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7047 Super Concentrate Soldering Flux

Core Bake (A)
Tank to Header (B)
Tube to Header (C)

Features

Super concentrate: Reduced shipping cost

Strong bonds

Superior foam control

100% soluble

Produces good fillets

Long life

Controlled uniform quality
Unsurpassed wettability

No chelators

Benefits

Exceptional cleaning ability for removal of fabricating oils, shop dirt and oxides

Expanded temperature parameters allowed

Easy to use - Super concentrate dilutes readily for homogeneous solutions

Economical to use - Excellent shelf life

Manufactured under strict standards

Reduced waste treatment
More than 99% volatilizes resulting in clean cores

* **Zinc Chloride free**
* **Will not turn cores green**
* **Metallic content less than 0.007%**
* **Conveniently packaged**

* **Price quotation upon request**
* **Immediate shipment**
* **No chelating agents**

Directions For Use

- A. Use as a spray, flood or immersion.
- B. Dilute 1 gallon super concentrate + 14 gallons of water = 15 gallons "Ready to use" flux.
- C. Do not add water to flux after concentrate is diluted "Ready to use".
- D. Excess flux should be blown off cores for economy and reduced residues.
- E. May be used with a wide range of solder alloys including low tin alloys.
- F. Control standards by means of analytical procedures.

PI(1)/7047SC-03/99

7047 Super Concentrate Soldering Flux
Typical Physical Properties and Analytical Methods

	<u>A (1+14)</u>	<u>B (1+ 2)</u>	<u>C (1+ 3)</u>
Free Acid:	0.693	4.75	3.46
Halogens:	21.25	96	70.50
Specific Gravity:	1.027	1.137	1.092
Baumé:	8.55	9.47	9.096
Freezing Point:	14 ⁰ F (-10 ⁰ C)		

Control

Analytical methods "Ready to use" flux

Free Acid

Titration: To a 5 ml. sample of flux, add 100 mls. of tap water in an Erlenmeyer flask, add 10 drops of Methyl Orange indicator. Titrate with 1.0 N Sodium Hydroxide to a lemon color. Multiply the end point by 1.98 to obtain the free acid value.

Example: A (1 + 14) 0.35 mls. of 1.0 N Sodium Hydroxide x 1.98 = .693

B (1 + 2) 2.4 mls. of 1.0 N Sodium Hydroxide x 1.98 = 4.75

C (1 + 3) 1.74 mls. of 1.0 N Sodium Hydroxide x 1.98 = 3.46

Halogens

Titration: To a 1 ml. sample of flux add 99 mls. of distilled water in an Erlenmeyer flask. Add 15 mls. of dilute Nitric acid and 8 mls. of 0.1 N Silver Nitrate. Add 10 drops of Ferric Ammonium Sulfate. Titrate with 0.1 N Ammonium Thiocyanate. The end point is a rust color. Subtract the amount of Ammonium Thiocyanate from the 8 mls. of Silver Nitrate and multiply by 5 for total Halogens.

Example:

A (Core Bake) 8 mls. Silver Nitrate - 3.75 mls. Ammonium Thiocyanate = 4.25

4.25 x 5 = 21.25 Halogens

B (Tank to Header) 25 mls. silver Nitrate - 5.8 mls. Ammonium Thiocyanate = 19.2

19.2 x 5 = 96 Halogens

C (Tube to Header) 20 mls. Silver Nitrate - 5.9 mls. Ammonium Thiocyanate = 14.1

14.1 x 5 = 70.5 Halogens

Note:

The Baumé (specific gravity) will increase as the flux is used due to dissolving metal oxides from the header. **DO NOT ADD** water once it is "Ready to use".

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