



# QUALITEK<sup>®</sup>

## DELTA<sup>®</sup> 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

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. 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

<b>Color and Appearance</b>	Metallic Gray
<b>Copper Mirror Test</b>	Pass/No breakthrough
<b>Silver Chromate (Chloride &amp; Bromide Test)</b>	Pass/No discoloration
<b>Surface Insulation Resistance-Ohms</b>	
J-STD-004	>1.0 x 10 <sup>10</sup>
<b>pH-5% Aqueous Solution (Flux Extract)</b>	4.2 – 4.8
<b>Softening Point</b>	80°C
<b>Viscosity</b>	
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 Month (from DOS)

1. Malcom PCU-Series, 10 RPM, 25°C
2. Brookfield RVTD, TF spindle, 5 RPM, 25°C, 0.75" spindle depth

Delta<sup>®</sup> is a registered trademark of Qualitek International, Inc.

TEL: (630) 628-8083 FAX: (630) 628-6543 E-MAIL: [solder@qualitek.com](mailto:solder@qualitek.com) HOME PAGE: <http://www.qualitek.com>

HEADQUARTERS: 315 Fairbank St., Addison, IL 60101 U.S.A.

WORLDWIDE BRANCHES: UNITED KINGDOM – MEXICO – CHINA – PHILLIPINES - SINGAPORE

**QUALITEK INTERNATIONAL, INC. AN ISO 9002 CERTIFIED COMPANY**

This data is based on information that the manufacturer believed to be reliable and offered in good faith. Qualitek International, Inc. makes no warranties expressed or implied as to its accuracy and assumes no responsibilities and liabilities arising out of its use by others as conditions and methods of use of the products is beyond the control of Qualitek International, Inc. The user must determine the suitability of the product before using it on a commercial basis. The warranties extend only to the conformity of the product to the physical descriptions. In no event will Qualitek International, Inc. be responsible for special, incidental and consequential damages whether the claim is in contract, negligence or otherwise.

Rev: 082099-215D

Consult MSDS for health and safety information

# 215D PROFILE

