SUPERIOR No. 27

INORGANIC SALTS SOLDERING FLUX

- Formulated for babbitting or as a cover flux.
- Very wide process window due to low-melt point and high temperature capabilities
- Recommended for copper, copper-based alloys, and ferrous metals.

DESCRIPTION

SUPERIOR No. 27 is a white, granular powder that is active in the temperature range of 180-315°C/350-600°F. It was developed for those soldering operations requiring anhydrous flux. It is recommended for use with copper, copper-based alloys and ferrous alloys. ***SUPERIOR No. 27*** is effective in dissolving oxides and tarnish, especially when molten.

APPLICATIONS

SUPERIOR No. 27 soldering salts are used for general purpose soldering and tinning. They are also employed for roll-tinning applications, babbitting and solder pot covering. ***SUPERIOR No. 27*** is formulated for processes incorporating tin-lead alloys with tin contents ranging from 30-85%, and lead-free alloys.

DIRECTIONS

Best results can be obtained by following these guidelines:

1. Remove dirt, oil, grease and other impurities from metals to be soldered.
2. Heat the flux or sprinkle the powder on the work piece.
3. At the right temperature the flux will liquefy and rapidly flow into the joints, dissolving all surface oxides and tarnish.
4. Continue heating until the solder fills the joints, producing shiny fillets.
5. To insure complete removal of flux residues, first use water containing 2% HCl followed by as many hot water rinses as necessary.

SUPERIOR No. 27 maybe used in powder form or mixed with water. The flux residues are soluble in hot water (60°C ± 5°C /140°F ± 10°F for optimum results).

SUPERIOR No. 27 contains zinc chloride. Contact local, state, and/or federal EPA for disposal guidelines.

Keep away from heat, moisture and water, as they reduce shelf life. Return flux to sealed container to prevent caking and excessive water pickup.

Superior Flux & Mfg. Co. 6615 Parkland Blvd. • Cleveland, OH 44139 • Phone: 440-349-3000 • Fax: 440-349-3003 www.superiorflux.com • e-mail: info@superiorflux.com

PHYSICAL PROPERTIES

Form	Powder
Color	White
Bulk Density	1.5 g/cc
Water Content	Less than 1%
Humidity Effect	Significant Moisture Absorption
Melting Point	180°C/350°F
Active Temperature Range	180-500°C/355-930°F*

THIS PRODUCT IS RoHS COMPLIANT

**** Caution:*** Lead at temperatures of 500°C/900°F yields lead oxide fumes, which is a dangerous fume to breathe/ingest.

SAFETY PRECAUTIONS

SUPERIOR No. 27 contains Zinc Chloride and should be used only in well-ventilated areas. Wear NIOSH approved gloves, goggles, and ventilation masks.

- Avoid contact with skin, eyes and clothing.
- Avoid breathing dust and fumes produced during soldering processes.
- In case of eye contact, flush eyes with water and call a physician immediately.

Superior No. 27 has a two (2) year shelf life when stored properly.

Refer to Material Safety Data Sheet (MSDS) for additional information.

Store flux in cool, un-humid environment in a very tightly sealed container. Desiccant bags are recommended to prevent hygroscopic absorption of humidity into the flux.

The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Superior Flux & Mfg. Co.'s control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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