

FLUX-N-SOL

SOLDER AND FLUX IN ONE:
FOR ALL TYPES OF
NON-PRECIOUS ALLOYS

The Research & Development Department has now taken all the guesswork out of soldering by combining flux and solder into one perfect prefluxed solder. No more guessing which flux to use or how much flux to use when soldering.

- :: Eliminates guesswork
- :: Fast and Accurate
- :: Less training time needed
- :: Readily available
- :: Less costly than individual quantities of flux and solder



IMPERIAL TRADING LTD.
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FLUX-N-SOL

combines in perfect proportion the exact flux
and solder necessary for a secure bond.

INSTRUCTIONS FOR USE

Preparation

The gap for soldering should be 0.2-0.5mm wide with parallel walls. All sharp corners should be rounded off. Use a matrix system of your choice, sticky wax and a bur, Duralay, Zap-It or a plaster key. Whatever material you use must be eliminated after investing!

Investing

Make a creamy mix using a phosphate casting investment mixed only with water and vibrate it into the abutments. Squeeze out the remaining mix onto a paper towel. Set the bridge on top, being careful not to cover the units. Leave as much metal exposed as possible, protecting the margins. Make a ditch "V" under the area(s) to be soldered for the flame to pass through. After bench setting, remove any remaining wax by placing the bridge in boiling water or lightly passing a flame over plastic material to soften and then remove.

Pre-Heating

When the unit has dried, place it into the burnout oven and heat to 900-1000°F (482-538°C) and hold for at least 15 minutes.

Soldering

Have everything ready for soldering: the soldering block or tri-pod, solder, hemostat, and torch with soldering tip. Remove the unit from the burnout furnace and lightly blast through the joints that will be soldered, to remove any debris and/or oxidation. A light blast of air should remove any dust. Touch the prefluxed solder to the still warm joint to leave a coating of flux. Light the torch, adjusting the flame and slowly heat the entire bridge slightly. In order to minimize oxidation, once the flame is directed to the joint, do not remove it from the joint area. Keeping the flame on one side, when the metal is an orange red, feed the solder from the opposite side. The metal itself must be hot enough to melt the solder as the solder will flow towards the heat. Once the solder fills the joint, pull the torch back slightly and continue heating until the solder become motionless. This will bring the flux to the surface, leaving a solid, porosity-free union.

Finishing

To remove any residual flux, place the units in a plastic container containing a hydrofluoric acid substitute (Strip-It, No-San, etc.) and ultrasonic for 5 to 10 minutes and then wash in distilled water in the ultrasonic cleaner for 5 minutes. Finish, blast, clean and degas per alloy instructions.

COMPOSITION

Ni	Cr	Fe	Si	B
75.0%	14.0%	4.0%	4.0%	3.0%

PROPERTIES

Flow Temperature	1970°F (1075°C)
Melting Range	1750°-1970°F (955-1075°C)
Density	8.9 g/cc