



TECHNICAL DATA SHEET

CATEGORY: **WATER SOLUBLE LIQUID FLUX**
PRODUCT: **RAD FLUX #1**

FEATURES

- WATER SOLUBLE
- ENHANCED ACTIVITY LEVEL
- CAN BE FOAMED, BRUSHED, OR DIPPED
- EXCELLENT WETTING
- WIDE PROCESS WINDOW
- FOAM RESISTANT RESIDUES

DESCRIPTION

RAD Flux #1 is a water-based, inorganically activated liquid flux designed for radiator production applications. Though designed for application via foam fluxer, RAD Flux #1 may also be applied by dipping or brushing with favorable results. Since RAD Flux #1 is highly corrosive, all residues must be rinsed with water after soldering.

PHYSICAL PROPERTIES

| SOLIDS CONTENT | FLUX DENSITY | ACID VALUE |
|----------------|--------------|----------------|
| 50% | 1.25 | 325MG KOH/GRAM |

HANDLING

- RAD Flux #1 has an unopened shelf life of 1 year when stored at room temperature.
- Do not store near fire or flame. Keep away from sunlight as it may degrade product.
- RAD Flux #1 is shipped ready-to-use, no mixing is necessary.
- Do not mix used and unused chemical in the same container. Reseal any opened containers.

FLUX APPLICATION

- RAD Flux #1 is formulated for application via foam but may be brushed, or dipped as well. Flux pots should be plastic or titanium.
- When foaming, air stones should be supplied with compressed air, free of oil and moisture. Adjust foam head to achieve a uniform distribution of small bubbles for optimum flux coverage.

PROCESS CONTROL

- Dump and refill flux pot with fresh flux at least once per week when used daily.

CLEANING

RAD Flux #1 can be cleaned in normal tap water; however, deionized water is recommended for the final rinse. A temperature of 100° - 150°F is sufficient for removing any residues. An in-line or other pressurized spray cleaning system is suggested, but is not required.

SAFETY

- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying **Material Safety Data Sheet** for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

The information contained herein is based on data considered accurate and is offered at no charge. No warranty is expressed or implied regarding the accuracy of this data. Liability is expressly disclaimed for any loss or injury arising out of the use of this information or the use of any materials designated.

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