TECHNICAL INFORMATION SHEET

STAY CLEAN® ALUMINUM SOLDERING FLUX

FLUX DESCRIPTION & USE

Stay Clean aluminum soldering flux is an active flux formulation designed for soldering aluminum and joining aluminum to other metals. The flux is formulated with amines and complex inorganic fluorides and was designed for use with Harris Products Group Alsolder® 500.

It is also a good choice for use with other tin based solders that have a suitable melting temperature.

HEATING

During initial heating avoid directing the flame on the flux. Heat adjacent to the flux and allow heat to be conducted through the base metal. Fluxing action decreases near 600°F (315°C) so avoid overheating.

TYPICAL PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>Working temperature</td>
<td>350°F - 550°F (177°C - 288°C)</td>
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<tr>
<td>Specific gravity</td>
<td>1.30 @ 68°F</td>
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<tr>
<td>PH</td>
<td>7 - 9</td>
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</tbody>
</table>

FLUX REMOVAL

The flux is slightly corrosive so post soldering residue should be removed with hot water or other suitable cleaner.

AVAILABLE SIZES

Stay Clean aluminum flux is available in 4 oz containers and is included in Alsolder 500 kits, (flux and solder in one package).

SPECIFICATION COMPLIANCE

Harris Products Group internal standard.

SAFETY INFORMATION

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDS), and your employer's safety practices.
- Avoid eye and skin contact.
- Do not take internally.
- Keep your head out of the fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.


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