Technical Bulletin
JOHNSON MANUFACTURING COMPANY
Princeton, Iowa 52768-0096

D-57 STAINLESS STEEL DIPPING FLUX
Part No. 04-00 Series

DESCRIPTION:

Johnson's D-57 Stainless Steel Dipping Flux is a highly concentrated flux for dip soldering all alloys of stainless steel, as well as most other difficult-to-solder metals, except aluminum, magnesium and titanium. This flux offers the aggressive cleaning of an acid, as well as the reduced spattering and extended temperature range that only a fully saturated flux can provide.

Other uses include tinning tough cast iron bearing shells prior to babbitting. This balanced chemical and acid formulation produces strong solder bonds that are bright and shiny. Johnson's D-57 works well with tin-lead solders like 30/70, 50/50 or 60/40, as well as high-lead solders like 5Sn/95 or Ag1.5, plus it works especially well with Pure Tin and most non-leaded solders.

PHYSICAL DATA:

Specific Gravity	**1.535 ± .005 @ 60° F (As Shipped)**
pH	**0-1**
Solubility in Water	**100%**
Appearance	**Clear, Amber Liquid**
Odor	**Sharp Acidic Odor**

USAGE:

This flux is generally used as shipped, however it may be diluted with water for certain applications. D-57 Stainless Steel Dipping Flux residues are corrosive and must be completely removed from the workpiece. Use hot water and a mild detergent to speed the removal process.

HANDLING:

Always wear protective clothing and eye wear when handling this flux. Please refer to the *OSHA Material Safety Data Sheet* for additional information. This flux contains, among other things, zinc chloride and free hydrochloric acid. Store, mix and use in non-metallic containers only.

WASTE DISPOSAL:

Johnson's D-57 Stainless Steel Dipping Flux must be neutralized before discharging into the sewer. Beyond this, we cannot make specific recommendations due to variations in local laws.