

## Solders, Fluxes, Kits, and Soldering Units

### FLUXES

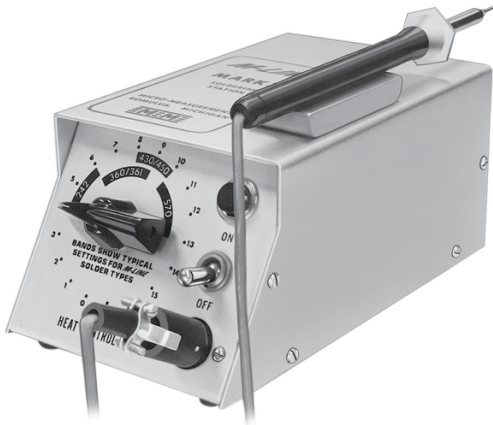
With solid wire solders, it is necessary to use separate, externally applied fluxes. Even with rosin-core solders, flux may be helpful when soldering fine jumper wires to gage tabs or printed-circuit terminals, because not enough flux is released from the cored solder. It may also be necessary to supplement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

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

**Note 1:** All products shown are RoHS compliant.

| <b>MARK V SOLDERING STATION</b>   |   |
|---|---|
|  | <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><b>M5S-1</b>    <b>Mark V Soldering Station</b>, Complete with M5S-4 Tip</p> <p><b>M5S-2</b>    <b>Mark V Control Unit only</b></p> <p><b>M5S-3</b>    <b>Mark V Soldering Pencil only (includes one tip)</b></p> <p><b>M5S-4</b>    <b>Mark V Soldering Tip only</b></p> |

## Disclaimer

ALL PRODUCTS, PRODUCT SPECIFICATIONS AND DATA ARE SUBJECT TO CHANGE WITHOUT NOTICE.

Vishay Precision Group, Inc., its affiliates, agents, and employees, and all persons acting on its or their behalf (collectively, "VPG"), disclaim any and all liability for any errors, inaccuracies or incompleteness contained herein or in any other disclosure relating to any product.

The product specifications do not expand or otherwise modify VPG's terms and conditions of purchase, including but not limited to, the warranty expressed therein.

VPG makes no warranty, representation or guarantee other than as set forth in the terms and conditions of purchase. **To the maximum extent permitted by applicable law, VPG disclaims (i) any and all liability arising out of the application or use of any product, (ii) any and all liability, including without limitation special, consequential or incidental damages, and (iii) any and all implied warranties, including warranties of fitness for particular purpose, non-infringement and merchantability.**

Information provided in datasheets and/or specifications may vary from actual results in different applications and performance may vary over time. Statements regarding the suitability of products for certain types of applications are based on VPG's knowledge of typical requirements that are often placed on VPG products. It is the customer's responsibility to validate that a particular product with the properties described in the product specification is suitable for use in a particular application. You should ensure you have the current version of the relevant information by contacting VPG prior to performing installation or use of the product, such as on our website at [vpgsensors.com](http://vpgsensors.com).

No license, express, implied, or otherwise, to any intellectual property rights is granted by this document, or by any conduct of VPG.

The products shown herein are not designed for use in life-saving or life-sustaining applications unless otherwise expressly indicated. Customers using or selling VPG products not expressly indicated for use in such applications do so entirely at their own risk and agree to fully indemnify VPG for any damages arising or resulting from such use or sale. Please contact authorized VPG personnel to obtain written terms and conditions regarding products designed for such applications.

Product names and markings noted herein may be trademarks of their respective owners.

Copyright Vishay Precision Group, Inc., 2014. All rights reserved.