



QUALITEK®

DELTA® 615D Solder Paste No-Clean, Syringe Dispensing

DESCRIPTION

615D is a No-clean solder paste designed for surface mount applications using a syringe dispensing method.

BENEFITS

- **Bellcore compliant**
- **Excellent dot-to-dot consistency**
- **Non corrosive**
- **High SIR**
- **No cleaning required**

APPLICATION

NEEDLE GAUGE / PARTICLE SIZE

- 14 - 18: Use -200+325 mesh
- 20 - 23: Use -325+500 mesh
- 25: Use -400+635 mesh
- 27: Use -500 mesh

ALLOYS

Sn63/Pb37, Sn62/Pb36/Ag2, etc.
(Meets J-STD-006 Specification)

METAL CONTENT – 88%

REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 615D can be processed in most reflow media, (i.e. IR, Vapor-phase, Forced convection, etc.). Ramp rate of 2.5-3.0°C per second is desirable, since most components are rated for 4.0°C per second.

PHYSICAL / CHEMICAL CHARACTERISTICS

Color and Appearance	Metallic Gray
Copper Mirror Test	Pass/No breakthrough
Silver Chromate (Chloride & Bromide Test)	Pass/No discoloration
Surface Insulation Resistance-Ohms	
J-STD-004	>1.0 x 10 ¹⁰
Slump Test	Pass
Electromigration³	Pass
pH-5% Aqueous Solution (Flux Extract)	5.3 – 5.9
Softening Point	94°C
Viscosity	
Malcom ¹	85 -110 kcps, 88% metal
Brookfield ²	300 - 400 kcps +/- 10%, 88% metal

SHIPPING & STORAGE

Recommended Storage Temperature 35°-50°F

SHELF LIFE

Unopened Container	35°-50°F	3 - 6 Months (from DOM)
	77°F	1 Months (from DOS)

1. Malcom PCU-Series, 10 RPM, 25°C
2. Brookfield RVTD, TF spindle, 5 RPM, 25°C, 0.75" spindle depth
3. Bellcore GR-78-CORE

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Consult MSDS for health and safety information

615D PROFILE

