

**FORCE  
INDUSTRIES  
DIVISION**

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## **PRODUCT INFORMATION**

### **AMCO 64**

(589)

#### **General Characteristics And Uses**

*AMCO 64* is a chloride free, high viscosity, organic based flux compounded for low-temperature soldering of aluminum and aluminum alloys. Applications for this general purpose liquid are aluminum to most ferrous and non-ferrous metals. It is also used in the joining of aluminum to other difficult to solder materials such as stainless steel, Alnico, Kovar, nickel etc. Preferred solders for use with the Amco 64 are 63Pb-34Sn-3Zn and 91Sn-9Zn. Applicable to all types of joining techniques including iron, flame, furnace and dip soldering.

#### **Physical Data**

- Clear, amber colored, viscous liquid
- Specific Gravity: 1.38 @ 70 °F
- Weight per gallon: 10.0 lbs
- pH 9.5 - 10.5

#### **Performance Criteria**

- Residue – non-corrosive, non-conductive. May be removed with warm water
- Operating temperature range: 350° F – 550° F. Do not exceed 600° F.
- Can be used as received or diluted up to 25% by weight using:
  - ethyl or methyl alcohol
  - distilled water for high-speed mechanized soldering process
- Prepared solution should be stored in sealed glass or plastic containers
- Rapid dispersion and surface reaction

#### **Storage and Handling**

- Shelf life – 1 year in unopened container stored at room temperature
- Keep from freezing
- Packaging: 10 pound jug  
50 pound jug  
550 pound drum

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