packed in cartridges and shipped in a vertical position, tip-down to minimize the risk of separation. The inside flap of the cartridge box has a temperature indicator label affixed.

Shipping temperatures: In an uncontrolled external environment the temperature should not exceed 43°C (109°F). LOCTITE GC 50 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 50 is shipped without cold packs. If shipment with cold packs is required, advise the customer service representative at the point of order.

RECEIVING

Goods inwards temperature: If the temperature indicator label shows that the temperature during transit exceeded 43°C (109°F), follow local guidelines for CCMS (Customer Complaints Management System).

Time to transfer to controlled storage: Immediately on receipt transfer the paste to the storage area in accordance with the storage conditions recommended as below.

STORAGE

Storage on site: As received. Cartridges of LOCTITE GC 50 solder paste should be stored in a vertical position, tip-down to avoid flux separation.

Storage temperature:
Per cartridge label instruction: 5-25°C (41-77°F).
Shelf life is 6 months at 5-25°C (41-77°F).

Added information is below:

Americas
Henkel Corporation
14000 Jamboree Road
Irvine, CA 92606 USA
+1.714.368.8000

Europe
Henkel Limited.
Wood Lane End
Hemel Hempstead
Hertfordshire HP2 4RQ
+44 (0) 1442 278000

Asia
Henkel (Malaysia) Sdn Bhd
Lot 62049 Jalan Portland
Tasek Industrial Estate
31400 Ipoh, Malaysia
+605.547.6811

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

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 50 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.

LOCTITE GC 50 cartridges should ALWAYS be stored

- With tip cap attached (no needle)
- In a vertical position tip-down (in a rack)
- Without removal of end cap

LOCTITE GC 50 cartridges should NOT be stored

- Without tip cap
- With needle attached
- Non-vertical position
- Without the end cap

Paste Life: In most applications the paste should be dispensed completely. However partially used cartridges can be resealed (as mentioned above) and kept in a vertical position, tip-down for up to 2 weeks at 20-25°C (68-77°F).

Unopened cartridge:

Condition	Temperature (°C/°F)	Unopened storage	Avoid
From receipt	5-25/ 41-77	Vertical position, tip-down	Artificial warming of the cartridge. Removing tip cap. Storing cartridge in non-vertical position.
Refrigerated	< 5/ 41		
Room temperature	20-25/ 68-77		

Partially used cartridge:

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Cartridges should be resealed with tip cap and stored at 20-25°C (68-77°F).

Time	After Opening	Avoid Storing
<8hr	Vertical position, tip-down	Without tip cap. With needle attached.
<2wks		Without end cap. In a non-vertical position.

Before Use:

LOCTITE GC 50 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 the cartridge 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 removing tip cap.
- >25°C (77°F) and <43°C (109°F), it should be allowed to return to 20-25°C (68-77°F) before removing tip cap.
- Under refrigerated conditions (0-5°C, 32-41°F), a minimum of at least two hours should be allowed for paste to stabilise to 20-25°C (68-77°F).

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

Conditioning: To ensure consistent dispense quality, it is recommended that 1-2cm bead of solder paste be manually pressed out. This should be followed by purging in the dispense head until the paste comes out of the needle.

This should be practised for both unused and correctly stored used cartridges.

Thinning: The addition of any material to LOCTITE GC 50 solder paste is never recommended.

Packaging availability: LOCTITE GC 50 solder paste is available in EFD and Iwashita cartridges. Other suitable cartridges may become available if requested.

Disposal: Used LOCTITE GC 50 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).