**1: PRODUCT AND COMPANY IDENTIFICATION**

**Trade name:** 2331ZX  
**Application of the substance / the preparation:** Soldering Flux

**1.3 Details of the supplier of the safety data sheet**

**Manufacturer/Supplier:**
- Kester Inc.  
  800 West Thorndale Avenue  
  Itasca, IL 60143  
  Tel (630) 616-4000
- ITW Specialty Materials (Suzhou) Co., Ltd.  
  Heng Qiao Road  
  Wujiang Economic Development Zone  
  Suzhou, Jiangsu 215200 China  
  Tel +86 512 82060808

**Information department:** Product Compliance: EHS_Kester@kester.com

**1.4 Emergency telephone number:**
- CHEMTREC 24-Hour Emergency Response Telephone Number: (800) 424-9300
- CHEMTREC 24-Hour Emergency Response (Outside US & Canada) Telephone Number: (703) 527-3887

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**2: HAZARDS IDENTIFICATION**

**2.1 Classification of the substance or mixture**

**Classification according to Regulation (EC) No 1272/2008**

- GHS02 Flame
  - Flam. Liq. 2 H225 Highly flammable liquid and vapor.

- GHS05 Corrosion
  - Eye Dam. 1 H318 Causes serious eye damage.

- GHS07
  - Acute Tox. 4 H302 Harmful if swallowed.
  - Acute Tox. 4 H312 Harmful in contact with skin.
  - Acute Tox. 4 H332 Harmful if inhaled.
  - STOT SE 3 H335-H336 May cause respiratory irritation. May cause drowsiness or dizziness.

**2.2 Label elements**

**Labelling according to Regulation (EC) No 1272/2008**

The product is classified and labeled according to the CLP regulation.

**Hazard pictograms**

- GHS02
- GHS05
- GHS07

**Signal word** Danger

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(Contd. on page 2)
Hazard statements
H225 Highly flammable liquid and vapor.
H302+H312+H332 Harmful if swallowed, in contact with skin or if inhaled.
H318 Causes serious eye damage.
H335-H336 May cause respiratory irritation. May cause drowsiness or dizziness.

Precautionary statements
P210 Keep away from heat/sparks/open flames/hot surfaces. - No smoking.
P280 Wear protective gloves / eye protection.
P303+P351+P338 IF ON SKIN (or hair): Remove/Take off immediately all contaminated clothing. Rinse skin with water/shower.
P304+P340 IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing.
P403+P233 Store in a well-ventilated place. Keep container tightly closed.
P501 Dispose of contents/container in accordance with local/regional/national/international regulations.

Hazard description:
WHMIS Symbols
B2 - Flammable liquid
D2A - Very toxic material causing other toxic effects

Classification system:
NFPA ratings (scale 0 - 4)
Health = 2
Fire = 3
Reactivity = 0

HMIS-ratings (scale 0 - 4)
HEALTH 2
Fire 3
Reactivity 0

2.3 Other hazards
Results of PBT and vPvB assessment
PBT: Not applicable.
vPvB: Not applicable.

3: COMPOSITION OF MIXTURE
Description: Mixture of the substances listed below with nonhazardous additions.

<table>
<thead>
<tr>
<th>CAS No.</th>
<th>Description</th>
<th>% Range</th>
</tr>
</thead>
<tbody>
<tr>
<td>CAS: 67-63-0 EINECS: 200-661-7</td>
<td>Isopropanol</td>
<td>55-70%</td>
</tr>
<tr>
<td>CAS: 56-81-5 EINECS: 200-289-5</td>
<td>glycerol</td>
<td>10-25%</td>
</tr>
<tr>
<td>CAS: 111-42-2 EINECS: 203-868-0</td>
<td>diethanolamine</td>
<td>5-10%</td>
</tr>
<tr>
<td>CAS: 506-59-2 EINECS: 208-046-5</td>
<td>dimethylammonium chloride</td>
<td>5-10%</td>
</tr>
</tbody>
</table>
Trade name: 2331ZX

41.1.10

CAS: 79-14-1 EINECS: 201-180-5

glycolic acid

Skin Corr. 1B, H314; Eye Dam. 1, H318

Acute Tox. 4, H302

3-5%

Additional information:
This product will be heated to a temperature of 217°C (Celsius) during soldering. All volatile substances will evaporate and not remain on the finished circuit board.

4: FIRST AID MEASURES

4.1 Description of first aid measures
General information: Follow general first aid procedures.
After inhalation: Supply fresh air; consult doctor in case of complaints.
After skin contact: Immediately wash with water and soap and rinse thoroughly.
After eye contact: Rinse opened eye for several minutes under running water. If symptoms persist, consult a doctor.
After swallowing: Seek immediate medical advice.

4.2 Most important symptoms and effects, both acute and delayed
No further relevant information available.

4.3 Indication of any immediate medical attention and special treatment needed
No further relevant information available.

5: FIREFIGHTING MEASURES

5.1 Extinguishing media
Suitable extinguishing agents:
CO2, extinguishing powder or water spray. Fight larger fires with water spray or alcohol resistant foam.

For safety reasons unsuitable extinguishing agents: Water with full jet

5.2 Special hazards arising from the substance or mixture
In case of fire, the following can be released:
Carbon monoxide (CO)
Nitrogen oxides (NOx)
Carbon dioxide (CO2)

5.3 Advice for firefighters
Protective equipment: Wear self-contained respiratory protective device.

6: ACCIDENTAL RELEASE MEASURES

6.1 Personal precautions, protective equipment and emergency procedures
Wear protective equipment. Keep unprotected persons away.
Ensure adequate ventilation
Keep away from ignition sources

6.2 Environmental precautions: Do not allow to enter sewers/ surface or ground water.

6.3 Methods and material for containment and cleaning up:
Ensure adequate ventilation.
Do not flush with water or aqueous cleansing agents

6.4 Reference to other sections
See Section 7 for information on safe handling.
See Section 8 for information on personal protection equipment.
See Section 13 for disposal information.

7: HANDLING AND STORAGE

7.1 Precautions for safe handling
Store in cool, dry place in tightly closed receptacles.
Ensure good ventilation/exhaustion at the workplace.
Prevent formation of aerosols.
8: EXPOSURE CONTROLS / PERSONAL PROTECTION

Additional information about design of technical systems: No further data; see item 7.

8.1 Control parameters

<table>
<thead>
<tr>
<th>Components with limit values that require monitoring at the workplace:</th>
</tr>
</thead>
<tbody>
<tr>
<td>67-63-0 Isopropanol</td>
</tr>
<tr>
<td>PEL</td>
</tr>
<tr>
<td>REL</td>
</tr>
<tr>
<td></td>
</tr>
<tr>
<td>TLV</td>
</tr>
<tr>
<td></td>
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<tr>
<td></td>
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<tr>
<td></td>
</tr>
</tbody>
</table>

8.2 Exposure controls

Personal protective equipment:

General protective and hygienic measures:
The usual precautionary measures for handling chemicals should be followed.
Keep away from foodstuffs, beverages and feed.
Immediately remove all soiled and contaminated clothing.
Wash hands before breaks and at the end of work.
Avoid contact with the eyes and skin.

Breathing equipment:
Exposure Controls: Use appropriate engineering control such as process enclosures, local exhaust ventilation to control airborne levels below recommended exposure limits.
When ventilation is not sufficient to remove airborne levels from the breathing zone, a NIOSH safety approved respirator or self-contained breathing apparatus should be worn. Consult with local procedures for selection, training, inspection and maintenance of the personal protective equipment.
Not necessary if room is well ventilated.

Protection of hands:

Protective gloves

Material of gloves:
Nitrile rubber, NBR
Natural rubber, NR

Penetration time of glove material:
The exact break through time has to be found out by the manufacturer of the protective gloves and has to be observed.
Eye protection:  
Safety Glasses with Sideshields at all times.

Face Shield with Safety Glasses when refilling.

9: PHYSICAL AND CHEMICAL PROPERTIES

9.1 Information on basic physical and chemical properties

General Information

Appearance:
- Form: Liquid
- Color: Amber colored
- Odor: Mild

pH-value at 20 °C (68 °F): 6.7

Change in condition
- Melting point/Melting range: Undetermined.
- Boiling point/Boiling range: 82 °C (180 °F)

Flash point: 18 °C (64 °F)

Ignition temperature: 370 °C (698 °F)

Auto igniting: Product is not selfigniting.

Danger of explosion: Product is not explosive. However, formation of explosive air/vapor mixtures are possible.

Explosion limits:
- Lower: 0.9 Vol %
- Upper: 12.0 Vol %

Vapor pressure at 20 °C (68 °F): 43 hPa (32 mm Hg)

Density at 20 °C (68 °F): 0.9 g/cm³ (7.511 lbs/gal)

Solubility in / Miscibility with Water: Miscible

Solvent content:
- Organic solvents: VOC Content 649 g/L

10: STABILITY AND REACTIVITY

10.1 Reactivity  No further relevant information available.

10.2 Chemical stability

Thermal decomposition / conditions to be avoided: No decomposition if used according to specifications.

10.3 Possibility of hazardous reactions  No dangerous reactions known.

10.4 Conditions to avoid  No further relevant information available.

10.5 Incompatible materials:  Strong acids, strong oxidizers.

10.6 Hazardous decomposition products:  Hydrogen chloride (HCl)
11: TOXICOLOGICAL INFORMATION

11.1 Information on toxicological effects

Acute toxicity:
Harmful if swallowed, in contact with skin or if inhaled.

LD/LC50 values that are relevant for classification:

<table>
<thead>
<tr>
<th>Substance</th>
<th>Oral LD50</th>
<th>Dermal LD50</th>
<th>Inhalative LC50/4 h</th>
</tr>
</thead>
<tbody>
<tr>
<td>67-63-0 Isopropanol</td>
<td>5045 mg/kg (rat)</td>
<td>12800 mg/kg (rabbit)</td>
<td>30 mg/l (rat)</td>
</tr>
<tr>
<td>111-42-2 diethanolamine</td>
<td>1600 mg/kg (rat)</td>
<td>12200 mg/kg (rabbit)</td>
<td></td>
</tr>
</tbody>
</table>

Primary irritant effect:
- on the skin: Possible local irritation by contact with flux or fumes.
- on the eye: Smoke during soldering can cause eye irritation. Causes serious eye damage.
- through inhalation: Vapors during use may irritate mucous membranes and respiratory system. High concentrations can cause headache, dizziness, and nausea.
- through ingestion: May cause gastrointestinal irritation.

Sensitization: Based on available data, the classification criteria are not met.

Additional toxicological information:

Carcinogenic categories

<table>
<thead>
<tr>
<th>Agency</th>
<th>Substance</th>
<th>Carcinogenic Category</th>
</tr>
</thead>
<tbody>
<tr>
<td>IARC (International Agency for Research on Cancer)</td>
<td>67-63-0 Isopropanol</td>
<td>3</td>
</tr>
<tr>
<td></td>
<td>111-42-2 diethanolamine</td>
<td>2B</td>
</tr>
</tbody>
</table>

NTP (National Toxicology Program)
None of the ingredients is listed.

OSHA-Ca (Occupational Safety & Health Administration)
None of the ingredients is listed.

12: ECOLOGICAL INFORMATION

12.1 Toxicity

Aquatic toxicity: No further relevant information available.

Additional ecological information:

General notes:
Do not allow undiluted product or large quantities of it to reach ground water, water course or sewage system.

12.5 Results of PBT and vPvB assessment

PBT: Not applicable.

vPvB: Not applicable.
13: DISPOSAL CONSIDERATIONS

13.1 Waste treatment methods
Recommendation:
Must not be disposed of together with household garbage. Do not allow product to reach sewage system. Disposal must be made according to official regulations.

Uncleaned packagings:
Recommendation: Disposal must be made according to official regulations.

14: TRANSPORT INFORMATION

14.1 UN-Number
DOT, ADR, IMDG, IATA
UN1219
14.2 UN proper shipping name
DOT, ADR, IMDG, IATA
UN 1219 Isopropanol, mixture, 3, II
14.3 Transport hazard class(es)

DOT
Class
3 Flammable liquids
Label
3

ADR, IMDG, IATA
Class
3 Flammable liquids
Label
3

14.4 Packing group
DOT, IMDG, IATA
II
14.6 Special precautions for user
Marine pollutant:
No
14.7 Transport in bulk according to Annex II of MARPOL73/78 and the IBC Code
Not applicable.

Transport/Additional information:

DOT
Quantity limitations
On passenger aircraft/rail: 5 L
On cargo aircraft only: 60 L

ADR
Excepted quantities (EQ)
Code: E2
Maximum net quantity per inner packaging: 30 ml
Maximum net quantity per outer packaging: 500 ml
IMDG
Limited quantities (LQ) 1L
Excepted quantities (EQ) Code: E2
Maximum net quantity per inner packaging: 30 ml
Maximum net quantity per outer packaging: 500 ml
UN "Model Regulation": UN 1219 Isopropanol, mixture, 3, II

15: REGULATORY INFORMATION

15.1 Safety, health and environmental regulations/legislation specific for the substance or mixture

USA The following information relates to product regulation specific to the USA.

SARA (Superfund Amendments and Reauthorization Act)
Section 355 (extremely hazardous substances):
None of the ingredient is listed.

Section 313 (Specific toxic chemical listings):
111-42-2 diethanolamine

TSCA (Toxic Substances Control Act): Kester certifies that all components listed below for the subject finished product are on the TSCA Inventory of Chemical Substances and are not subject to any chemical specific regulation under TSCA Section 12(b) export notification requirements delineated at 40 CFR part 707, subpart D.
All ingredients are listed or exempt from listing.

California Proposition 65
Chemicals known to cause cancer:
diethanolamine

Chemicals known to cause reproductive toxicity:
None of the ingredients is listed.

Carcinogenic categories
EPA (Environmental Protection Agency)
None of the ingredients is listed.

NIOSH-Ca (National Institute for Occupational Safety and Health)
None of the ingredients is listed.

CANADA:
Workplace Hazardous Materials Identification (WHMIS):
This product has been classified in accordance with the hazard criteria of the Canadian Controlled Products Regulation (CPR) and the Safety Data Sheet (SDS) contains all of the information required by the CPR.

Labelling according to Regulation (EC) No 1272/2008
The product is classified and labeled according to the CLP regulation.

Hazard pictograms

| GHS02 | GHS05 | GHS07 |

Signal word Danger
Hazard statements
H225 Highly flammable liquid and vapor.
H302+H312+H332 Harmful if swallowed, in contact with skin or inhaled.
H318 Causes serious eye damage.
SAFETY DATA SHEET (SDS)
According to 1907/2006/EC, Article 31

Trade name: 2331ZX

H335-H336 May cause respiratory irritation. May cause drowsiness or dizziness.

Precautionary statements
P210 Keep away from heat/sparks/open flames/hot surfaces. - No smoking.
P280 Wear protective gloves / eye protection.
P303+P361+P353 IF ON SKIN (or hair): Remove/Take off immediately all contaminated clothing. Rinse skin with water/shower.
P305+P351+P338 If in eyes: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing.
P304+P340 IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing.
P403+P233 Store in a well-ventilated place. Keep container tightly closed.
P501 Dispose of contents/container in accordance with local/regional/national/international regulations.

15.2 Chemical safety assessment: A Chemical Safety Assessment has not been carried out.

16: OTHER INFORMATION

This information is based on our present knowledge. However, this shall not constitute a guarantee for any specific product features and shall not establish a legally valid contractual relationship.

The information contained herein is based on data considered accurate and is offered solely for information, consideration and investigation. Kester extends no warranties, makes no representations and assumes no responsibility as to the accuracy, completeness or suitability of this data for any purchaser's use. The data on this Material Safety Data Sheet relates only to this product and does not relate to use with any other material or in any process. All chemical products should be used only by, or under the direction of, technically qualified personnel who are aware of the hazards involved and the necessity for reasonable care in handling. Hazard communication regulations require that employees must be trained on how to use a Material Safety Data Sheet as a source for hazard information.

Department issuing Safety Data Sheet (SDS): Product Compliance / EHS Department

Contact: EHS_Kester@kester.com

Date of preparation / last revision 08/14/2015 / 8

Abbreviations and acronyms:
ADR: Accord européen sur le transport des marchandises dangereuses par Route (European Agreement concerning the International Carriage of Dangerous Goods by Road)
IMDG: International Maritime Code for Dangerous Goods
DOT: US Department of Transportation
IATA: International Air Transport Association
GHS: Globally Harmonised System of Classification and Labelling of Chemicals
EINECS: European Inventory of Existing Commercial Chemical Substances
ELINCS: European List of Notified Chemical Substances
CAS: Chemical Abstracts Service (division of the American Chemical Society)
NFPA: National Fire Protection Association (USA)
HMIS: Hazardous Materials Identification System (USA)
WHMIS: Workplace Hazardous Materials Information System (Canada)
LC50: Lethal concentration, 50 percent
LD50: Lethal dose, 50 percent
PBT: Persistent, Bioaccumulative and Toxic
vPvB: very Persistent and very Bioaccumulative
Flam. Liq. 2: Flammable liquids, Hazard Category 2
Acute Tox. 4: Acute toxicity, Hazard Category 4
Skin Corr. 1B: Skin corrosion/irritation, Hazard Category 1B
Eye Dam. 1: Serious eye damage/eye irritation, Hazard Category 1
Eye Irrit. 2A: Serious eye damage/eye irritation, Hazard Category 2A
Carc. 2: Carcinogenicity, Hazard Category 2
STOT SE 3: Specific target organ toxicity - Single exposure, Hazard Category 3
STOT RE 2: Specific target organ toxicity - Repeated exposure, Hazard Category 2

* Data compared to the previous version altered.