



QUALITEK®

DELTA® 717D Solder Paste Water Soluble, Syringe Dispensing

DESCRIPTION

717D is a Halogen free, water-soluble solder paste designed for surface mount applications using a syringe dispensing method.

BENEFITS

- Halogen Free
- Excellent dot-to-dot consistency
- Eliminates the use of solvents and saponifiers
- Residues are easily removed with warm water

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 – 87%

REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 717D 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
Silver Chromate (Chloride & Bromide Test)	Pass
Slump Test	Pass
J-Std-004 Classification	ORL0
pH-5% Aqueous Solution (Flux Extract)	7.0 – 7.8
Viscosity	
Malcom ¹	85 -110 kcps, 87% metal
Brookfield ²	300 - 400 kcps +/- 10%, 87% metal

SHIPPING & STORAGE

Recommended Storage Temperature 35°-50°F

SHELF LIFE

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

Consult MSDS for health and safety information

717D PROFILE

