



Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

JOHNSON'S MILD CHLORIDE LIQUID FLUX for PRIVATE LABEL CONTRACTORS Part No. 04-60 Series

DESCRIPTION:

Johnson's Mild Chloride Liquid Flux provides the perfect balance for most soldering jobs that are done by the handyman or hobbyist. It's mildly aggressive nature makes it ideally suited for use on easy-to-solder metals such as copper, brass and pre-tinned steels, where little or no staining is desirable. Its chloride based formula contains no free acid, yet it has enough fluxing power for soldering mild steel, cast iron, some galvanized, and other coated metals. It resists spattering, smoking, and doesn't produce objectionable fumes however, as with any soldering flux, it should be used only in well ventilated areas.

PHYSICAL DATA:

Specific Gravity	1.100 ± .005 @ 60° F
pH	5
Appearance	Clear Liquid
Odor	None

USAGE:

Johnson's Mild Chloride Liquid Flux does not require dilution for most soldering jobs. Apply flux sparingly, contacting all surfaces to be soldered. This flux is thickened to keep it from running off the workpiece, yet it is very easy to apply. It wets all surfaces, without pulling back. Johnson's Mild Chloride Liquid Flux works well using a variety of heat sources, such as soldering iron, torch or oven. Avoid overheating the flux during soldering as it will turn very dark (char) thereby losing some of its fluxing power. Residues should be removed immediately after soldering. Residues are easily removed with water; hot water and/or scrubbing speeds removal of charred residues. DO NOT USE for soldering electronic or electrical assemblies.

HANDLING:

Wear protective clothing and eye wear when handling this flux. Please refer to the *OSHA Material Safety Data Sheet* for additional information. Store, mix, and use in non-metallic containers only.

WASTE DISPOSAL:

We cannot make specific recommendations due to variations in local laws.



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