



# Technical Bulletin

JOHNSON MANUFACTURING COMPANY  
Princeton, Iowa 52768-0096

## JOHNSON'S WELL-BAKE CORE BAKING FLUX CONCENTRATE Part No. 28-14 Series

### DESCRIPTION:

Johnson's Well-Bake is a strong halide type baking flux for hard to bake radiator cores and for other baking applications where a vigorous flux is required. This flux contains zinc chloride to extend its active temperature range, yet it leaves little or no corrosive residue behind on the surface of the core after baking, when properly diluted.

### PHYSICAL DATA:

Specific Gravity	1.28 ± .005 @ 60° F (As Shipped)
pH	0-1
Solubility in Water	100%
Appearance	Red Liquid
Odor	Slight Organic Odor

### USAGE:

This flux is highly concentrated and has a pH of <2.0, even when diluted with ten (10) parts of clean water. At a dilution of 9:1 to 10: 1 Well-Bake is excellent for baking many different types of radiators, including cores with steel fins, or where one or more conditions are less than ideal.

### HANDLING:

This flux contains hydrobromic acid and zinc chloride. Store, mix and use in non-metallic containers only. Wear protective clothing and eye wear when handling this or any flux. Please refer to *OSHA Material Safety Data Sheet* for additional information.

### WASTE DISPOSAL:

This flux must be neutralized and/or treated before discharging into the sewer. Beyond this we cannot make specifications because local laws vary.



TO ORDER CALL (800) 747-0030, FOR SUPPORT CALL (563) 289-5123, TO SEND FAX (563) 289-3825, EMAIL TO [johnsonmfg@aol.com](mailto:johnsonmfg@aol.com)