



QUALITEK®

DELTA® 230 Solder Paste Rosin Mildly Activated (RMA)

DESCRIPTION

230 is a non-corrosive and mildly activated rosin solder paste designed for surface mount applications.

BENEFITS

- Excellent Activity
- No slump
- High SIR Value
- Fine pitch printing

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%

PRINTING PARAMETERS

Squeegee speed: 1.0 to 2.0 in/sec (25 – 50mm/sec)

Squeegee pressure: 1.0 – 2.0 lbs. per liner inch of squeegee

REFLOW PROFILE

The melting temperature of the solder and the heat resistance of components determine reflow Profile. 230 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
Water Extract Resistivity(Flux Extract)	115,000 ohm/cm
pH-5% Aqueous Solution (Flux Extract)	5.00 – 5.70
Softening Point	80°C
Viscosity	
Malcom ¹	175 - 205 kcps, 90% metal, (-325+500 mesh)
Brookfield ²	1,000 kcps +/- 10%, 90% metal, (-325+500 mesh)
Tack	
Time	4 - 8 Hours

SHIPPING & STORAGE

Recommended Storage Temperature	35°-50°F
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SHELF LIFE

Unopened Container	35°-65°F	6 Months (from DOM)
	77°F	1 Months (from DOS)

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

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Consult MSDS for health and safety information

230 PROFILE

