

TALON

WATER SOLUBLE PASTE FLUX

TWF-SPEC

PRODUCT DESCRIPTION

PRODUCT

TALON Water Soluble Paste Flux

TYPE

TALON Water Soluble Paste Flux is a completely water soluble and flushable, acid free, lead free, self-cleaning flux that is suitable on all types of tin solder and their alloys. Its self-cleaning action will solder dissimilar metals and works excellent on older or tarnished copper without having to brush or sand the surface. Leaves no residue and will not transfer taste or odor in water coolers and potable water systems.

RECOMMENDED USES

Solder Flux for use with 95/5, 60/40, 50/50, 40/60 and Lead Free Solders on Copper, Lead Free Copper Alloys, Brass, Performance Bronze™ alloy*, Silicon Bronze, Galvanized Iron, Tin, Steel, Terne Plate, Zinc, Silver, Nickel and Sheet Lead.

COLOR/CONSISTENCY

White Paste

TEMPERATURE RANGE USE

Melting Temperature: 140°F (60°C)

Freezing Temperature: 14°F (-10°C)

Soldering Temperature Range:
200°F (93°C) to 600°F (315°C)

U.S. FEDERAL SPECIFICATION

Meets ASTM B-813 and the Copper Development Association (CDA) requirements.

ENVIRONMENTAL STATEMENT

TALON Water Soluble Flux is an all-weather flux that is non-fuming and lead free.

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APPLICATION PRECAUTIONS

Contains ZINC CHLORIDE and should be handled with care.

Refer to the SDS (Safety Data Sheet) for additional safety information.

PACKAGING

U.S. Measure:

<u>Stock Code</u>	<u>Size</u>
Screw Cap Plastic Jars	
TWF2	2 oz. (57 g)
TWF4	4 oz. (113.4 g)
TWF1	1 lb. (454 g)
Screw Cap Plastic Jar w/ Brush	
TWF8BT	8 oz. (226.8 g)

SHIPPING WEIGHT PER CASE

<u>Stock Code</u>	<u>Case Weight</u>	<u>#/Case</u>
TWF2	8 lbs. (3.6 kg)	36
TWF4	9 lbs. (4.1 kg)	24
TWF8BT	17 lbs. (7.7 kg)	24
TWF1	31 lbs. (14.1 kg)	24

WEIGHT PER U.S. GALLON

9.18 lbs. (4.2 kg) ± 0.02

SHELF LIFE

Two years

DIRECTIONS FOR USE

1. Remove any oil, grease, or other contaminants from the surface to be soldered.
2. Apply **TALON Water Soluble Paste Flux** to joint by swabbing or brushing to area being soldered.
3. Preheat or air-dry area to be soldered after flux has been applied to activate the **TALON Water Soluble Paste Flux** and yield optimum soldering characteristics and reduce or eliminate spattering.
4. Apply or feed solder wire to area being soldered.
5. Clean **TALON Water Soluble Paste Flux** residues from soldered area using a water rinse or by wiping off with a wet cloth.
6. Keep container closed when not in use.



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