

**FORCE  
INDUSTRIES  
DIVISION**

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**PRODUCT INFORMATION**

**AMCO 69**

(592)

**ALUMINUM SOLDERING FLUX**

**GENERAL CHARACTERISTICS AND USES.**

**AMCO 69** is a chloride free, organic flux especially formulated for low temperature, 350°F to 550° F (177°C to 288°C) soft soldering of aluminum. It is designed specially for joining aluminum to aluminum and aluminum to copper wire and cable in the electrical industry. The recommended solder for use with Amco 69 flux is 807, basically a Pb-Bi solder with small amounts of Ag and Sn.

**PHYSICAL DATA**

- Clear to hazy, amber colored, viscous liquid.
- Specific Gravity: 1.31 @ 70 °F
- Weight per gallon: 10.07 lbs
- Working Temp. 350°F to 550 °F
- pH 9.0 - 10.5
- Shelf Life At least one year in the unopened original and undamaged container stored temperatures below 100°F. Keep from freezing.

**APPLICATION**

- Use as is or dilute with ethyl alcohol. Dilution ratio depends on operating conditions and must be established accordingly.
- Used in high volume soldering of incandescent lamp bases.

**RESIDUE**

- The active ingredients may be decomposed under the soldering temperature but may leave slightly corrosive products. If desired, the residue may be removed with water or alcohol.

**PACKAGING**

- 5-gallon jugs
- 55-gallon drums

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