

Product	327-SEL
Date	2018.07.04
Release	14.1
Language	English

General Selective soldering flux

Summary

Rosin based Halide Halogen free

FLUX CODE	327-SEL
PROCESS	
No-Clean process	5
Post-solder cleaning	4
INDUSTRY APPLICATION	
Consumer electronics	3
Standard industrial electronics	4
Hi-Rel electronics (automotive)	5
PROCESS CAPABILITY	
Dip Soldering	4
Drag soldering	5
Dropjet fluxing	4
High Pre-heat compatible	5
High soldering temp compatible	5
Long contact time compatible	5
Reduces spreading of flux	3
Reduces solderballing	4
Reduces bridging	4
Improves TH filling	4
Brilliant joint appearance	5
Cosmetic Cleanliness	3
ICCT compatible	3
Conformal coating compatible	5

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	IPC-TM-650 2.3.13	[mg KOH/g]	19.7
Solid content	IPC-TM-650 2.3.34	[% w/w]	4.9
Water content		[% w/w]	5
VOC content		[% w/w]	Remainder
Color			Colorless
Odor			Alcoholic
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
Shelf-life in months		
Storage temperature	20-25 °C	12

Check material compatibility with every process change!

Industrial chemical product.

Read SDS before use.

Legend	
<i>Especially 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

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