

323-ITM

Rev: 16.1

Date	2021.08.18
Language	English
SDS	950328



Summary

323-ITM is a ROL1 classified, alcohol-based flux for wave soldering and is based on natural resins.

Flux code	323-ITM	
PROCESS		
No-Clean process		9
Post-solder cleaning		8

INDUSTRY APPLICATION		
Standard electronics		9
Industrial electronics		9
Hi-Rel electronics (automotive)		8

PROCESS CAPABILITY		
Foam fluxing		9
Spray fluxing		9
Short preheat		9
Short contact time		9
Pb-free process Air		9
Pb-free process N2 wave		9
Pb-free process N2 tunnel		6
Skipped joints		9
Solderballing		8
Bridging		9
Promotes wicking		8
PTH filling		9
Cosmetic cleanliness		6
Cosmetic cleanliness N2		7
Shiny joint appearance		8
Pin testability		8
Conformal coating (see AN)		6

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 ISO 9454-1: 2016	1222
IPC-J-STD-004-A: 2004	ROL1

PROPERTIES		
Density	@ 20°C [kg/dm³]	0.82
Solid content	[% w/w]	3.8
Acid number	[mg KOH/g]	22.0
Water content	[% w/w]	7
VOC content	[% w/w]	Remainder
Filmformer(s)		Rosin
Color		Colorless
Odor		Alcoholic
Flashpoint COC	[°C]	13
Thinners		308-00

TEST REPORTS			
Certificate of Compliance			Website
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		Pass
Halides	IPC-TM-650 2.3.33	[Silver Chromate]	Pass
Halide	IPC-TM-650 2.3.35.1	[Fluoride by Spot]	Pass
Copper Corrosion	IPC-TM-650 2.6.15		Pass
SIR	IPC-TM-650 2.6.3.3		Pass
ECM	IPC-TM-650 2.6.14.1		N/A

PACKAGING AND STORAGE		
Packaging can	(HDPE) [liter]	10
Packaging Drum	(HDPE) [liter]	200
Shelf-life in months	20-25 °C	9

Check material compatibility with every process change!
Industrial chemical product.
Read SDS before use.

Disclaimer:

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