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7818RL/10X Soldering Flux

Tube to Header

Core Bake for Large Trucks and Large Cores

Features

Heavy duty composition as "ready to use" solution

Can be concentrated to conserve freight

Strong bonds

Superior foam control

100% soluble

Produces good fillets

Long Life

Controlled uniform quality

Benefits

Exceptional cleaning ability for removal of fabricating oils, shop dirt and oxides

Expanded temperature parameters allowed

Easy to use - Concentrate dilutes readily for homogeneous solutions

Economical to use - Excellent shelf life

Manufactured under strict standards

More than 99% volatilizes resulting in clean cores

Unsurpassed wettability

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

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- * Price quotation upon request
 - * Immediate shipment

Directions For Use

- A. Use as a spray, flood or immersion
- B. Dilute 1 gallon super concentrate + 9 gallons water = 10 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 wide range of solder alloys.
- F. Control standards by means of easy analytical procedures.

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7818RL/10X Soldering Flux
Core Bake & Tube to Header
Typical Physical Properties and Analytical Methods

Free Acid:	2.1 - 2.5
Halogens:	45 - 55
Specific Gravity:	1.60 - 1.70
Baumé:	8.85
Freezing Point:	14 ⁰ F (-10 ⁰ C)

Control

Analytical methods “ 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: 1.1 mls. of 1.0 N Sodium Hydroxide x 1.98 = 2.178

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 12 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: 12 mls. Silver Nitrate - 2 mls. Ammonium Thiocyanate = 10
10 x 5 = 50 Halogens

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 gallon of super concentrate + 9 gallons of water =
10 gallons of “Ready to use” flux