



Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

LLOYD'S NO. 101 NO-CLEAN ORGANIC ACID SOLDERING FLUX Part No. 04-70 Series

DESCRIPTION:

Lloyd's No. 101 NO-CLEAN, Organic Acid Flux is highly effective flux for the production soldering of electrical connections, stranded wire harnesses, or other copper or pre-tinned surfaces. This alcohol based flux contains no resins or halide type activators therefore, only a slight trace of active residues may remain on the workpiece after soldering.

PHYSICAL DATA:

Hazard	Flammable
Flash Point	51°F
Decomposition Temp.	450°F Approx.
Density	6.65 Lbs/Gal.
Specific Gravity	0.8 ± .005 @ 60° F
Appearance	Clear Liquid
Odor	Alcohol Odor

USAGE:

Lloyd's No. 101 NO-CLEAN is designed to be used straight (no-dilution recommended). When this flux is used as a dipping flux, the solids level may increase due to evaporation of its alcohol carrier. Titration is suggested as a means to monitor this flux. Isopropyl alcohol may be added as necessary to maintain the proper solids content. Flux may also be brushed or sprayed on surfaces to be soldered.

DIRECTIONS:

This flux contains less than 1% water, therefore it should not spatter when used as a dipping flux. When using organic acid fluxes for dipping cable ends or insulated wires, it is a good practice to touch the fluxed ends to a moist sponge, or shake them to remove excess flux before dipping in the solder bath. Doing so can cut the amount of flux forced up the wire, under the insulation, by more than half. This greatly reduces the chance for corrosion, where wire temperatures may not reach the decomposition threshold of the flux.

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

HANDLING:

Lloyd's No. 101 is flammable. Store away from heat, sparks or open flame. Use this flux only in areas with adequate ventilation. Avoid breathing vapors and contact with skin, eyes or mucous membranes. Store flux in plastic (polyvinyl chloride or polyethylene) containers only. Wear protective clothing and eye wear when handling this flux. Avoid mixing other chemicals with this flux. Please refer to the *OSHA Material Safety Data Sheet* for additional information.

WASTE DISPOSAL:

Used Lloyd's No. 101 may constitute a flammable waste and must be disposed of properly. Beyond this, we cannot make specific recommendations due to variations in local laws.