Technical Bulletin

JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

JOHNSON'S ACTIVATED LIQUID ROSIN FLUX
Part No. 27-00 Series

DESCRIPTION:

Johnson's Activated Liquid Rosin Flux is a homogeneous solution made with electronic grade rosin with a blend of solvents chosen for high tolerance of their vapor concentration in air, plus of a small quantity of a control etching ingredient that dissolves the tarnish film of solderable metals, thus enhancing the natural activity of the rosin. Johnson's flux is characterized by its ability to remove even tenacious tarnish films, making it suitable for use in soldering electronic assemblies where post-soldering cleaning is either used, or not required, as well as electrical connections and even architectural copper or coated roofing metals. For most applications these flux residues need not be removed from the workpiece. Under normal conditions of usage they are non-conductive, non-corrosive, non-hygroscopic and resistant to fungus growth.

PHYSICAL DATA:

Specific Gravity	**.885 ± .002 @ (As Shipped)**
Percent Solids	**35.0 ± 2.0%**
Boiling Point	**78°C (174°F)**
Free Acidity	**None**
Flash Point (Open Cup)	**16°C (60°F)**

SPECIFICATIONS:

Johnson's Activated Liquid Rosin Flux conforms to the following government specifications: Mil-S-6872 - Neutral and Non-Corrosive; 41065 - Fungus Resistant; 111 R 626 R, WW Rosin; J-STD-004 - Rosin, Moderately Active with Halide (ROM 1)

USAGE:

Johnson's Activated Liquid Rosin Flux may be applied by any conventional means, such as brushing, rolling, spraying, etc. Metals successfully soldered included: Brass, Bronze, Copper, Nickel Plate, Silver, Terne Plate, Tin Plate, Tin-Zinc.

HANDLING:

This flux contains solvents that evaproate rapidly. If it becomes too viscous due to evaporation of this flux, it can be restored to its original fluidity using ethanol. Johnson's Activated Liquid Rosin Flux can also be thinned to any desired fluidity by the same method. Inhalation of flux vapors should be avoided. Soldering should be done in well-ventilated areas, as the by-products can be volatile and toxic. Read Johnson's *OSHA Material Safety Data Sheet* for additional information.