

The S.A. Day Mfg. Co., Inc.

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3360/5X Soldering Flux

Tube to Header (1 + 4)
Tank to Header (1 + 4)
TOC - Inlet/Outlet (1 + 4)
Core Bake (1 + 13)

Features

Extra heavy duty composition
Can be concentrated to conserve freight
Excellent tolerance to open torch heat
Unsurpassed wettability
100% soluble
Long life
Controlled uniform quality

Benefits

Exceptional cleaning ability for removal of fabricating lubricants, shop dirt and oxides
Expanded temperature parameters allowed
Easy to use-Concentrates dilute readily for homogeneous solutions
Economical to use-Excellent shelf life
Manufactured under strict standards
More than 99% volatilizes

* **Zinc Chloride free**
* **Will not turn cores green**
* **Conveniently packaged**

* **Price quotation upon request**
* **Immediate shipment**

Directions For Use:

- A. Use by immersion, spray or with a brush.
- B. Dilute 1 gallon super concentrate + 4 gallons water = 5 gallons "Ready to use" flux.
- C. Do not add water to flux after concentrate is diluted "Ready to use".
- D. Excess flux should be blown off cores for economy and reduced residues.
- E. May be used with a wide range of solders.
- F. Control standards by means of easy analytical procedures.

PI(1)/3360 03/99

3360/5X Soldering Flux

Typical Physical Properties and Analytical Methods

Tube to Header		Core Bake (Automotive)
Free Acid:	1.20 - 1.60	.396 (.297 - .495)
Halogens:	100 - 120	35 - 45
Specific Gravity:	1.70 - 1.80	1.067
Baumé:	20	9.1
Freezing Point:	14 ⁰ F (-10 ⁰ C)	

Control

1 + 4 Dilution = Above Control Standards

1 + 13 Dilution = Above Control Standards

Free Acid

Titration: To a 5 ml. sample of flux, add 100 mls. of tap water in an Erlenmeyer flask, add 10 drops of Methyl Orange indicator. Titrate with 1.0 N Sodium Hydroxide to a lemon color. Multiply the end point by 1.98 to obtain the free acid value.

Example: 0.7 mls. of 1.0 N Sodium Hydroxide x 1.98 = 1.386 (Tube to Header)

Example: 0.2 mls. of 1.0 N Sodium Hydroxide x 1.98 = .396 (Core Bake)

Halogens

Titration: To a 1 ml. sample of flux add 99 mls. of distilled water in an Erlenmeyer flask, add 15 mls. of dilute nitric acid and 25 mls. of 0.1 N Silver Nitrate, add 10 drops of Ferric Ammonium Sulfate. Titrate with 0.1 N Ammonium Thiocyanate. The end point is a rust color. Subtract the amount of Ammonium Thiocyanate from the 12 mls. of Silver Nitrate and multiply by 5 for the total halogens.

Example: 25 mls. Silver Nitrate - 3 mls. Ammonium Thiocyanate = $22 \times 5 = 110$ Halogens (Tube/Header)

Example: 25 mls. Silver Nitrate - 16.4 mls. Ammonium Thiocyanate = $8.6 \times 5 = 43$ Halogens (Core Bake)

Note: The Baumé (specific gravity) will increase as the flux is used due to dissolving metal oxides from the header. **DO NOT ADD** water to the flux once it is "Ready to use".

Super Concentrate: 1 gal of concentrate + 4 gal of water = 5 gallons of "Ready to use" flux for tube to header.

Core Bake (Industrial) 1 + 11 Dilution

Free Acid: .396 - .594

Halogens: 40 - 55

Specific Gravity: 1.084

Baumé: 11.25

PI(2)/3360/5X-03/99