

# AMOLEA™ AT2

AGC

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.

## Typical 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

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

## Physical Properties

Property	AMOLEA AT2
Boiling Point	44 °C (111.2 °F)
KB Value	66
Surface Tension (mN/m)	18.0
Density (g/cm <sup>3</sup> , 25 °C)	1.30
Vapor Pressure (kPa, 25 °C)	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

## Composition

Components	AMOLEA AT2
Trans-1,2-dichloroethylene	50-80%
HFE-347pc-f	10-25%
Fluorinated solvent	5-25%

## Cleaning Procedure

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

Material	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

Material	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

Property	AMOLEA AT2
Ozone Depletion Potential (ODP), CFC-11 = 1.0	None
Global Warming Potential (GWP), CO <sub>2</sub> = 1.0, 100yr ITH	112
Flash Point	None

## 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.



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