

**FORCE
INDUSTRIES
DIVISION**

American Solder & Flux Co., Inc. • 28 Industrial Boulevard • Paoli, PA 19301-0947 • (610) 647-3575 • FAX (610) 647-2375

PRODUCT INFORMATION

AMCO 4701-T SOLDERING FLUX

(625)

GENERAL CHARACTERISTICS AND USES.

Amco 4701-T flux is a concentrated formulation developed specifically for the soldering of copper, copper based alloys and specialty copper based metals such as beryllium copper. It is a water-based flux and can be diluted with tap water. Amco 4701-T has also been designed for the soldering of copper radiators.

PHYSICAL DATA

- ◆ Water clear to amber colored liquid. Color shift is a natural change and does not affect product performance and activity.
- ◆ Specific Gravity: 1.17 – 1.19 @ 72 °F (22 °C)
- ◆ Weight per gallon: 9.74 – 9.91 lbs/gal
- ◆ % Active Ingredients: 50% minimum
- ◆ Flash Point: None
- ◆ Boiling Point: 214 °F (101 °C)
- ◆ Shelf Life: At least one year in the unopened original container stored at room temperature

APPLICATION

- ◆ Best result obtained with tin-lead alloys containing 20-30% tin, small percent antimony; rest lead. However, all common soft solders can be used.
- ◆ When used as a flux for top and bottom tank attachment to the core, it should be diluted at a minimum with 4 volumes of water with 1 volume of Amco 4701-T.
- ◆ Can be diluted as low as 20 volumes of water with 1 volume of Amco 4701-T, depending on the conditions and results desired.

RESIDUE

- ◆ The active ingredients may be decomposed under the soldering temperature, thereby leaving no corrosive products

PACKAGING

- ◆ 1 gallon jug (4/carton)
- ◆ 5 gallon plastic jug.
- ◆ 55 gallon non returnable drum

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