



DSP 718D (Sn/Ag/Cu)
LEAD FREE
WATER SOLUBLE
SOLDER PASTE

CORPORATE HEADQUARTERS USA: 315 Fairbank St. Addison, IL 60101¹ 630-628-8083¹ FAX 630-628-6543
EUROPE UK: Unit 9 Apex Ct. Bassendale Rd. Bromborough, Wirral CH62 3RE¹ 44 151 334 0888¹ FAX 44 151 346 1408
ASIA-PACIFIC HEADQUARTERS SINGAPORE: 6 Tuas South St. 5 Singapore 637790¹ 65 6795 7757¹ FAX 65 6795 7767
PHILIPPINES: Phase 1 Qualitek Ave. Mariveles, Bataan Philippines C-2106¹ 6347 935 4119¹ FAX 6347 935 5608
CHINA: 3B/F, YiPa Print Bldg. 351 # JiHua Rd., Buji Shenzhen, China 518112¹ 86 755 28522814¹ FAX 86 755 28522787

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Description

Qualitek has developed a unique flux system designed specifically for high temperature lead free alloys. It provides the fluxing activity levels that promote thermal stability and prevents thermal degradation when reflowing under air atmosphere (normal). Since use of nitrogen is not required, DSP 718D Lead Free Solder paste will provide excellent cost savings.

In addition, DSP 718D Lead Free solder paste exhibits superior joint strength, excellent wettability, extraordinary print definition and tack life.

Main Features

- Low foaming
- Yields bright, shiny joints
- Long tack time
- Excellent wettability

Technical Data

Flux Classification	Specification	Test Method
	ORH1	J-STD-004
Copper Mirror	Complete removal of copper film	IPC-TM-650 2.3.32
Corrosion	Pass	IPC-TM-650 2.6.15
SIR		
J-STD-004	4.55 x 10 ¹⁰ ohms	IPC-TM-650 2.6.3.3
Electromigration	Pass	Bellcore GR-78-CORE 13.1.4
Post Reflow Flux Residue	60%	TGA Analysis
Acid Value	60	IPC-TM-650 2.3.13
Metal Loading	87%	IPC-TM-650 2.2.20
Viscosity		
Brookfield ⁽¹⁾ , kcps	400+/-10% kcps	IPC-TM-650 2.4.34 modified
Malcom ⁽²⁾ , poise	850-1100	IPC-TM-650 2.4.34.3 modified
Thixotropic Index	0.50-0.60	
Slump Test		
25 C, 0.63 vertical/horizontal	No bridges all spacings	IPC-TM-650 2.4.35
150 C, 0.63 vertical/horizontal	No bridges all spacings	IPC-TM-650 2.4.35
25 C, 0.33 vertical/horizontal	0.15 /0.15	IPC-TM-650 2.4.35
150 C, 0.33 vertical/horizontal	0.20/0.20	IPC-TM-650 2.4.35
Solder Ball Test	Pass	IPC-TM-650 2.4.43
Tack		
Initial	96 gm	JIS Z 3284
Tack retention @ 24 hr	127gm	JIS Z 3284
Tack retention @ 72 hr	136 gm	JIS Z 3284

Physical Properties

Solder Composition

Qualitek Sn/Ag/Cu (Tin/Silver/Copper) alloys are designed as a lead-free alternative for Sn/Pb alloys for electronics assembly operations. Qualitek Sn/Ag/Cu alloys conform and exceed the impurity requirements of J-STD-006 and all other relevant international standards.

Typical Analysis														
	Sn	Ag	Cu	Pb	Sb	Bi	In	As	Fe	Ni	Cd	Al	Zn	Au
LF955-38	Bal	3.6-4.0	0.5-0.9	0.070 Max	0.200 Max	0.100 Max	0.100 Max	0.030 Max	0.020 Max	0.010 Max	0.002 Max	0.005 Max	0.003 Max	0.050 Max
LF958-35	Bal	3.3-3.7	0.5-0.9	0.070 Max	0.200 Max	0.100 Max	0.100 Max	0.030 Max	0.020 Max	0.010 Max	0.002 Max	0.005 Max	0.003 Max	0.050 Max
LF965-30	Bal	2.8-3.2	0.3-0.7	0.070 Max	0.200 Max	0.100 Max	0.100 Max	0.030 Max	0.020 Max	0.010 Max	0.002 Max	0.005 Max	0.003 Max	0.050 Max
LF217	Bal	3.8-4.2	0.3-0.7	0.070 Max	0.200 Max	0.100 Max	0.100 Max	0.030 Max	0.020 Max	0.010 Max	0.002 Max	0.005 Max	0.003 Max	0.050 Max

	Sn/Ag/Cu	Sn63/Pb37
Melting Point, °C	217-221	183 E
Hardness, Brinell	15HB	14HB
Coefficient of Thermal Expansion	Pure Sn= 23.5	24.7
Tensile Strength, psi	4312	4442
Density, g/cc	7.39	8.42
Electrical Resistivity (μohm-cm)	13.0	14.5
Electrical Conductivity, %IACS	16.6	11.9

	Sn/Ag/Cu	Sn63/Pb37
Yield Strength, psi	3724	3950
Total Elongation,%	27	48
Joint Shear Strength, at 0.1mm/min 20 °C	27	23
Joint Shear Strength, at 0.1mm/min 100 °C	17	14
Creep Strength, N/mm ² at 0.1mm/min 20 °C	13.0	3.3
Creep Strength, N/mm ² at 0.1mm/min 100 °C	5	1
Thermal Conductivity, W/m.K	58.7	50.9

Particle Size

SAC alloys are available in 3(45-25μm), 4(38-20μm) and 5(25-15μm) J-STD-005 powder distribution. Solder powder distribution is measured utilizing laser diffraction, optical analysis and sieve analysis. Careful control of solder powder manufacturing processes ensures the particles' shape are 95% spherical minimum (aspect ratio < 1.5) and that the alloy contains a typical maximum oxide level of 80 ppm.

Metal Loading

Typical metal loading for dispensing application is **86-87 %**. Compared to typical Sn63/Sn62 solder pastes manufactured with 88% by weight metal loading, DSP 718D Lead Free provides as much as 10-12% higher metal volume than Sn63/Sn62. This increased in volume of DSP 718D promotes better wetting and spreading of Sn/Ag/Cu Lead Free alloy.

Printing of Solder Paste

Dispensing

Needle Gauge	Needle inner diameter		Applicable powder (mesh cut)
	in.	µm	
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

The clearance gap between the needle and the substrate affects the shape and quality of the dot dispensed. If the clearance is too little, the dot tends to be flattened out, and if too large, the dot tends to have long tailing.

Pressure

The pressure applied in the syringe should be kept at a minimum, and the proper head pressure kept in the range of 15-25 lb/in² (1.05-1.76 kg/cm²). In cases where a paste requires much higher pressure (more than 40 lb/in² or 2.82 kg/cm²) to dispense, the paste will become inconsistent and clogging may be expected. The external air pressure supply should be maintained constant.

Open & Abandon Time

Tests have proven that DSP 718D will perform during continuous dispensing for up to 8 hrs. The paste can be left in the dispensing unit for up to 4 hours without paste drying out. If extended downtime is expected (>4 hrs) , the whole dispensing system should be flushed without leaving any paste in any part of the system.

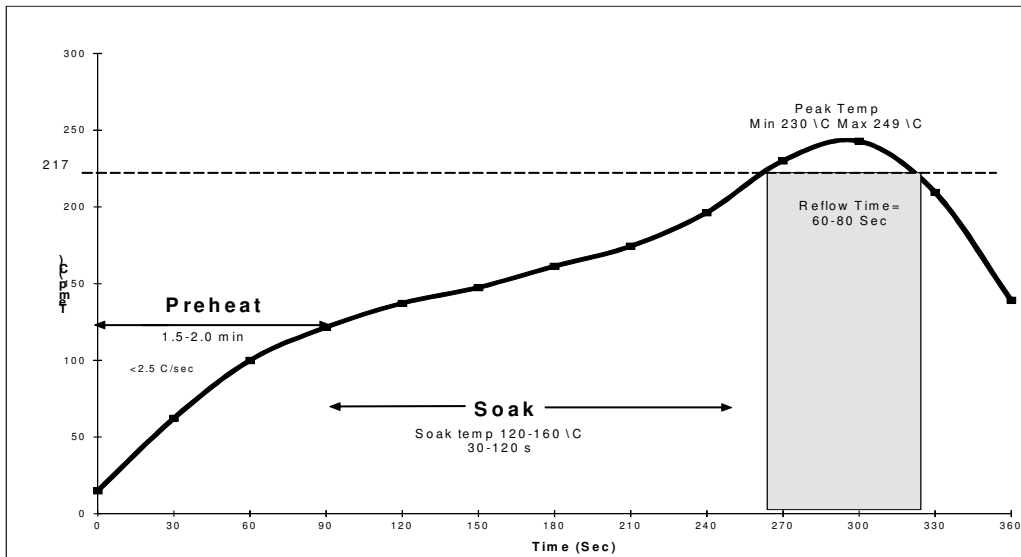
Paste Application

Solder paste should be taken out of the refrigerator at least 3 to 6 hours prior to use. This will give the paste enough time to come to thermal equilibrium with the environment. The flow rate of paste in a dispensing application depends on viscosity, which can be altered by temperature change. If solder paste is supplied in syringes pre-mixing is not necessary due to the shear action produced from the dispensing.

Reflow

Best results have been achieved when DSP 718D is reflowed in a **forced air convection** oven with a minimum of 8 zones (top & bottom), however, reflow is possible with a 4 zone oven (top & bottom).

The following is a recommended profile for a forced air convection reflow process. The melting temperature of the solder, the heat resistance of the components, and the characteristics of the PCB (i.e. density, thickness, etc.) determine the actual reflow profile.



Preheat Zone- The preheat zone, is also referred to as the ramp zone, and is used to elevate the temperature of the PCB to the desired soak temperature. In the preheat zone the temperature of the PCB is constantly rising, at a rate that should not exceed 2.5 C/sec. The oven's preheat zone should normally occupy 25-33% of the total heated tunnel length.

The Soak Zone- normally occupies 33-50% of the total heated tunnel length exposes the PCB to a relatively steady temperature that will allow the components of different mass to be uniform in temperature. The soak zone also allows the flux to concentrate and the volatiles to escape from the paste.

The Reflow Zone- or spike zone is to elevate the temperature of the PCB assembly from the activation temperature to the recommended peak temperature. The activation temperature is always somewhat below the melting point of the alloy, while the peak temperature is always above the melting point.

Flux Residues & Cleaning

DSP 718D 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 conveyor cleaner system. Spray pressures should be maintained at 20-30 psi and conveyor speed of 3-6ft/min.

Storage & Shelf Life

It is recommended that solder paste be stored at a temperature of between 35-50 °F (2-10 °C) to minimize solvent evaporation, flux separation, and chemical activity. If room temperature storage is necessary it should be maintain between 68-77 °F (20-25 °C).

Shelf Life

Unopened Container (35-50°F/2-10°C) 6 months (from DOM)

Unopened Container (68-77°F/20-25°C) 3 months (from DOM)

Working Environment

Solder paste performs best when used in a controlled environment. Maintaining ambient temperature of between 68-77 °F (20-25 °C) at a relative humidity of 40-65% will ensure consistent performance and maximum life of paste.

Packaging

10cc Syringe

35 gm

30cc Syringe

100 gm

Disposal

DSP 718D should be stored in a sealed container and disposed of in accordance with state & local authority requirements.