

## Product Data Sheet

Product	327-SEL
Productgroup	Selective Flux
Date	31-10-2011
Release	11.1

5	Especially made for this purpose
4	Generally qualified for this purpose
3	Generally usable, but not the best choice
2	Generally not usable for this purpose
1	Wrong choice

ISO 9454-1	1.2.3.A
IPC-ANSI-J-STD-004	RELO
JIS Z 3197	1.2.3.N_I
No-Clean process	5
Post-solder cleaning	3
General Wave Soldering	2
Pb-Free process - N2	5
Consumer electronics	3
Med-Rel electronics	4
Hi-Rel electronics	5
1-layer, video/tv boards	4
2-layer boards	5
Multi-layer boards	5
OSP compatible	5
Ni/Au compatibel	5
Ni/Pd compatible	4
Ag compatible	4
Sn compatible	5
Bubble jet fluxing	5
Nozzle-spray fluxing	5
Template/dip fluxing	4
Hot bar soldering	5
Static solder-nozzle	5
Flow solder-nozzle	5
Short contact time with solder	5
Moderate preheat	4
Reduces spread of flux	3
Reduces solder balling	5
Reduces bridging	4
Cosmetic cleanliness	3
Cosmetic cleanliness N2	4
ICCT compatible	4
Conformal coating	5

SG @ 20 °C [kg/dm <sup>3</sup> ] (+/- 0.5%)	0.840
Solids content [% w/w]	4.94
Halides [Silver-Chromate Test]	Pass
Halides [Potentiometric]	Pass
Acid number [mgKOH] (+/-2.5%)	19.70
Water content [% w/w]	5.
VOC-content [% w/w]**	90.00
Filmformer(s)	Resin
Color	Colorless
Flashpoint COC [°C]	13.5
Telcordia/Bellcore TR-NWT-000078/3	Compliant
Test report(s)	Available
Certificate of Compliance	Available
SPC-data*	Auditable
Environmental Load Unit	6.00
RoHS-Compliance Certificate	Available
User's Guidelines	English
<b>Packaging</b>	
Bottle (HDPE) [liter]	1
Can (HDPE) [liter]	5, 10
Thinner	425-00
<b>Shelf-life (Weeks)</b>	
Storage 20 [°C]	52.
Storage 25 [°C]	40.