

**Product** 323-ITM  
**Date** 2018.04.13  
**Release** 16.1  
**Language** English

## General wave soldering flux

### Summary

VOC -- General Rosin wave solder flux.

FLUX CODE	323-ITM
<b>PROCESS</b>	
No-Clean process	5
Post-solder cleaning	4
<b>INDUSTRY APPLICATION</b>	
Consumer electronics	5
Standard industrial electronics	5
Hi-Rel electronics (automotive)	4
<b>PROCESS CAPABILITY</b>	
Foam fluxing	5
Spray fluxing	5
Short preheat	5
Short contact time	5
Pb-free process Air	5
Pb-free process N2 wave	5
Pb-free process N2 Tunnel	3
Skipped joints	5
Solderballing	4
Bridging	5
PTH filling	5
Cosmetic cleanliness	3
Cosmetic cleanliness N2	4
Shiny joint appearance	4
Pin testability	4
Conformal coating (see AN)	3

Legend	
<i>Epecially made for this purpose</i>	5
<i>Generally qualified for this purpose</i>	4
<i>Generally usable, but not the best choice</i>	3
<i>Generally not usable for this purpose</i>	2
<i>Wrong choice</i>	1

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

PROPERTIES			
Density		@20°C [kg/dm³]	0.82
Acid number	IPC-TM-650 2.3.13	[mg KOH/g]	22.0
Solid content	IPC-TM-650 2.3.34	[% w/w]	3.8
Water content		[% w/w]	7
VOC content		[% w/w]	Remainder
Color			Colorless
Odor			Alcoholic
Thinners			308-00

TEST REPORTS			
Certificate of Compliance			Website
Application Note			EN/DE
Copper Mirror	IPC-TM-650 2.3.32		L
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		L
SIR	IPC-TM-650 2.6.3.3		Pass

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

Check material compatibility with every process change!

Industrial chemical product.

Read SDS before use.

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