



SUPERIOR NO. 155



Solvent-Based Battery Fabrication Flux

- Low fuming
- Minimal residue
- Not highly corrosive to equipment
- Free of chlorides
- Free of organic acids
- Rapid evaporation of solvent
- Wide window of operating temperatures

DESCRIPTION

Superior No. 155 Solvent Base Battery Flux was specially formulated for high-volume case-on-strap manufacturing operations where rapid evaporation of solvent is necessary. The flux contains NO CHLORIDES, heavy metals or organic acids that could affect the long-term life of the batteries. Other key advantages are the wide window of operation at various temperatures and line speeds. Whether operating at low temperatures due to straps cracking or high temperatures to accommodate the large mass plates, **Superior No. 155** remains consistently active to produce strong burn-in cast bonds.

DIRECTIONS

Superior No. 155 provides excellent metallurgical bonding of all lead-based battery alloys as may be employed in the cast-on-strap operating process. The flux exhibits very low fuming or smoke during the burn-in manufacturing process, and leaves minimal residue after completion of the COS process.

Superior No. 155 can be applied by dipping, spraying or brushing and will function in a closed or open system. This flux has a long shelf life as well as a long working life in the flux pot.

The following steps are recommended for optimum soldering results:

- ❶ Remove any oil, grease, or other contaminants from the surface to be soldered.
- ❷ Apply flux to joint by dipping, spraying, dragging, swabbing or brushing to area being soldered.
- ❸ 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.
- ❹ Apply solder, dip part, place torch or iron to area being soldered.
- ❺ 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.

Superior manufactures quality fluxes. Our business is solving problems.



PHYSICAL PROPERTIES

| | |
|------------------------------|-----------------------------|
| Specific Gravity | 1.046 @ 20-25°C/68-77°F |
| Pounds/Gallon | 8.72/Lbs. @ 20-25°C/68-77°F |
| Flash Point (TCC) | 29°C/85°F |
| Mv | 350-450 |
| Odor | Alcoholic |
| Appearance | Clear Liquid |
| Color | Red |
| Recommended Soldering Range* | 260-455 °C/500-850 °F |

This Product is RoHS Compliant

** Due to lead oxide formation at 900°F, it is recommended that process temperature not exceed 850°F.*

SAFETY PRECAUTIONS

Superior No. 155 contains a low-flash-point solvent and should be handled with great care and caution. 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.

Refer to the MSDS for additional safety information.

Superior No. 155 has a two (2) year shelf life.

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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