SUPERIOR NO. 68

ZINC CHLORIDE-FREE FLUX

- Contains no Zinc Chloride or Ammonium Chloride.
- A versatile organic acid flux that is VOC-Free and non-hazardous.
- Used in air-conditioning, automotive, heat exchangers, refrigeration, plumbing, industrial cable and wire tinning, and other industrial tinning applications.
- Excellent for all metals except aluminum and magnesium.

DESCRIPTION

Superior No. 68 is a water-based, organic acid flux that is entirely free of Zinc Chloride. It begins to clean metals at room temperature, reaching peak activity at 260°C/520°F, where it promotes excellent solderability on mild stainless steel, Copper, and non-ferrous alloys.

DIRECTIONS

Superior No. 68 may be applied by brushing, swabbing, or dipping. Soldering should be carried out as soon as possible after applying flux. Air-drying or moderate preheating will reduce or eliminate spattering. Residues are water-soluble and can be cleaned completely using a hot (60°C/140°F) water rinse.

The following steps are recommended for optimum soldering results:

1. Remove any oil, grease, or other contaminants from the surface to be soldered.
2. Apply flux to joint by dipping, spraying, dragging, swabbing or brushing to area being soldered.
3. Preheat or air-dry area to be soldered after flux has been applied to activate the flux and yield optimum soldering characteristics and reduce or eliminate spattering.
4. Apply solder, dip part, place torch or iron to area being soldered.
5. Clean flux residues from soldered area using de-ionized, distilled, RO, and in some cases tap water heated to a temperature of 60°C±5°C /140°F±10°F for best results. Room temperature water may also be used.

SAFETY PRECAUTIONS

Superior No. 68 is a non-hazardous product, but should be treated as an industrial chemical. Store in plastic containers away from heat, sparks, or open flame. Do not store or place flux in contact with metals.

Adequate ventilation is necessary to remove flux fumes along with vapors and fumes from hot solder. Avoid breathing vapors and contact with skin, eyes and mucous membranes.

Superior No. 68 has a two (2) year shelf life.

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

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PHYSICAL PROPERTIES

Form	Colorless Liquid
Specific Gravity	1.029 ± 0.011 @ 20-25°C/68-77°F
Density	8.59 Lbs/Gallon @ 20-25°C/68-77°F
pH	1.35 ± 0.65 @ 20-25°C/68-77°F
Recommended Soldering Range	95-315°C/200-600°F
Spread Factor	80 Minimum
Surface Tension	35 dynes/cm maximum
Flash Point	None
Freezing Effects	None
Residues	Completely water-soluble

THIS PRODUCT IS RoHS COMPLIANT

DISPOSAL

Superior No. 68 is a VOC-Free flux containing organic activators. It has a water base that contains no alcohols, solvents, petroleum derivatives, heavy metals, or inorganic material additives

The following steps should be taken to effect proper disposal:

❶ Measure out the amount of flux for disposal.

❷ As a general rule, add soda ash as a neutralizer to spent flux. This ratio of neutralizer to flux may differ depending upon pre-neutralization solids content and/or pH.

❸ When the neutralization bubbling subsides, the solution may be flushed down a drain. The neutralized solution has a pH of 6 to 8. Use a pH meter or paper to determine the pH.

Consult local, state, or federal EPA to determine local guidelines regarding disposal.

ENVIRONMENTAL

Replacing Zinc Chloride-based fluxes with ***Superior No. 68*** may be crucial in meeting acceptable local Zinc discharge levels.

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