AMOLEA™ AT2

Amolea™ AT2 is a mixture of trans 1,2 dichloroethylene, HFE-347pc-f (Asahiklin AE-3000), and a fluorinated solvent. It is a non-flammable, non-ozone depleting solvent.

Applications

- Degreasing (cutting oils, press oils, silicone oils), greases, waxes, asphalt pitches
- Defluxing of printed wiring assemblies
- Carrier solvent for silicone oils
- Replacement for 3M Novec, trichloroethylene, n-propyl bromide and Dupont Vertrel solvents

Benefits

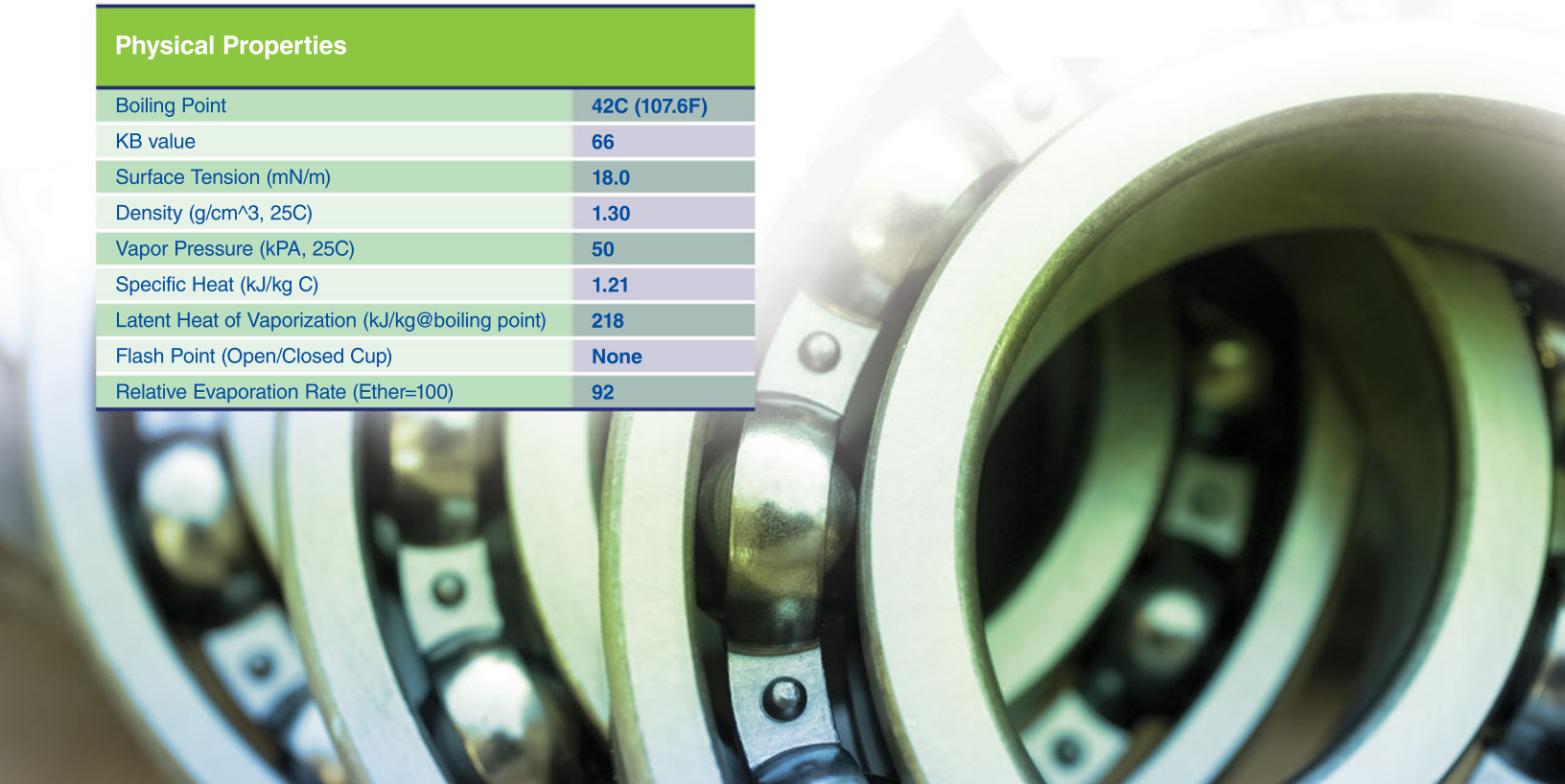
- Non-flammable
- Low surface tension, low viscosity, high liquid density
- Excellent compatibility with metals
- Excellent thermal, chemical, and hydrolytic stability
- No stabilizer additions or monitoring
- Superior drying
- Zero ozone depletion potential (ODP)
- Low global warming potential (GWP)
- Recyclable
- Can be used with ultrasonics
- Recoverable by simple distillation

Material Composition	
Components	
Trans 1,2 dichloroethylene	**50-80%**
HFE-347pc-f	**10-25%**
Fluorinated solvent	**5-25%**

Physical Properties	
Boiling Point	**42C (107.6F)**
KB value	**66**
Surface Tension (mN/m)	**18.0**
Density (g/cm^3, 25C)	**1.30**
Vapor Pressure (kPA, 25C)	**50**
Specific Heat (kJ/kg C)	**1.21**
Latent Heat of Vaporization (kJ/kg@boiling point)	**218**
Flash Point (Open/Closed Cup)	**None**
Relative Evaporation Rate (Ether=100)	**92**

Cleaning Procedures

It is recommended that Amolea AT2 be used in a vapor degreaser to optimize cleaning efficiency, economy, and emission control. The cleaning procedures commonly consist of immersing a workload into the boiling solvent, rinsing or spraying with cool solvent and drying in solvent vapor.



Material Compatibility for Plastics

Note: negative numbers denote shrinkage

	At boiling for 5min			At boiling for 3 days		
	Weight change (%)	Linear Swell (%)	Extractables (%)	Weight change (%)	Linear Swell (%)	Extractables (%)
Polyvinyl chloride (rigid)	4.8	0.21	0.22	54.0	8.4	6.1
Polyvinyl chloride (plasticized)	20.0	1.6	5.1	6.1	-5.1	31.7
Polyethylene (HP)	0.7	0.16	<0.1	11.6	2.8	0.2
Polyethylene (LP)	3.9	0.49	<0.1	32.0	7.8	0.9
Polypropylene	1.0	0.16	<0.1	21.2	4.8	1.2
Polystyrene	affected	affected	affected	affected	affected	affected
Acrylic	affected	affected	affected	affected	affected	affected
Polycarbonate	affected	affected	affected	affected	affected	affected
Polyacetal	<0.1	<0.1	<0.1	9.1	2.5	0.1
Phenolic	0.2	<0.1	<0.1	0.1	0.1	<0.1
ABS	affected	affected	affected	affected	affected	affected
PTFE	<0.1	<0.1	<0.1	1.2	0.1	<0.1
Epoxy (FR)	0.2	<0.1	<0.1	3.0	<0.1	<0.1
Nylon6	<0.1	<0.1	<0.1	-0.1	-0.2	<0.1
Nylon66	<0.1	<0.1	<0.1	0.1	<0.1	<0.1
Polyester	1.78	<0.1	0.3	19.4	0.1	5.6
Polyphenylene oxide	affected	affected	affected	affected	affected	affected
Polyphenylene sulfide	<0.1	<0.1	<0.1	n/a	n/a	n/a

Material Compatibility for Elastomers

	At boiling for 5min			At boiling for 3 days		
	Weight change (%)	Linear Swell (%)	Extractables (%)	Weight change (%)	Linear Swell (%)	Extractables (%)
Natural rubber	22	5.0	2.7	88	20	13
Urethane rubber	26	4.3	<0.1	165	33	0.3
Isobutylene isoprene rubber	21	3.1	3.3	78	7.0	16
Chloroprene rubber	23	3.5	2.3	112	24	11
Fluoroelastomer	7.0	1.7	0.2	56	18	2.0
Chlorosulfonated polyethylene	16	2.2	2.0	94	19	13
Nitrile rubber	28	4.9	2.9	179	38	15
Ethylene propylene diene terpolymer (EPDM)	24	4.0	2.1	108	21	13

Environmental Properties

Properties	Amolea AT2
Ozone Depletion Potential (ODP)[1]	None
Global Warming Potential (GWP)[2]	112
Flash Point	None

[1] CFC-11 = 1.0
[2] CO2 = 1.0, 100yr ITH

Chemistry for a Blue Planet
AGC Chemicals

Environmental Health and Safety

Please read the Safety Data Sheet available through your AGCCA technical service representative and the precautionary statement on the product package prior to use. Follow all applicable precautions and directions.

Amolea AT2 is nonflammable. The solvent is a constant boiling blend and is resistant to thermal breakdown and hydrolysis during storage and use. Recommended handling procedures are provided in the Safety Data Sheet.