

Date	2021.08.17
Language	English
SDS	950322



Summary

327-SEL is a ROLO classified alcohol based flux for selective soldering. It is based on natural resins and is free of halogens and halides.

Flux code	327-SEL	
PROCESS		
No-Clean process		9
Post-solder cleaning		8

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

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

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	1.1.3.A
IPC-J-STD-004-A: 2004	ROLO

PROPERTIES		
Density	@20°C [kg/dm³]	0.84
Acid number	[mg KOH/g]	19.7
Solid content	[% w/w]	4.9
Water content	[% w/w]	5
VOC content	[% w/w]	Remainder
Filmformer(s)		Rosin
Color		Colorless
Odor		Alcoholic
Flashpoint COC	[°C]	13.5
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:

This information is intended as advice to the best of our knowledge. The provided data is based on our own measurements, they do not provide any guaranteed properties nor are these delivery specifications. Due to the versatility of materials, applications and taking in consideration the industrial property rights of third parties, Balver Zinn Josef Jost GmbH & Co. KG cannot take any liability.