

**FORCE  
INDUSTRIES  
DIVISION**

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**PRODUCT INFORMATION**

**AMCO 4327**

(154)

**GENERAL CHARACTERISTICS AND USES**

**AMCO 4327** is a non-corrosive organic flux, which contains a highly refined resin activator and stabilizer in a blend of alcohol solvents. Designed especially for soldering handles and nozzles on F style cans and for use in the fabrication of 5 gallon square cans which are air tested for leakage.

**PHYSICAL DATA**

- o Clear white liquid with viscosity similar to water
- o Specific gravity: 0.845 ± 0.006 @ 68°F
- o Weight per gallon: 7.04 lbs.
- o Flash point: 48°F
- o Boiling point: 199°F
- o pH: 5.53
- o Surface tension: 24.8 dynes/cm
- o Shelf life: 2 years in unopened container stored at room temperature
- o Resistivity: 94,000 ohm-cm
- o FDA Approved

**APPLICATION**

- o Can be used with most Sn/Pb soft solders, particularly those alloys near the eutectic solder.
- o Compatible with can lining coatings.

**RESIDUE**

- o Residue is non-corrosive and transparent with esthetic characteristics.

**PACKAGING**

- o 1 gallon jug
- o 5 gallon jug
- o 55 gallon drum

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