



QUALITEK®

DELTA® 619D Solder Paste No-Clean, Syringe Dispensing

DESCRIPTION

619D is a No-clean solder paste designed for surface mount applications using a syringe dispensing method.

BENEFITS

- Bellcore compliant
- Excellent dot-to-dot consistency
- Non corrosive
- High SIR
- No cleaning required

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 – 88%

REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 619D 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)	Pass/No discoloration
Surface Insulation Resistance-Ohms	
J-STD-004	>1.0 x 10 ¹⁰
Slump Test	Pass
Electromigration ³	Pass
pH-5% Aqueous Solution (Flux Extract)	5.3 – 5.9
Softening Point	94°C
Viscosity	
Malcom ¹	85 -110 kcps, 88% metal
Brookfield ²	300 - 400 kcps +/- 10%, 88% metal

SHIPPING & STORAGE

Recommended Storage Temperature 35°-50°F

SHELF LIFE

Unopened Container	35°-50°F	3 - 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
3. Bellcore GR-78-CORE

Delta® is a registered trademark of Qualitek International, Inc.

TEL: +44 (0) 151 334 0888 FAX: +44 (0) 151 346 1408 E-mail: sales@qualitek-europe.com Internet: www.qualitek.com
9 Apex Court, Bassendale Road, Wirral International Business Park, Bromborough, Wirral, CH62 3RE



WORLDWIDE BRANCHES: UNITED KINGDOM – MEXICO – CHINA – PHILIPPINES – SINGAPORE-USA

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.

619D PROFILE

