TECHNICAL DATA SHEET

CATEGORY: WATER SOLUBLE LIQUID FLUX

PRODUCT: ST-501A

FEATURES
- WATER SOLUBLE
- EXCELLENT WETTING
- ENHANCED ACTIVITY LEVEL FOR STAINLESS STEEL
- WIDE PROCESS WINDOW

DESCRIPTION
ST-501A is a water-based, inorganically activated liquid flux designed to solder almost all grades of stainless steel. Though designed for application via a foam fluxer, ST-501A also may be applied by dipping or brushing. Since ST-501A is highly corrosive, all residues must be rinsed with water after soldering.

PHYSICAL PROPERTIES*

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<tr>
<th>SOLIDS CONTENT</th>
<th>FLUX DENSITY</th>
<th>ACID VALUE</th>
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<td>50%</td>
<td>1.25</td>
<td>340MG +/- 10% KOH/GRAM</td>
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HANDLING
- ST-501A has a sealed shelf life of one year. Do not freeze this product.
- ST-501A is shipped ready-to-use; no mixing is necessary.
- Do not mix used and unused chemical in the same container. Reseal any opened containers.

*Please be aware that these fluxes are toxic and cannot be shipped via UPS or FedEx under any circumstances in any quantity. These can only be shipped via truck freight and cannot be expedited.

FLUX APPLICATION
ST-501A can be used in dipping, spraying, brushing, swabbing, and many other fluxing operations. Flux pots should be plastic or titanium.

CLEANING
The residues and raw flux are completely water soluble and should be washed in an aqueous cleaning system using de-ionized or distilled water heated to a recommended temperature of 100-150°C.

SAFETY
- Use with adequate ventilation and proper personal protective equipment.
- Refer to the accompanying Material Safety Data Sheet for any specific emergency information.
- Do not dispose of any hazardous materials in non-approved containers.

The information contained herein is based on data considered accurate and is offered at no charge. Product information is based upon the assumption of proper handling and operating conditions. All information pertaining to solder paste is produced with 45-micron powder. Liability is expressly disclaimed for any loss or injury arising out of the use of this information or the use of any materials designated. Please refer to http://www.aimsolder.com/Home/TermsConditions.aspx to review AIM's terms and conditions.