



# QUALITEK®

## Delta Elite™ 775-2

### Water-Soluble Solder Paste

#### DESCRIPTION

775-2 is a halogen free, slump resistant, water-soluble solder paste designed for surface mount and other electronic assembly applications. 775-2 utilizes a low volatility solvent system, resulting in a tack time over 12 hours. Post soldering residue can be easily removed with warm DI water cleaning systems.

#### BENEFITS

- Halogen free
- Non-hygroscopic
- High tack force
- High slump resistance
- Flux residues easily removed with warm DI water
- Pleasant odor
- Extended stencil life

#### APPLICATION

##### STENCIL 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. 775-2 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
Slump Test	Pass
Copper Mirror Test	Pass/No breakthrough
Surface Insulation Resistance(cleaned)-Ohms	
J-STD-004	>1.0 x 10 <sup>11</sup>
pH-5% Aqueous Solution (Flux Extract)	7.0 - 8.0
Viscosity	
Malcom <sup>1</sup>	210-250 kcps, 90% metal, (-325+500 mesh)
Brookfield <sup>2</sup>	1000 kcps +/- 10%, 90% metal, (-325+500 mesh)
Tack <sup>3</sup>	
Time	>12 hours
Initial tack force	38.6 grams (1.16g/mm <sup>2</sup> )
Tack retention after 24 hours	23.2 grams (.70g/mm <sup>2</sup> )

#### 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
3. Per IPC-TM-650 2.4.44

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# QUALITEK

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Consult MSDS for health and safety information

# 775-2 PROFILE

