



# QUALITEK®

## DELTA® 215D Solder Paste Rosin Mildly Activated (RMA)

### DESCRIPTION

215D is a non-corrosive and mildly activated rosin solder paste designed for surface mount applications using a syringe dispensing method.

### BENEFITS

- Excellent Activity
- Excellent dot-to-dot consistency
- No clogging/stringing
- No slump

### 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

Sn96.5/Ag3.5,  
(Meets J-STD-006 Specification)

**METAL CONTENT** – 86%

### REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 215D 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 <sup>10</sup>
pH-5% Aqueous Solution (Flux Extract)	4.2 – 4.8
Softening Point	80°C
Viscosity	
Malcom <sup>1</sup>	85 -110 kcps, 86% metal
Brookfield <sup>2</sup>	300 - 400 kcps +/- 10%, 86% metal

### SHIPPING & STORAGE

Recommended Storage Temperature 35°-50°F

### SHELF LIFE

Unopened Container	35°-65°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

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Consult MSDS for health and safety information

# 215D PROFILE

Alloy: Sn96.5/Ag3.5

