

Date	2021.08.17
Language	English
SDS	950322



Summary

327-SEL is a ROL0 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	ROL0

PROPERTIES		
Density	@20°C [kg/dm ³]	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.

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