

Date	2021.08.18
Language	English
SDS	950305



Summary

327 is a ROL1 classified, alcohol-based flux for wave soldering. It is based on natural Rosins and is highly activated. The residues are non-hygroscopic and therefore highly resistant to corrosion.

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

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

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		6
Pb-free process N2 tunnel		4
Skipped joints		9
Solderballing		9
Bridging		9
Promotes wicking		9
PTH filling		9
Cosmetic cleanliness		4
Cosmetic cleanliness N2		6
Shiny joint appearance		8
Pin testability		6
Conformal coating (see AN)		4

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	1.1.2.A
IPC-J-STD-004-A: 2004	ROL1

PROPERTIES		
Density	@20°C [kg/dm³]	0.838
Solid content	[% w/w]	4.9
Acid number	[mg KOH/g]	29.0
Water content	[% w/w]	5
VOC content	[% w/w]	Remainder
Filmformer(s)		Rosin
Color		Yellowish
Odor		Alcoholic
Flashpoint COC	[°C]	13.5
Thinners		425-00

TEST REPORTS	
Certificate of Compliance	Website
Application Note	EN/DE

PACKAGING AND STORAGE		
Packaging can	(HDPE) [liter]	10
Packaging Drum	(HDPE) [liter]	200
Shelf-life in months	20-25 °C	12

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

Disclaimer:

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