



# SUPERIOR NO. ACF-7



## SOLDER CORE FLUX FOR ALUMINUM

- Permits direct aluminum to copper and aluminum to aluminum connections
- Eliminates the need for plating aluminum before soldering
- Best results when soldering to 1XXX, 3XXX, and 6XXX series aluminum
- Good for soldering of aluminum to nickel and brass surfaces
- Good for soldering of aluminum to mild and stainless steel surfaces

### DESCRIPTION

**Superior Solder Core Flux ACF-7** is a water-soluble formulation designed as a core flux for solders doing direct aluminum to copper soldering. It also has excellent soldering characteristics for copper alloys and nickel-plated aluminum surfaces. It can be used as a solder core flux with many metals but is incompatible with zinc based solder alloys.

### APPLICATION

**Superior Solder Core Flux ACF-7** is made from chemistry typical to aluminum soldering fluxes with a unique binding system to survive the highly basic chemistry required for soft solder-like temperature soldering of aluminum. The **Superior Solder Core Flux ACF-7** must be heated to 100°C – 110°C to be injected with pressure (not just gravity fed) into a solder core. Lower or higher temperature than this range will result in the flux reacting and creating a very high viscosity product that cannot be put into a solder core. Controlling the injecting temperatures is key for successfully using this flux.

### DIRECTIONS

- ➊ Heat the **Superior Solder Core Flux ACF-7** to 100°C – 110°C.
- ➋ Inject the flux into the extruding core solder with pressure, gravity feeding the flux has been found to be ineffective.
- ➌ The core flux upon cooling will have a nearly solid consistency at room temperature, but the unsealed core can flow out over time because the exposed core flux is somewhat hygroscopic.

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



## PHYSICAL PROPERTIES

Recommended Soldering Range	280 - 380°C
Odor	Ammonia
Flash Point	None
Freezing Point	None

## CLEANING and STORAGE

**Superior Solder Core Flux ACF-7** is a completely water soluble solder flux core formulation. All equipment in contact with the solder core flux can be cleaned with water.

**Superior Solder Core Flux ACF-7** should be stored with consideration of the effect that storage conditions will have on the long term stability core flux:

- The flux should be maintained in a cool and dry location. Maximum temperature should not exceed 25°C.
- The **Superior Solder Core Flux ACF-7** is hygroscopic with exposure to atmosphere; the containers should be kept sealed immediately after drawing out material.
- If liquid collect on the top of the core flux material, this should be discarded before collecting the solid material below.
- A storage life of 1 year can be expected.
- Avoid direct sunlight.

## SAFETY PRECAUTIONS

**Superior Solder Core Flux ACF-7** attacks many metals to some extent. It is recommended that polyethylene, PVC or fiberglass reinforced polyester containers be used. Avoid skin contact and/or breathing vapors. Wear gloves and eye protection.

This product, during handling or use, may be hazardous to health or the environment. Read the Material Safety Data Sheet and warning label before using this product.

The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Superior Flux & Mfg. Co.'s control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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**Superior Flux  
& Mfg. Co.**

6615 Parkland Blvd. • Cleveland, OH 44139 • Phone: 440-349-3000 • Fax:  
440-349-3003 [www.superiorflux.com](http://www.superiorflux.com) • e-mail: [info@superiorflux.com](mailto:info@superiorflux.com)