TECHNICAL INFORMATION SHEET

STAY CLEAN® PASTE SOLDERING FLUX

FLUX DESCRIPTION & USE:

Stay Clean Paste Soldering Flux is an active zinc/ammonium chloride formulation designed primarily for soldering copper and brass. It is also effective on some grades of clean steel. For stainless steel or other metal alloys, (except aluminum), use Stay Clean Liquid Soldering Flux.

Stay Clean Paste Flux is an excellent choice for use with leaded and lead-free solders. Its petrolatum base allows convenient brush application and promotes adherence on pipe and tube.

Stay Clean Paste Flux may be used in selected plumbing applications, but confirm compliance to applicable plumbing codes. For applications where flux must conform to ASTM B813, use Harris Water Soluble Flux.

HEATING:

Stay Clean Paste Flux is effective with air-fuel torches, soldering irons/guns, and other soldering heating methods. During initial heating avoid directing the flame on the flux. Heat adjacent to the flux and allow heat to be conducted through the base metal. Fluxing action decreases near 600°F (316°C) so avoid overheating.

TYPICAL PHYSICAL PROPERTIES:

Working temperature	350°F - 600°F (177°C - 316°C)
Density	0.95 g/cm^3

FLUX REMOVAL:

The flux is mildly corrosive so post-soldering residue should be removed with hot water or other suitable cleaner.

SPECIFICATION COMPLIANCE:

O-F-506 C Type 1 Form A
A-51145 D Type 1 Form A

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.
FUMES AND GASES can be hazardous to your health.
HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (SDS), and your employer's safety practices.
- Avoid eye and skin contact.
- Do not take internally.
- Keep your head out of the 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.

STATEMENT OF LIABILITY- DISCLAIMER:

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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