

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

AMCO 5135 ALUMINUM SOLDERING FLUX

(807)

GENERAL CHARACTERISTICS AND USES

Amco 5135 is a chloride free liquid, low viscosity version of Amco 2213 designed specifically for soldering to aluminum, to copper and to stainless steel. This flux is formulated with amines and complex inorganic fluorides with an optimal temperature range of 350F - 550F. Excellent results when used with 91Sn/9Zn, 63Pb/34Sn/3Zn or 50Sn/50Zn soldering alloys.

PHYSICAL DATA

Clear to hazy, amber colored, syrup.

Specific Gravity: 1.30 – 1.35 @ 70 °F

Working Temp. 350 °F to 550 °F

Weight per gallon: 10.8 -11.2 lbs

pH 8-10

Viscosity 1300-1800 cps (Brookfield RV. Spindle#3@ 20 rpm, 78F)

PERFORMANCE CRITERIA

Residue is slightly corrosive - remove with hot water.

Rapid cleaning and de-oxidation of surface area

Excellent dispersion properties

Proven performance on aluminum cable and wire connector.

Chars and deteriorates near 600 °F with loss of fluxing action. Avoid overheating.

STORAGE AND HANDLING

Shelf Life: At least one year in the unopened original and undamaged container stored at room temperatures.

Keep from freezing. The product will increase in viscosity at low temperatures. Warming will restore it to normal working viscosity.

PACKAGING

1 lb. bottles - 12 per case

10 lb. bottles - 4 per case Gallon jugs - 4 per case

50 lb. Pail

While we believe the data presented herein is accurate and reliable, the data are not to be taken as a guarantee or representation of any kind for which Force Industries assumes legal responsibility. They are offered solely for your consideration, investigation and verification.