



TECHNICAL
DATA SHEET

FLUXAK 1396

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IR : 2

Tinning of lead and copper alloy parts

. PRODUCT DESCRIPTION

A low temperature flux that is totally removed when the parts are dipped into the soldering or tinning bath. This flux is formulated from specially selected amine salts.

It is removed by sublimation in the melting range of the lead and lead alloys that are used in the manufacture of batteries. As there are no residual salts after welding, this technology prevents auto discharge and corrosion phenomena.

This flux has a good reducing power and does not leave combustion residues. The parts remain in their original state and it does not pollute the soldering or tinning bath.

. CHARACTERISTICS - PHYSICO-CHEMICAL PROPERTIES, COMPOUND ELEMENTS

Amine Chlorhydrate

Wetting agents

. APPLICATION FIELD

An organic flux designed for the manufacture of batteries, security dry batteries and copper alloy heat exchangers. It is designed for the tinning of heavy metals: lead, tin-lead on automatic production lines of plate components kits and for starter batteries, calcium lead or antimony lead.

. DIRECTIONS FOR USE

This flux can be used pure or diluted in water, depending upon the surface quality of the parts (oxidised or dirty lugs). When used in its diluted form it is necessary to dry the lugs before tinning. For the manufacture of copper alloy heat exchangers, the dilution changes from 7% to 15% in water depending upon the surface quality.

. USING CARE AND RECOMMENDATIONS

For all other information please refer to the Material Safety Data Sheet available on demand