



QUALITEK®

DeltaElite™

818 Solder Paste, Low Residue, No-Clean

Description

818 No-Clean is a low residue solder paste designed for surface mount and other electronic assembly applications. The unique properties of this formula provide excellent activity, long stencil life, long tack time, high print speed and a longer shelf life. Post Soldering residues are transparent, non-corrosive and non-conductive.

BENEFITS

- Bellcore compliant
- 24 hour stencil life
- 48 hour tack time
- Excellent wetting on OSP
- Non-corrosive
- Prints up to 200mm per sec.
- Low residue
- Air or nitrogen Reflow

APPLICATION

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. 818 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	
Classification	RELO
J-STD-004	9.8 x 10 ¹² ohms (7 days, 85C, 85% R.H.)
Bellcore	4.12 X 10 ohms (7 days, 85C, 85% RH.)

Electromigration Bellcore	Pass
pH-5% Aqueous Solution (Flux Extract)	3.0 – 5.0
Softening Point	125°C
Viscosity	
Malcom¹	140- 200 kcps, 90% metal, (-325+500 mesh)
Brookfield²	900 kcps +/- 10%, 90% metal, (-325+500 mesh)
Tack Time	48 Hours (22C, 45% RH.)

SHIPPING & STORAGE

Recommended Storage Temperature	35°-50°F
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SHELF LIFE

Unopened Container	35°-65°F	9 Months (from DOM)
	77°F	1 Month (from DOS)

1. Malcom PCU-Series, 10 RPM, 25°C
2. Brookfield RVT, TF spindle, 5 RPM, 25°C, 0.75" spindle depth
3. Bellcore GR-78-CORE

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818 PROFILE

