

323-ITM

Rev: 16.1

**Date** 2021.08.18  
**Language** English  
**SDS** 950303



**Summary**

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

Flux code	323-ITM
<b>PROCESS</b>	
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		
Storage temperature	20-25 °C	9

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

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