SUPERIOR NO. 462

ZINC-FREE ORGANIC ACID TINNING FLUX

- Continuous Tinning Flux for Copper Wire and Strip
- Zinc-Free, Chloride Activated, Organic Acid Formulation
- Designed for Continuous Tinning of Heavy Gage Copper Wire
- Does Complete Tinning of Strip or Wire Surfaces with a Single Pass
- Completely Water-based Formulation, No Solvents and No Alcohols

DESCRIPTION

Superior No. 462 is a zinc-free, halide-activated, organic acid type flux for continuous tinning of copper wire and strip. The acidity of the ***Superior No. 462*** comes from organic acid, as a result it is much less corrosive to tinning equipment than inorganic acid and zinc chloride based fluxes. ***Superior No. 462*** leaves minimal, zinc-free residue in the tinning pot after tinning.

APPLICATIONS

Superior No. 462 was formulated for the continuous tinning of copper wire and strip. The activity of this flux allows it to work on heavy gage wire that typically is tinned at high speeds. Normal flux application such as total immersion of the copper wire or strip is recommended. Non-continuous applications will work by adding flux by part immersion or by brush.

DIRECTIONS

1. ***Superior No. 462*** is normally applied at room temperature. It can be diluted up to three parts water to one part flux by volume.
2. For continuous copper wire or strip tinning a slight excess of flux (as evidenced by slight bubbling on the molten tin pot as the tinning occurs) is usually viewed as desirable.
3. Post-tinning residues are minimal in a continuous tinning application and therefore usually do not need to be removed.
4. In a non-continuous tinning operation, post-soldering residues are water-soluble and can normally be removed, if necessary, in a hot water wash of 60-80°C/140-176°F.

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

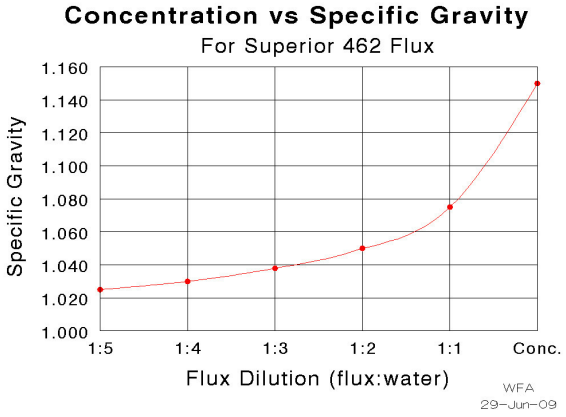
PHYSICAL PROPERTIES

Appearance	Clear, Colorless to Yellow
Specific Gravity	1.150 ± 0.010 @ 20-25°C/68-77°F
Density	9.6 Lbs./Gallon @ 20-25°C/68-77°F
pH	2.0 ± 0.50 @ 20-25°C/68-77°F
Surface Tension	32 dynes/cm minimum
Recommended Soldering Range	260-427°C/500-800°F
Odor	Mild
Flash Point	None
Freezing Point	None

This Product is RoHS Compliant

PREPARATION and HANDLING

Superior No. 462 is shipped as a concentrate to be diluted of up to three parts water to one part flux by volume. For greater strength, lower dilution ratios should be used. Mix well when diluting and check specific gravity with a hydrometer before use. The solution will not separate on standing.



SAFETY PRECAUTIONS

Since ***Superior No. 462*** attacks many metals to some extent, it is recommended that polyethylene, PVC or fiberglass reinforced polyester containers be used. Any machinery or construction materials, which might be exposed to direct contact with the flux, should also be able to withstand acids.

This product, during handling or use, may be hazardous to health or the environment. Read the Material Safety Data Sheet and warning label before using this product.

Superior No. 462 has a two (2) year shelf life.

Superior manufactures quality fluxes. Our business is solving problems.

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