



QUALITEK®

DELTA® 315D Solder Paste Rosin Activated (RA)

DESCRIPTION

315D is a non-corrosive activated rosin solder paste designed for surface mount applications using a syringe dispensing method.

BENEFITS

- Superior Wetting
- Excellent dot-to-dot consistency
- No clogging/stringing

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 – 86%

REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 315D 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) | Present |
| Surface Insulation Resistance-Ohms | |
| J-STD-004 | 1.0 x 10 ⁹ |
| Water Extract Resistivity(Flux Extract) | 135,000 ohm/cm |
| pH-5% Aqueous Solution (Flux Extract) | 4.2 – 4.8 |
| Softening Point | 80°C |
| Viscosity | |
| Malcom ¹ | 85 -110 kcps, 86% metal |
| Brookfield ² | 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

315D PROFILE

