



# SUPERIOR No. 1260



## ALUMINUM SOLDERING FLUX GEL

- A high activity flux designed for low temperature soldering of Aluminum and Aluminum alloys.
- Effective on joining Aluminum to most ferrous and non-ferrous alloys.
- Organic-based, chloride-free.

### DESCRIPTION

**Superior No. 1260** is a high activity, organic-based, chloride-free, viscous Aluminum soldering flux. Applications in which this flux should be used include: Aluminum-to-Aluminum, Aluminum-to-Copper, Aluminum-to-Brass, and Aluminum-to-plated terminals. This flux also performs well in hot dip coating of Aluminum cable connectors to provide a low-electrical resistance contact surface.

**Superior No. 1260** can also be utilized in joining Aluminum to difficult-to-solder metals like stainless steel, kovar, or nickel. The preferred solder is 91Sn/9Zn (Eutectic 199°C/390°F) and other tin/zinc alloys. This flux has also shown to work effectively with other tin-based solder alloys, such as SN100C and 99.3Sn/0.7Cu.

### DIRECTIONS

**Superior No. 1260** can be used with all conventional soldering techniques, including soldering iron, torch, furnace, and dip soldering. The soldering temperature must be monitored because the flux chars at 315°C/600°F, which will result in loss of fluxing action. Overheating should be avoided.

The post-solder residues of **Superior No. 1260** are conductive and mildly corrosive. Residues are water-soluble, and an aqueous cleaning process using hot water (60°C/140°F) is recommended as the primary cleaning method. In applications where water cannot be used, methyl or isopropyl alcohols can be used to remove post-solder residues.

### PHYSICAL PROPERTIES

Form	Viscous Liquid
Specific Gravity	1.30 +/-0.05 @ 20-25°C/68-77°F
Density	11.01 lbs./Gallon @ 20-25°C/68-77°F
Appearance	Clear, amber viscous liquid
Flashpoint	180°C/355°F Tag Closed Cup Method
pH/10.6% Solution	9.5 +/-0.5 @ 25°C @ 20-25°C/68-77°F
Recommended Soldering Range	177-288°C/350-550°F

**THIS PRODUCT IS RoHS COMPLIANT**

### SAFETY PRECAUTIONS

**Superior No. 1260** is mildly corrosive to steel and should be stored in sealed glass or plastic containers. Keep away from sparks, open flames, and heat sources. Avoid skin contact and/or breathing vapors. Use with adequate ventilation. Refer to material safety data sheet (MSDS) for additional information.

The certified shelf-life of this product is two (2) year if stored at room temperature.

*Superior manufactures quality fluxes. Our business is solving problems.*



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