



QUALITEK®

DELTA® 619D Solder Paste No-Clean, Syringe Dispensing

DESCRIPTION

619D is a No-clean solder paste designed for surface mount applications using a syringe dispensing method. Post soldering residues are soft and pin – probable.

BENEFITS

- Bellcore compliant
- Excellent dot-to-dot consistency
- Non corrosive
- Pin Testable post solder residue
- Excellent wetting on OSP
- 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. 619D 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
Electromigration ³	Pass
pH-5% Aqueous Solution (Flux Extract)	6.0-8.0
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	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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Rev: A

Consult MSDS for health and safety information

619D PROFILE

