



TECHNICAL SPECIFICATION SHEET

J.W. HARRIS CO., INC.
4501 QUALITY PLACE
MASON, OHIO 45040
TEL. (513) 754-2000
FAX, (513) 754-8778
www.jwharris.com

ISO 9002
Cert. No. 31598

STAY CLEAN[®] ALUMINUM SOLDERING FLUX

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS (INFRARED RADIATION) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheet (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

STATEMENT OF LIABILITY — DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. J.W. Harris Co., Inc. and its affiliates shall have no liability in respect thereof.

NOMINAL COMPOSITION:

Aminoethylethanolamine
Ammonium Fluoborate
H₂O
Tin
Zinc

PHYSICAL PROPERTIES:

Color	Thick Amber Liquid
Flash point	275°F
Boiling point	273°F
Specific Gravity (H ₂ O =1)	1.245
Solubility in water	100%

SOLDERING PROPERTIES:

Stay Clean[®] Aluminum soldering flux is a chloride free flux for soldering aluminum alloys and dissimilar metals using Tin/Zinc, Tin /Silver and other soft solders.

Optimal temperature range of this viscous amber flux would be 350° - 550°F which has an ammonia odor.

AVAILABLE FORMS: 4 oz. With 24 to a case or Alsolder 500 Kits 1-oz of each solder & flux

SPECIFICATION COMPLIANCE: J.W. Harris Internal

J.W. Harris Co., Inc.
4501 Quality Place
Mason, Ohio 45040

Customer Service: 800-733-4533
800-733-4043
Technical Service: 800-733-5956 ext. 6192
Facsimile: 513-754-8778
E-mail: salesinfo@jwharris.com
techsupport@jwharris.com

For technical support and product information, visit our web site at www.jwharris.com.