

## 385-SEL

Rev: 14.1

**Date** 2021.08.17  
**Language** English  
**SDS** 950309



## Summary

385-SEL is a REL0 classified, alcohol-based flux for selective soldering. It is based on synthetic resins and shows high SIR values.

Flux code	385-SEL
PROCESS	
No-Clean process	9
Post-solder cleaning	6

INDUSTRY APPLICATION	
Consumer electronics	6
Standard industrial electronics	8
Hi-Rel electronics (automotive)	9

PROCESS CAPABILITY	
Dip Soldering	6
Drag soldering	9
Dropjet fluxing	9
High Pre-heat compatible	6
High soldering temp compatible	6
Long contact time compatible	7
Reduces spreading of flux	6
Reduces solderballing	8
Reduces bridging	8
Improves TH filling	8
Brilliant joint appearance	9
Cosmetic Cleanliness	9
ICCT compatible	9
Conformal coating compatible	9

Legend	
<i>Especially made for this purpose</i>	9 - 10
<i>Generally qualified for this purpose</i>	7 - 8
<i>Generally usable, but not the best choice</i>	5 - 6
<i>Generally not usable for this purpose</i>	3 - 4
<i>Wrong choice</i>	1 - 2

CLASSIFICATION	
DIN EN 29454-1: 1994	1.2.3.A
IPC-J-STD-004-A: 2004	REL0

PROPERTIES		
Density	@20°C [kg/dm³]	0.804
Acid number	[mg KOH/g]	18.8
Solid content	[% w/w]	1.9
Water content	[% w/w]	1
VOC content	[% w/w]	Remainder
Filmformer(s)		Resin
Color		Colorless
Odor		Alcoholic
Flashpoint COC	[°C]	11.9
Thinners		425-00

TEST REPORTS	
Certificate of Compliance	website
Application Note	english

PACKAGING AND STORAGE		
Packaging bottle (HDPE) [liter]	(HDPE) [liter]	1
Packaging can (HDPE) [liter]	(HDPE) [liter]	5 / 10
Recommended shelf-life in Months		
Storage temperature	20-25 °C	12

**Check material compatibility with every process change!**

**Industrial chemical product.**

**Read MSDS before use.**

**Disclaimer:**

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