



SUPERIOR No. 1260



ALUMINUM SOLDERING FLUX

- A high activity flux designed for low temperature soldering of Aluminum and Aluminum alloys.
- Effective on joining Aluminum to most ferrous and non-ferrous alloys.
- Organic-based, chloride-free.

DESCRIPTION

Superior No. 1260 is a high activity, organic-based, chloride-free, viscous Aluminum soldering flux. Applications in which this flux should be used include: Aluminum-to-Aluminum, Aluminum-to-Copper, Aluminum-to-Brass, and Aluminum-to-plated terminals. This flux also performs well in hot dip coating of Aluminum cable connectors to provide a low-electrical resistance contact surface.

Superior No. 1260 can also be utilized in joining Aluminum to difficult-to-solder metals like stainless steel, kovar, or nickel. The preferred solder is 91Sn/9Zn (Eutectic 199°C/390°F) and other tin/zinc alloys. This flux has also shown to work effectively with other tin-based solder alloys, such as SN100C and 99.3Sn/0.7Cu.

DIRECTIONS

Superior No. 1260 can be used with all conventional soldering techniques, including soldering iron, torch, furnace, and dip soldering. The soldering temperature must be monitored because the flux chars at 315°C/600°F, which will result in loss of fluxing action. Overheating should be avoided.

The post-solder residues of **Superior No. 1260** are conductive and mildly corrosive. Residues are water-soluble, and an aqueous cleaning process using hot water (60°C/140°F) is recommended as the primary cleaning method. In applications where water cannot be used, methyl or isopropyl alcohols can be used to remove post-solder residues.

PHYSICAL PROPERTIES

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| Form | Viscous Liquid |
| Specific Gravity | 1.30 +/-0.05 @ 20-25°C/68-77°F |
| Density | 11.01 lbs./Gallon @ 20-25°C/68-77°F |
| Appearance | Clear, amber viscous liquid |
| Flashpoint | 180°C/355°F Tag Closed Cup Method |
| pH/10.6% Solution | 9.5 +/-0.5 @ 25°C @ 20-25°C/68-77°F |
| Recommended Soldering Range | 177-288°C/350-550°F |

THIS PRODUCT IS RoHS COMPLIANT

SAFETY PRECAUTIONS

Superior No. 1260 is mildly corrosive to steel and should be stored in sealed glass or plastic containers. Keep away from sparks, open flames, and heat sources. Avoid skin contact and/or breathing vapors. Use with adequate ventilation. Refer to material safety data sheet (MSDS) for additional information.

The certified shelf-life of this product is one (1) year if stored at room temperature.

Superior manufactures quality fluxes. Our business is solving problems.



**Superior Flux
& Mfg. Co.**

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