



RADEX™ #200 FLUX

- LOW RESIDUE - Rinsing is not needed.**
- NON-CORROSIVE - No green corrosion or pin holes.**
- LESS SPITTING AND POPPING - Easier to work with.**
- GOOD TUBE TO HEADER JOINT - Produces nice solder fillet.**

Radex #200 flux is an organic compound of hydrobromic acid specifically designed for solder pot dipping of copper, brass and steel components. This product meets the radiator manufacturer's requirements for a header dipping flux which leaves no residue after soldering. This is what is commonly called "low residue" or "non-corrosive" flux.

The #200 flux is less volatile than #140 and more volatile than ZCF. The highly concentrated flux contains a special wetting agent that forms a very nice fillet between tubes and headers. It is also designed to cut through the most stubborn stamping oils without a pre-wash in caustic soda. The flux may also be used in heater manufacture and tube mills.

HEADER DIPPING IN A SOLDER POT

Start with a water dilution of 1 to 3 (5.5° Bé specific gravity). This may be varied depending on your actual conditions. Ventilation is recommended as is the use of goggles, gloves and apron. In actual use the piece is dipped into the diluted flux for 10 to 15 seconds. The core assembly should be rocked back and forth slowly to be sure trapped air bubbles do not prevent the flux

from getting to all parts of the header. Allow the excess flux to drain off by tilting the core and holding it over the flux tray for a few seconds. The header is dipped into the solder for a time appropriate for the gauge of metal used. Usually this is for 10 to 30 seconds. You will notice that there is less spitting and popping than with some other fluxes. The heat of the pot will volatilize all the flux leaving no residue if care was taken not to get flux too far up the tubes or fins. A support in the flux tray helps to prevent dipping to far. The temperature of the pot depends on the solder alloy being used.

As water evaporates from the flux tank the flux becomes stronger. The flux should be tested daily and enough water added to keep the specific gravity correct. Use a Hydrometer and/or Acid Test Kit to control daily additions of water and flux.

Contains no hydrazine or hydrazine compounds.

PHYSICAL DATA: Color: Colorless
Odor: Mild Acidic

PACKAGING: 55 gallon plastic drums

Dilutions:

	<u>Flux: Water</u>	<u>Hydrometer</u>
<u>HEADER DIPPING</u>	1:3	5.5°
<u>FACE DIPPING</u>	1:3 - 1:4	5.5 - 4.5°
<u>HEATER CORES</u>	1:3 - 1:4	5.5 - 4.5°
<u>TUBE MILLS OR TINNING BRASS STOCK</u>	1:2 - 1:3	7.0 - 5.5°

Radex200.pub - 3/14/04