



## **FLUX 1026 - RESIDUE FREE** **MANUFACTURE OF BATTERIES IN THE C.O.S. PROCESS**

### **① ➤ DESCRIPTION – PRESENTATION.**

A low temperature flux that is totally eliminated when dipped into the soldering bath.

Due to its own organic acidity, this flux has a good pickling capability and leaves no combustion residues. Parts stay in their original state and it does not pollute the soldering bath.

### **② ➤ CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS.**

Flux 1026 is formulated from the synthesis of one specially selected acid and one amine salt. In the temperature range where lead and lead alloys used in the manufacture of batteries melt, Flux 1026 is removed by sublimation. After soldering there are no residual salts, therefore eliminating any conductivity and corrosion phenomena.

#### COMPOSITION

Secondary amine salts  
Organic acid

#### PHYSICO-CHEMICAL PROPERTIES

Density at 20° C = 0,9  
pH = 4,7 ± 0,3  
Impurities :  
Chlorides < 50 ppm  
Fe < 10 ppm  
Cu < 10 ppm  
Mn < 10 ppm  
Ni < 10 ppm  
Zn < 10 ppm  
Co < 10 ppm

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#### **3 ➤ PRODUCT APPLICATION**

Non-corrosive flux, formulated for the manufacture of accumulators and security dry batteries.

It is intended for the soldering of heavy metals : lead, tin-lead on automatic production lines of plate-components kits - for starter batteries, calcium-lead or antimony-lead.

It has also been specially designed for the soldering of the plate/connector lugs in the C.O.S. process, and for thick plates in the manufacture of stationary batteries where the lack of residue avoids discharge problems.

#### **4 ➤ DIRECTIONS FOR USE.**

Flux 1026 must be used undiluted on the surface of the lugs.

#### **5 ➤ USING CARE AND RECOMMENDATIONS.**

Without particular risk.

For all other information please see the Material Safety Data Sheet also available on our web site ([www.stts-flux.com](http://www.stts-flux.com)) or contact us directly.