

Solders, Fluxes, Kits, and Soldering Units

FLUXES

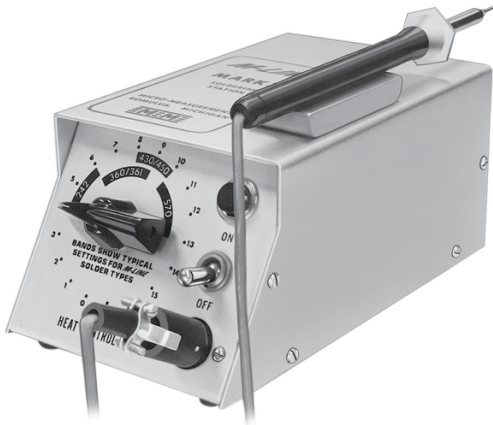
With solid wire solders, it is necessary to use separate, externally applied fluxes. Even with rosin-core solders, flux may be helpful when soldering fine jumper wires to gage tabs or printed-circuit terminals, because not enough flux is released from the cored solder. It may also be necessary to supplement the cored flux in high-temperature solders such as Type 570.

Two fluxing compounds are available for strain gage soldering applications. M-Flux AR is an active but noncorrosive rosin flux that is effective on constantan, copper, and nickel. M-Flux SS is a very active acid flux

that is used primarily with solid-wire solders applied to isoelastic and K-alloy gages, and to stainless steel. The two fluxes should never be mixed. Whether the rosin or acid flux is used, it must be completely removed immediately after soldering to prevent degradation of protective coatings and corrosion of the metals, and to eliminate conductive flux residues. Rosin residues are best removed with *M-LINE* Rosin Solvent. Removal of M-Flux SS requires two steps: liberal applications of M-Prep Conditioner A, which must be blotted dry; and then M-Prep Neutralizer 5A, also to be blotted dry.

FLUX AND ROSIN SOLVENT KITS (See Note 1)	
FAR-2 M-Flux AR Kit	Two 1-oz (30-ml) brush-cap bottles M-Flux AR Two 1-oz (30-ml) brush-cap bottles <i>M-LINE</i> Rosin Solvent
RSK-1 M-LINE Rosin Solvent Kit	Twelve 1-oz (30-ml) brush-cap bottles
RSK-2 M-LINE Rosin Solvent Bulk	1-qt (960-ml) bottles
RSK-4 M-LINE Rosin Solvent Kit	Four 1-oz (30-ml) brush-cap bottles
FSS-1 M-Flux SS Kit	One 1-oz (30-ml) applicator cap bottle M-Flux SS One 1-oz (30-ml) brush-cap bottle M-Prep Conditioner A One 1-oz (30-ml) brush-cap bottle M-Prep Neutralizer 5A

Note 1: All products shown are RoHS compliant.

MARK V SOLDERING STATION	
	<p>A time-proven precision soldering instrument for miniature and/or delicate soldering applications. Full 25-watt rating in 17 selector positions to handle all <i>M-LINE</i> solder alloys except 1240-FPA. Magnetic solder pencil holder and flexible, burn-resistant cord. Lightweight soldering pencil [1.1 oz (31g)]. Specify 115 or 220 Vac, 50 or 60 Hz operation.</p> <p>M5S-1 Mark V Soldering Station, Complete with M5S-4 Tip</p> <p>M5S-2 Mark V Control Unit only</p> <p>M5S-3 Mark V Soldering Pencil only (includes one tip)</p> <p>M5S-4 Mark V Soldering Tip only</p>



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