TECHNICAL INFORMATION SHEET

STAY CLEAN® LIQUID SOLDERING FLUX

DESCRIPTION:

Stay Clean liquid flux is an inorganic acid & salt type flux. It is formulated to be active at temperatures optimum for a range of solder compositions and is ideal for soldering a variety of base metals as noted below.

PHYSICAL DATA:

Color	Clear to slightly yellow liquid
pH	1.2

PROPERTIES & USE:

Stay Clean liquid effectively removes surface oxide and prevents oxide formation during soldering. Stay Clean can be used with most tin-based solder compositions and is an excellent companion flux with Harris Stay Brite® and Stay Brite® #8. Stay Clean is an active soldering flux. It works well on copper and brass but is more frequently used on base metals that require a more aggressive flux, such as steel, nickel, and stainless steel, (it is not suitable for aluminum or magnesium).

Minimal pre-cleaning is required with Stay Clean Flux, but it is good practice to remove excess oil, grease, or other surface contaminants prior to fluxing and soldering.

Flux should be applied with a brush or other type applicator. Avoid getting excess flux inside tube or other connections.

Flux residue is corrosive, and a post-solder flux removal procedure should be employed. Because of this it is not recommended for use in electrical or electronic applications.

FLUX RESIDUE REMOVAL:

Stay Clean contains zinc and ammonium chloride and a small percentage of hydrochloric acid. To best neutralize remaining residue the following steps are suggested as soon as possible after soldering.

1. Thoroughly soak and wash soldered parts in a solution made up of one to two ounces tri-sodium phosphate (TSP) or bicarbonate of soda added to one gallon of water heated to 120^{O} F (49 ^{O} C).

2. Rinse thoroughly in a detergent treated water, heated to 120 ^{O} F (49 ^{O} C) Keep parts in motion to promote complete removal of step 1.

3. The final rinse is accomplished using clean water heated to 120 ^{O} F (49 ^{O} C) and keep parts in motion to remove step 2 processes.

SPECIFICATION COMPLIANCE:

Commercial Specification A-A51145D Type I Form B Liquid,
Federal Specification OF-506C Type 1 Form B, (cancelled 9Jan87).

AVAILABLE SIZES:

4 oz.	48/ case
16 oz.	24/case
32 oz.	12/case
1 gallon	4/case
55-gallon drum	



SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES and VAPORS can be hazardous to your health.
FLUX IS CORROSIVE: may be harmful or fatal if inhaled or swallowed.
FLUX CAUSES SKIN AND EYE BURNS.
DO NOT TASTE OR SWALLOW.
DO NOT GET ON SKIN OR IN EYES.
KEEP OUT OF THE REACH OF CHILDREN.
HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.
Before using it, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
Keep your head out of fumes. Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
Wear correct eye, ear, and body protection.
See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes,* published by the American Welding Society,
8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

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