



Kapp Lunar™ Flux for Aluminum Soldering

Description

Kapp Lunar™ Flux is a white paste for the high temperature soldering of Aluminum and Zinc Diecast alloys. It is a reaction-type flux with 70% active ingredients dispersed in alcohol. The paste stays where it is applied to simplify the soldering process. **Kapp Lunar™ Flux** has considerable shelf life stability, as the suspending agents prevent separation and re-crystallization of the active ingredients. The performance of the paste in depositing Zinc on Aluminum and Diecast surfaces is also consistent over time.

Applications

- Higher temperature soldering of Aluminum and Zinc Diecast parts such as:
 - Automobile hardware
 - Marine parts such as propellers
- Works well on all common Aluminum and Zinc Diecast alloys
- Recommended soldering alloys:
 - Alumite™
 - KappAloy30™
 - Higher Zinc content KappAloy™ Tin-Zinc solders
 - KappLead50™ - 50% Tin (Sn) - 50% Lead (Pb) solder
 - Any alloy/application for Aluminum soldering which demands working temperature range of 550-800°F (288-427°C).
- **CAUTION: WHEN USED WITH ALUMINUM, TOXIC FUMES WILL BE GIVEN OFF. PLEASE READ AND UNDERSTAND THE PRECAUTIONS AND PROCEDURES ON THE [SAFETY DATA SHEET](#).**

Properties

The following chart represents the physical properties of **Kapp Lunar™ Flux**. Many factors, such as materials, temperature, and method of application determine the most effective flux. Call Kapp for engineering assistance to discuss your specific needs. We recommend testing appropriate fluxes in your specific application to ensure suitability.

Technical Data	
Active Temperature Range:	550-800°F (288-427°C)
Specific Gravity:	1.51 @ 73°F (22°C)
Appearance:	White paste with an alcohol odor
Solubility:	Soluble in ethyl alcohol
pH:	Alkaline
Corrosivity:	Mildly corrosive to Steel and soldered joints
Flash Point:	71°F (22°C) – TCC
Weight Per Gallon:	12.6 lb. (5.7 kg)
Shelf Life:	2 years unopened at ambient temp.
Packaging:	3 and 8 oz. jars

***Note: Flux is rated by D.O.T. as a Corrosive Hazard - Can Not be shipped by Air**

Product Variants

- 3 oz. jar
- 8 oz. jar