



Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

JOHNSON'S PRODUCTS *for* BABBITTING

E-127 FLUX- 'N-SOLDER WITH PURE TIN

Part No. 16-00 series

A mildly aggressive, inorganic paste flux mixed with pure tin powder. This product contains less than 0.2% lead.

JOHNSON'S SOLDERING FLUID

Part No. 01-00 series

An excellent liquid zinc chloride flux which contains no free acid. It is highly active when heated, yet nearly inactive when cold.

LLOYD'S STAINLESS STEEL SOLDERING FLUX

Part No. 03-00 series

Our most aggressive, inorganic chloride flux which contains hydrochloric acid. Designed to solder stainless, chrome and other difficult to solder metals.

JOHNSON'S TIN-EZY POWDER OR BUTTER

Part Nos. 20-00 & 23-00 series

Johnson's Tin-Ezy compounds are blends of inorganic chlorides (in powder or butter form) mixed with powdered tin/lead solder or pure tin.

BABBITT METALS

We manufacture most grades and forms of babbitt metals.

The following briefly describes the use of E-127 Flux-'N-Solder to pre-tin a bearing surface. Using a torch or furnace, raise the temperature of the shell to approximately 550-600° F. Brush E-127 on the surface using a fiberglass acid brush and note how quickly it tins. Make sure the entire surface is coated, leaving no voids or dark areas. Reapply as necessary. To tin difficult areas, apply Lloyd's Stainless Steel Flux and scrub with a stainless steel toothbrush, if necessary. Johnson's soldering Fluid may be applied to the heated surface using a fiberglass acid brush or spray bottle. The powerful cleaning action of this flux, will loosen the black residues and lay a protective coating on the newly tinned surface to prevent re-oxidation. If any residues still appear to stick to the surface, apply more Johnson's Soldering Fluid and scrub until completely dissolved. Re-heat the part. Bring the babbitt alloy to approximately 100°F over its melting temperature, and pour. Brush the molten surface with a flame, gradually withdrawing the heat until the babbitt metal solidifies, uniformly. If rapid solidification is called for, Johnson's Soldering Fluid mixed with water can be an effective quench.



TO ORDER CALL (800) 747-0030, FOR SUPPORT CALL (563) 289-5123, TO SEND FAX (563) 289-3825, EMAIL TO johnsonmfg@aol.com

Some bearing surfaces may require the deeper cleaning of Johnson's Tin-Ezy(s) to bring about a perfectly tinned shell. The use of Johnson's Soldering Fluid is still effective for removing these residues and preventing oxidation during the pouring operation as described above.

Wash the entire part to remove all chloride residues.