

327-SEL

Rev: 14.1

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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		
Especially made for this purpose	9 - 10	
Generally qualified for this purpose	7 - 8	
Generally usable, but not the best choice	5 - 6	
Generally not usable for this purpose	3 - 4	
Wrong choice	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:

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