

Product data sheet

BALVER ZINN[®]
COBAR[®]

Product 323-ITM
Date 2014.05.01
Release 14.1
Language English

General wave soldering flux

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

Flux code	Summary
323-ITM	VOC -- General Rosin wave solder flux.

FLUX CODE	323-ITM
PROCESS	
No-Clean process	5
Post-solder cleaning	4
INDUSTRY APPLICATION	
Consumer electronics	5
Standard industrial electronics	5
Hi-Rel electronics (automotive)	4
PCB CAPABILITY	
1-layer, video/tv boards	5
2-layer boards	5
Multi-layer boards	5
OSP compatible	5
Ni/Au compatible	4
ImAg compatible	4
ImSn compatible	5
PROCESS CAPABILITY	
Foam fluxing	5
Nozzle spray fluxing	5
Moderate preheat	5
Short contact time	5
Pb-free process Ambient	5
Pb-free process N2 wave	5
Pb-free process N2 Tunnel	3
Reduces skipped joints	5
Reduces solderballing	4
Reduces bridging	5
Improves TH filling	5
Cosmetic cleanliness	3
Cosmetic cleanliness N2	4
Brilliant joint appearance	4
ICCT compatible	4
Conformal coating	3
SAFETY	
Ionic Contamination	N/A
No corrosion	4
High SIR	4

CLASSIFICATION	
ISO 9454-1	1.1.2.A
IPC-J-STD-004	ROL1

PROPERTIES	
Density @20°C [kg/dm ³] (+/-0,5%)	0,82
Solid content [% w/w]	3,8
Acid number [mg KOH] +/- 2.5%	22
Water content [% w/w]	7
VOC content [% w/w]	90
Filmformer(s)	Rosin
Color	Colorless
Odor	Alcoholic
Flashpoint COC [drg c]	13
Thinners	304-00

TEST REPORTS	
Telcordia GR-78-CORE	Qualified
Certificate of Compliance	Available
SPC-data	Auditable
Application Note	GB/DE

PACKAGING AND STORAGE	
Packaging can (HDPE) [liter]	10
Packaging Drum (HDPE) [liter]	200
Recommended shelf-life in months	
Storage temperature 20 - 25 [°C]	9

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

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