



QUALITEK®

DELTA® 798LF Solder Paste

DESCRIPTION

Qualitek has developed a unique flux system that is water soluble and halogen free, designed specifically for heat sink applications. In addition, DSP 798LF Lead Free solder paste exhibits superior joint strength, excellent wettability, which aid in water removal of post soldering residues.

APPLICATION

MESH SIZE / PARTICLE SIZE

-200+325 mesh : 45 – 75 µm
-325+500 mesh : 25 – 45 µm
-400+635 mesh : 20 – 38 µm

DISPENSING/PARTICLE SIZE

Needle Gauge	Needle Inner Diameter		Applicable Powder
	In.	µm	Mesh Cut
18	0.033	838	-200+325
20	0.023	584	-325+500
21	0.020	508	-325+500
22	0.016	406	-325+500
23	0.013	330	-325+500
25	0.010	254	-400+635
27	0.008	203	-500

ALLOY

Alloy Type	Melting Point, °C
Sn42/Bi58	138
Sn69.5/Bi29/Ag1.5	178
Sn69.5/Bi30/Cu0.5	149-186
Sn63/Pb37	183
Sn96.5/Ag3.5	221
Sn96.5/Ag3/Cu0.5	217 – 221

METAL CONTENT

Typically 86% - 92.0 %

REFLOW PROFILE

Reflow Profile is determined by the melting temperature of the solder and the heat resistance of components. 691A-HS 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 sec.

CLEANING

DSP798LF is water soluble formulation therefore the residues need to be removed. Residue removal is easily achieved, with the use of hot 60 C (140 F) de-ionized water in either a batch or conveyORIZED cleaner. Spray pressures should be maintained at 20-30 psi and conveyor speed of 3-6ft/min.

PHYSICAL / CHEMICAL CHARACTERISTICS

Color & Appearance: Metallic Grey
Flux Classification: ORH1
Copper Mirror: Complete removal of copper film
SIR: JSTD-004
Bellcore (Telecordia): 1.57 x 10⁸ ohms
6.12 x 10¹⁰ ohms
Solder Ball Test: Pass
Conforming to Halogen-free requirements:
Cl<900ppm, Br<900ppm, Cl+Br<1500ppm

VISCOSITY

Malcom^①: 150 - 500 Pa.S

TACKINESS

Tack Time^②: 100gF @ 24 hours

SHIPPING & STORAGE

Recommended storage temperature: 2 – 10 oC

SHELF-LIFE

Unopened container: 4 Months from DOM

1. Malcom PCU-203-Series, 10 RPM, 25°C
2. Press, JIS Method

QUALITEK SINGAPORE PTE LTD. AN ISO 9002 CERTIFIED COMPANY

No. 6, Tuas South Street 5, Singapore 637790. TEL: (65) 6795-7757 FAX: 6795-7767

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REV : 1 16-Jul-2015

Consult the MSDS for Health and Safety information

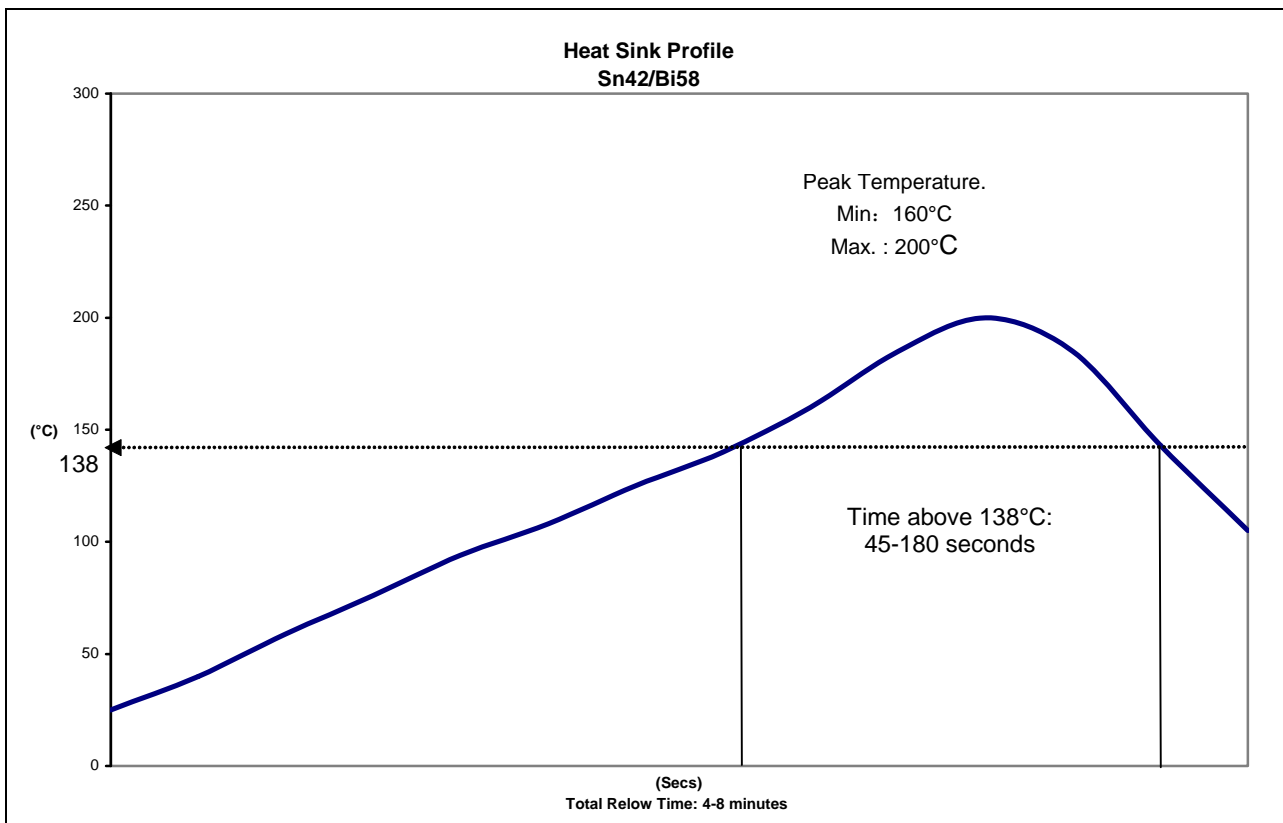


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Heat Sink Profile

REFLOW PROFILE:



注：在回流时要注意元器件是否能承受的最高温度。

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