



DSP 691A (Sn63/Pb37) NO CLEAN 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 DS[691A is a new generation no clean solder paste designed for surface mount and other electronic assembly applications. DSP 691A provides features such as fine pitch capability (<16 mil), high-speed printing, and probable residues. In addition, DSP 691A leaded solder paste exhibits excellent wettability, extraordinary print definition and tack life. The post soldering residues of DSP 691A are non-conductive, non-corrosive and highly insulated.

Main Features

- Excellent wetting on OSP
- 24 hour stencil life
- 48 hour tack time
- Pin testable
- Low residue

Technical Data

| Flux Classification | Specification | Test Method |
|----------------------------------|------------------------------|------------------------------|
| | RELO | J-STD-004 |
| Copper Mirror | No removal of copper film | IPC-TM-650 2.3.32 |
| Corrosion | Pass | IPC-TM-650 2.6.15 |
| SIR | | |
| J-STD-004 | 9.73 x 10 ¹² ohms | IPC-TM-650 2.6.3.3 |
| Bellcore (Telecordia) | 3.12 x 10 ¹² ohms | Bellcore GR-78-CORE 13.1.3 |
| Electromigration | Pass | Bellcore GR-78-CORE 13.1.4 |
| Acid Value | 92 | IPC-TM-650 2.3.13 |
| Metal Loading | 89-90% | IPC-TM-650 2.2.20 |
| Viscosity | | |
| Brookfield ⁽¹⁾ , kcps | 900+/-10% kcps | IPC-TM-650 2.4.34 modified |
| Malcom ⁽²⁾ , poise | 1650-1950 | 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 | 54.1 gm | JIS Z 3284 |
| Tack retention @ 24 hr | 68.6 gm | JIS Z 3284 |
| Tack retention @ 72 hr | 52 gm | JIS Z 3284 |
| Stencil Life | >8 hrs | QIT 3.44.5 |
| Abandon Time | 60-90 min | QIT 3.44.6 |
| ICT | 100% contact | QIT 3.44.7 |

Physical Properties

Solder Composition

Sn63/Pb37 alloy is the conventional eutectic solder used in most electronic assemblies. The Sn63 alloy conforms and exceeds the impurity requirements of J-STD-006 and all other relevant international standards.

| Typical Analysis | | | | | | | | | | | | | |
|-------------------------|------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| Sn | Pb | Cu | Ag | Sb | Bi | In | As | Fe | Ni | Cd | Al | Zn | Au |
| 62.5-63.5 | Bal. | 0.080 Max | 0.100 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 |

| | Sn63/Pb37 |
|--|------------------|
| Melting Point, °C | 183 E |
| Hardness, Brinell | 14HB |
| Coefficient of Thermal Expansion | 24.7 |
| Tensile Strength, psi | 4442 |
| Density, g/cc | 8.42 |
| Electrical Resistivity, (μohm-cm) | 14.5 |
| Electrical Conductivity, 10 ⁴ /ohm-cm | 6.9 |

| | Sn63/Pb37 |
|--|------------------|
| Yield Strength, psi | 3950 |
| Total Elongation,% | 48 |
| Joint Shear Strength, at 0.1mm/min 20 °C | 23 |
| Joint Shear Strength, at 0.1mm/min 100 °C | 14 |
| Creep Strength, N/mm ² at 0.1mm/min 20 °C | 3.3 |
| Creep Strength, N/mm ² at 0.1mm/min 20 °C | 1 |
| Thermal Conductivity, W/m.K | 50.9 |

Particle Size

Sn63 alloy is available in Type 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 stencil printing application is **89-90 %**.

Printing of Solder Paste

Stencil

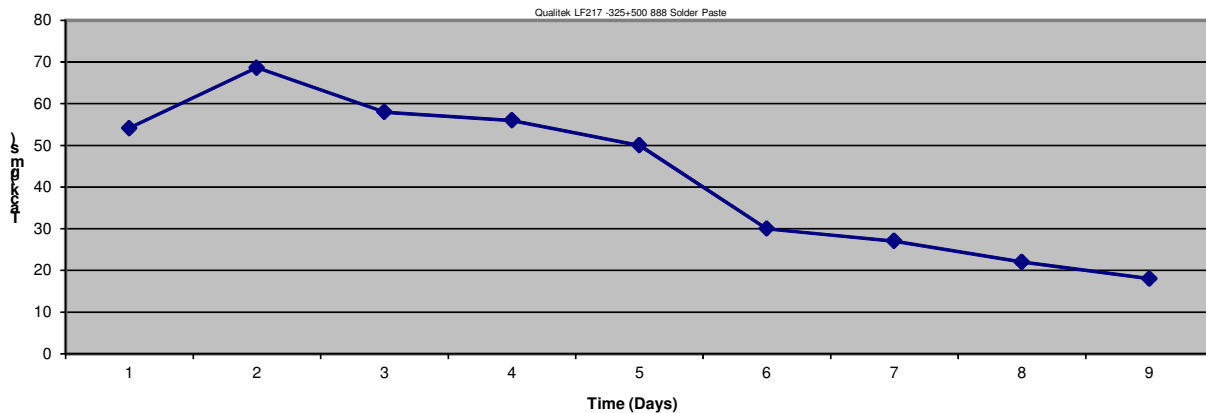
Use of chemical etched/electroformed stencil is preferred however DSP 691A has been used successfully with chemical etch, electroformed, and laser cut stencils.

Squeegee

- Blades:* Metal (stainless steel) squeegee blades angled from 45-60° give the best print definition. Metal (nickel) squeegee blades angled from 45-60° give the best performance. 90 durometer polyurethane may also be used.
- Pressure:* Pressure should be adjusted at the point where the paste leaves a relatively clean stencil after each print pass. Typical pressure setting is 0.6-1.5lb per linear inch of blade.
- Speed:* Normal print speeds are 1.0-2.5 (25-50mm) per second. As print speeds increase pressure will need to be increased. Although slower print speeds are desirable, Qualitek solder paste is capable of printing up to 6 inch per second.

Print Definition

DSP 691A provides excellent print definition characterized by brick-like prints. Good release is seen on 12-9 mil apertures. Tack values are high even after extended open time in both normal and high humidity environments.



Open & Abandon Time

Tests have proven that DSP 691A will perform during continuous printing for up to 8 hrs. Field test have shown that an abandon time of at least 1 hr is possible, resulting in a perfect 1st pass print on resumption of printing.

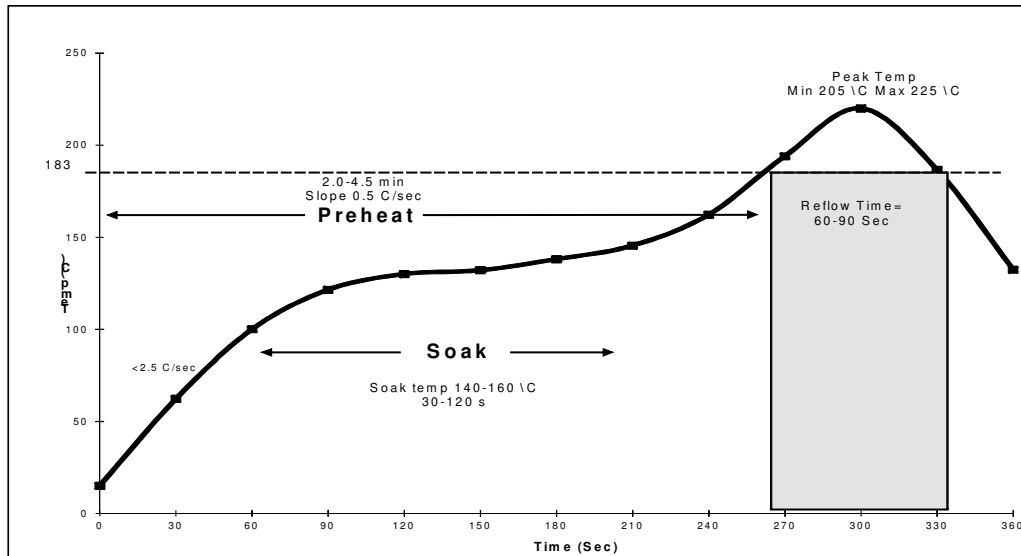
Paste Application

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. Also, any fresh jar of solder paste should be gently mixed for at least one minute with a spatula. Be sure not to mix the paste too vigorously, as this will degrade the paste’s viscosity characteristics and introduce entrapped air into the paste. The purpose of the mixing is to insure that the paste is smooth and consistent. If solder paste is supplied in cartridges pre-mixing is not necessary due to the shear action produced from the dispensing.

Reflow

Best results have been achieved when DSP 691A 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 691A is a no clean formulation, therefore, the residues do not need to be removed for typical applications. If residue removal is desired, the use of Everkleen 1005 Buffered Saponifier with a 5-15% concentration in hot 60 °C (140 °F) will aid in residue removal.

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 between 68-77 °F (20-25 °C) at a relative humidity of 40-65% will ensure consistent performance and maximum life of paste.

Cleaning Misprint Boards

If you should have a misprinted board, the paste may be cleaned off manually with alcohol (IPA) or Qualitek stencil cleaner, SK-11. If you have a more elaborate board cleaner, the paste may be easily removed with use of a 5% saponifier solution in hot DI water. Qualitek SK-45 Stencil Cleaner could be used in this process.

Stencil Cleaning

Periodic cleaning of the stencil during production is recommended to prevent any paste from being deposited in unwanted areas of the board. Without stencil cleaning, solder balling will increase. We recommend a periodic dry wipe (every 5 to 10 boards) with an occasional wet wipe (every 15 to 25 boards). When running fine pitch boards, the cleaning may need to become more frequent. The wet wipes should be performed with either alcohol or a stencil cleaner. Qualitek SK-11 stencil cleaner is designed for this purpose. When cleaning the stencil at the end of a job, the cleaning should be more thorough. If you have stencil cleaning equipment, Qualitek SK- 45 Stencil Cleaner is highly recommended for stencil cleaning purposes.

Packaging

| | |
|------------------|-------------|
| 6 oz. Jar | 250-500 gm |
| 6 oz. Cartridge | 500-700 gm |
| 12 oz. Cartridge | 1000-1400gm |

Disposal

DSP 691A should be stored in a sealed container and disposed of in accordance with state & local authority requirements.