

# No Rez 65

Water-Base Flux for Cast-on-Strap  
Battery

## TYPICAL PROPERTIES

Specific gravity: 1.214  
Color: Straw to Amber  
pH of Concentrate: <1.0  
Acid Content: 40 %  
Boiling point of concentrate:  
>105C

## Description

Water-base flux Super concentrate, the No Rez soldering compound - No Rez 65, is used for joining lead alloys together or for fusing various metals with tin/lead solder. Water based as opposed to commonly used flammable solvent borne fluxes.

## Recommended Application

- 1 Use plastic (or impervious to acid) equipment when handling flux. Use a 5-gallon container to prepare a solution of flux for use.
- 2 Measure 1.25 liters of the flux concentrate (No Rez 65) and pour into a plastic container.
- 3 Measure and add 15 to 19 liters of preferably demineralized water to the container.
- 4 Mix thoroughly. Perform titration of a sample to determine the concentration. Adjust when necessary.

## ADJUSTING FLUX CONCENTRATE:

Normally, the change in the flux concentrate level is due to the evaporation of water from the solution. Use the following procedure to adjust the flux concentration in your reservoir. A. Obtain a reading of flux solution using either the titration method or a conductivity meter. The recommended reading on the meter should be 15, indicating 15 to 1 ratio of water to flux. B. For every one point below 15 on the meter, add 1.25 liters of water. C. Stir the solution after adjustment and take another meter reading to verify the desired ratio.