

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-1 M-Flux AR Kit:

Two 1-oz [30-ml] brush-cap bottles M-Flux AR.
Two 1-oz [30-ml] brush-cap bottles M-LINE Rosin Solvent.

RSK-1 Rosin Solvent Kit:

Twelve 1-oz [30-ml] bottles M-LINE Rosin Solvent.

RSK-2 Rosin Solvent Bulk:

One quart (960-ml) bottle M-LINE Rosin Solvent.

RSK-4 Rosin Solvent Kit:

Four 1-oz [30-ml] bottles M-LINE Rosin Solvent.

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



A time-proven precision soldering instrument for miniature and/or delicate soldering applications. Full 25-watt rating in 17 selector positions to handle all M-LINE solder alloys except 1240-FPA. Magnetic solder pencil holder and flexible, burn-resistant cord. Lightweight soldering pencil (1.1 oz [31g]). Specify 115 or 220Vac, 50 or 60Hz operation.

M5S-1 Mark V Soldering Station,

Complete with A and B tips

M5S-2 Mark V Control Unit Only.

M5S-3 Mark V Soldering Pencil Only.

SOLDERING TIPS FOR MARK V

Types A, B, and C tips are pretinned, ironclad copper, over-plated with nickel/chromium to retard oxidation. Type D is nickel-plated copper, particularly suited to high-temperature soldering.

M5S-A Type A, general-purpose 1/16 in [1.5mm] screwdriver.

M5S-B Type B, miniature 1/16 in [1.5mm] chisel.

M5S-C Type C, heavy duty 1/8 in [3mm] screwdriver.

M5S-D Type D, high-temperature 3/32 in [2.5mm] chisel.

Note 1: Products shown in bold are RoHS compliant.

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