

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

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7114J Tube Mill Flux

Features

Excellent penetration

Unsurpassed wettability

Balanced composition as ready to use or concentrate solutions

Long life

100% soluble

Controlled uniform quality

Can be used on mills running in excess of 300 ft./min.

Benefits

Extra cleaning components added for exceptional cleaning ability for removal of forming lubricants, oxides, and mill soils.

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 resulting in clean tubes

* **Zinc Chloride free**
* **Conveniently packaged**

* **Price quote upon request**
* **Immediate shipment**

Directions For Use

A. Use by immersion

B. Dilute 1 gallon super concentrate
+ 3.24 gallons water = 4.24 gallons
"Ready to use" product

C. Do not add water to flux after
concentrate is diluted "Ready
to use"

D. May be used with a wide range of alloys

E. Control standards by means of easy
analytical procedures

F. Tighten rolls for stronger joint

7114J Tube Mill Flux
Typical Physical Properties and Analytical Methods

Free Acid:	7.0-8.0
Halogens:	35-45
Specific Gravity:	1.02-1.05 @ 77 ^o F (25 ^o C)
Baumé:	1.44
Freezing Point:	-13 ^o F (-25 ^o C)

Control

Analytical methods performed on "Ready to Use" flux

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: 3.69 mls. of 1.0 N Sodium Hydroxide x 1.98 = 7.3

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 10 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 10 mls. of Silver Nitrate and multiply by 5 for total Halogens.

Example: 10 mls. Silver Nitrate - 2.4 mls. Ammonium Thiocyanate = 7.6
7.6 x 5 = 38 Halogens

Note:

The Baumé (specific gravity) will increase as the flux is used due to dissolving metal oxides from the tubes. ***Do Not Add*** water to the flux once it is "ready to use".

Super Concentrate - 1 gallon of super concentrate plus 3.24 gallons of water =
4.24 gallons of "ready to use" flux.