

ALPHA[®] ROL1 IPC TEST FLUX

Per IPC/EIA/JEDEC

DESCRIPTION

ALPHA ROL1 IPC Test Flux is a standard flux formulated to meet the J-STD-002 & J-STD-003C specification for use in testing the solderability of component leads. **ALPHA ROL1 IPC Test Flux** is a clear homogeneous rosin flux of pure colophony dissolved in isopropyl alcohol with diethylamine hydrochloride.

READ ENTIRE TECHNICAL DATA SHEET BEFORE USING THIS PRODUCT

APPLICATION GUIDELINES

ALPHA ROL1 IPC Test Flux is to be used in compliance with “Bath/Dip Look Test”. Military products are to be tested in compliance with MIL-STD-2002 Method 208, also referenced in J-STD-002. This flux is typically applied via a dip process.

TECHNICAL DATA

Item	Typical Values	Item	Typical Values
Appearance	Clear, Pale Yellow Liquid	Flash Point (T.C.C.)	12 °C
Rosin Content	25%	Recommended Thinner	ALPHA 425
Specific Gravity @ 25 °C (77 °F)	0.843 ± 0.005	Shelf Life (from Date of Mfg.)	1080 days
Acid Number (mg KOH/g)	41.0 ± 2.0	IPC J-STD-004 Designation	ROL1
Halides, as % per solids	0.5 Max	Packaging Size	1, 5, 55 gallons

CORROSION & ELECTRICAL TESTING

Test	Requirement for ROL1	Results
Silver Chromate Paper IPC-TM 650 Test Method 2.3.33	No detection of halide	PASS
Copper Mirror Tests IPC-TM 650 Test Method 2.6.15	No complete removal of copper	PASS
Copper Corrosion Test IPC-TM 650 Test Method 2.3.32	No evidence of corrosion	No Evidence of Corrosion

RECYCLING SERVICES

We provide safe and efficient recycling services to help companies meet their environmental and legislative requirements and at the same time, maximize the value of their waste streams.

Our service collects solder dross, solder scrap, and various forms of solder paste waste. Please contact your local sales representative for recycling capabilities in your area or [link here](#).



SAFETY & WARNING

It is recommended that the company/operator read and review the Safety Data Sheets for the appropriate health and safety warnings before use. **Safety Data Sheets are available at MacdermidAlpha.com/assembly-solutions/knowledge-base.**

STORAGE

ALPHA ROL1 IPC Test Flux is to be stored at 10 to 25 °C (50 to 77 °F).

CONTACT INFORMATION

**To confirm this document is the most recent version, please contact
 Assembly@MacDermidAlpha.com
www.macdermidalpha.com**

<p>North America 109 Corporate Blvd. South Plainfield, NJ 07080, USA 1.800.367.5460</p>	<p>Europe Unit 2, Genesis Business Park Albert Drive Woking, Surrey, GU21 5RW, UK 44.01483.758400</p>	<p>Asia 8/F., Paul Y. Centre 51 Hung To Road Kwun Tong, Kowloon, Hong Kong 852.3190.3100</p>
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Also read carefully warning and safety information on the Safety Data Sheet. This data sheet contains technical information required for safe and economical operation of this product. READ IT THOROUGHLY PRIOR TO PRODUCT USE. Emergency safety directory assistance: US 1 202 464 2554, Europe + 44 1235 239 670, Asia + 65 3158 1074, Brazil 0800 707 7022 and 0800 172 020, Mexico 01800 002 1400 and (55) 5559 1588

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