

# Technical Bulletin

## TSC SOLDER PAINT (LEADED / PURE TIN)

### DESCRIPTION

TSC Solder Paint is a uniform mixture of finely powdered solder and zinc chloride activated flux, having a creamy consistency, for pre-tinning and solder coating. It has been especially formulated to keep the heavy solder powder in suspension and to reduce the settlement of the metal powder and therefore making it easier to re stir and an aid to prolong its shelf life.

If the metal powder does settle to the bottom of the container, then this is easily reconstituted with light stirring.

### FEATURES & BENEFITS

- High activity flux
- Improved shelf life
- Ease of application
- Paint easily restirred

### ALLOY AVAILABILITY

Metal loading is 70% by weight. A choice of two alloy grades are available.

Grade	Melting or Solidus / Liquidus Temp °C	Uses
Leaded -Sn40 / Pb60	183 - 235	General sweating and tinning
Pure Tin	232	Hand tinning / Sweat soldering where lead free solder is essential

### APPLICATION METHODS

For tinning the article is brushed or sprayed with the Solder Paint and heated until the solder melts to form an adherent coating. For soldering, the joint members should be coated before assembly, thus correctly locating the solder in the joint. To complete the joint, heat is applied until sweating occurs.

The solder paint should be applied to the metal surfaces to be tinned or sweat soldered in the cold state. As with other zinc chloride based fluxes, the residues can be corrosive and in most applications it is appropriate to wash the tinned area to remove these residues.

### TECHNICAL SPECIFICATIONS

	<b>Specifications</b>
Appearance	Grey, slurry, creamy
Odour	Faint
Density @ 20C (g/ml)	4
PH	Acidic

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## HANDLING & STORAGE

36 month (from date of manufacture shelf life. Room temperature storage only. No refrigeration necessary. Do not allow to Freeze. Consult Pure Tin MSDS for additional handling procedures and precautions.

## PACKAGING

TSC Solder Paint is available in various container sizes: 125g, 500g and 2.5Kg.

## HEALTH & SAFETY

Materials containing Lead are subject to the Control of Lead at Work Regulation. Eye and skin protection must be used when handling or working with fluxes. Always wear safety goggles and suitable rubber gloves. Avoid breathing fumes evolved during soldering process by providing fume extraction or good ventilation. In case of contact, immediately flush eyes or skin with plenty of water for at least 15 minutes. Obtain medical attention. Use with adequate ventilation and proper personal protective equipment. Refer to the accompanying Safety Data Sheet for any specific emergency information. Do not dispose of any hazardous materials in non-approved containers.

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