



**SURCLEAN**  
Electronic Production Materials



**SURCLEAN  
INDUSTRIAL**

## **TECHNICAL DATA SHEET**

### **Surclean - Tinmans No. 3 - Soft Solder Flux**

#### **PRODUCT APPLICATION**

Tinmans No.3 is a water based active flux for fast, economic soft soldering operations on Copper and its alloys. It is based on Zinc Chloride, plus additional salts for highly effective solder joint cleaning in a wide variety of trade and industrial applications. Residues are quickly and easily removed with water. It is a direct equivalent to Bakers fluid flux and similar products.

#### **CHARACTERISTICS**

**Highly reactive fluxing action** - Fast, effective and economic soft soldering of Copper and its alloys.

**Easy flux residue removal** - Residues are 100% water soluble and are quickly and easily washed away.

**Use with a variety of soft solder alloys** - Suitable for use with most common Tin/lead and Lead free soldering alloys.

#### **APPLICATION METHODS**

Surclean Tinmans No.3 can be applied by a number of methods, depending on the work piece. Brushing is most commonly used as it allows best control of the area of wetting. It can also be sprayed, or applied by immersion dipping of the assembly. Soldering should be carried out straight after flux application. As soon as heat is applied, the flux will start to activate, and the joint will be made as soon as the alloy melt point is reached. The flux is corrosive if left after soldering, and must be removed as soon as possible after the work has cooled down. Residues can be removed by washing with water, preferably warm, or for more thorough removal, with a 1% Hydrochloric Acid or Citric Acid wash, followed by a final water rinse.

#### **PACKAGING AVAILABILITY**

Surclean Tinmans No.3 is packed into plastic screw top containers. Standard pack sizes are 250 ml, 500 ml, 1 litre, 5 litre, and 10 litre containers. Other pack sizes can be supplied subject to availability.

#### **PHYSICAL & CHEMICAL PROPERTIES**

Appearance: Liquid.  
Odour: None.

Colour: Clear - colourless.  
Density: 1.23 at 20 deg. C.

PH Value: 1 (Acidic)  
Water solubility: 100%

#### **HEALTH & SAFETY**

Surclean Tinmans No.3 should be treated as a corrosive material. Take precautions to minimize risk of splashing or spillage. Use suitable eye and skin personal protection equipment. Read the application notes in this technical data sheet, and refer to the safety data sheet for the product.