



QUALITEK®

DELTA® 350 Solder Paste Rosin Activated (RA)

DESCRIPTION

350 is a non-corrosive, non-conductive fully activated rosin solder paste designed for surface mount applications.

BENEFITS

- **Excellent Activity**
- **No slump**
- **Non-corrosive**

APPLICATION

PRINTING / PARTICLE SIZE

≥ 50 mil pitch: Use -200 +325 mesh

≥ 16 mil pitch: Use -325 +500 mesh

≤ 16 mil pitch: Use -400 +635 mesh

ALLOYS

Sn63/Pb37, Sn62/Pb36/Ag2, etc.

(Meets J-STD-006 Specification)

METAL CONTENT

Stencil Printing: 90%

Screen Printing: 88%

REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 350 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

J-Std-004 Classification	ROL1
Color and Appearance	Metallic Gray
Copper Mirror Test	Pass
Surface Insulation Resistance-Ohms	
J-STD-004	1.0 x 10 ¹⁰
pH-5% Aqueous Solution (Flux Extract)	4.0 – 4.6
Softening Point	80°C
Viscosity	
Malcom ¹	175 - 205 kcps, 90% metal, (-325+500 mesh)
Brookfield ²	1,000 kcps +/- 10%, 90% metal, (-325+500 mesh)
Tack	
Time	4 - 8 Hours

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 RVT, TF spindle, 5 RPM, 25°C, 0.75" spindle depth

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Consult MSDS for health and safety information

350 PROFILE

