ALSOLDER® 500 ALUMINUM SOLDER

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NOMINAL SOLDER COMPOSITION:

<table>
<thead>
<tr>
<th>Component</th>
<th>Percentage</th>
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<tbody>
<tr>
<td>Tin</td>
<td>85%</td>
</tr>
<tr>
<td>Zinc</td>
<td>15%</td>
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PHYSICAL PROPERTIES: Mechanical properties of bulk solder

- Solidus: 391°F (199°C)
- Tensile Strength: Up to 20,000 psi (Cu to Cu)
- Elongation in 2": 50%
- Liquidus: 482°F (248°C)

SOLDERING PROPERTIES:
An intermediate temperature alloy useful for soldering aluminum to itself and other metals (not recommended for magnesium). Frequently used for repair of aluminum evaporators and soldering aluminum to copper tubing. When joining aluminum to dissimilar metals, the possibility of electrolytic corrosion must be considered. ALSOLDER 500 is also suited to repair zinc die cast alloys.

AVAILABLE FORMS:
- Standard wire diameters
- Preformed Rings
- Kits 1-oz of each solder & flux

SPECIFICATION COMPLIANCE:
Harris Internal

RECOMMENDED FLUX:
- Stay Clean Aluminum Flux
- Stay Clean Flux on other metals
WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
ARC RAYS can injure eyes and burn skin.
ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer’s instructions, Material Safety Data Sheets (MSDS), and your employer’s safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.