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**TECHNICAL SPECIFICATION**

**NO. 5  
LEAD FREE PASTE FLUX**



**TECHNICAL SPECIFICATION:** Oatey No. 5 Lead Free Paste Flux cleans and fluxes most commonly soldered metals including copper, brass, zinc, galvanized iron, lead and tin or copper-coated metals. Fluxing is a critical step in the soldering process. No. 5 Paste Flux provides superior wetting properties for better solder flow and can be used with most soft solders. No. 5 Paste Flux complies with CA & VT lead content regulations.



**PRECAUTIONS**

Read all cautions and directions carefully before using this product. Apply flux with brush- do not apply with fingers. Wash hands thoroughly after use and before eating. Wear safety glasses with side shields and rubber gloves. EYE AND SKIN IRRITANT. HARMFUL IF SWALLOWED. VAPOR MAY BE HARMFUL. Eye or skin contact may cause intense irritation and injury. In case of contact with eyes or skin, flush with water and seek medical attention immediately. If swallowed, DO NOT INDUCE VOMITING. Drink water and call physician or poison control center immediately. Ingestion of this product may cause gastrointestinal distress. If inhaled, get fresh air and seek medical attention if ill feelings persist. Keep container closed when not in use. DO NOT REUSE EMPTY CONTAINER. KEEP OUT OF REACH OF CHILDREN.

Refer to material safety data sheet for more information. For emergency first aid help, call 1-877-740-5015.

**PHYSICAL/CHEMICAL PROPERTIES**

Appearance	Amber Paste
Shelf Life	2 years from manufacture date
pH	3 - 4
Solder Temp. Range	400-700° F

**DIRECTIONS FOR USE**

Paste Fluxes require only a small amount of flux applied to the joint. Clean all surfaces before soldering. Apply small amount of flux inside the fitting and outside of the pipe. Heat to temperature required for soldering. Do not overheat the piping. For small diameter piping, direct the heat near the joint. For large diameter piping, move the heat around the joint to ensure adequate solder flow around the circumference of the joint. NOT FOR USE WITH ALUMINUM, STAINLESS STEEL OR MAGNESIUM. DO NOT USE ON ELECTRICAL PARTS.

When soldering process is complete, allow joint to cool undisturbed. Remove any flux residual with a damp cloth. Do not store No. 5 Paste Flux above 100° F.

**COMMON APPLICATIONS**

Oatey No. 5 Lead Free Paste Flux can be used to solder most commonly soldered metals including copper, brass, zinc, galvanized iron and tin or copper-coated metals.

Consult Oatey Technical Department for applications not specifically referenced above.

**INGREDIENTS**

Petrolatum (8009-03-8)  
Zinc Chloride (7646-85-7)  
Ammonium Chloride (12125-02-9)

**COMPLIANCE & LISTINGS**



NSF Listed  
to Standard 61



Lead Free Flux  
Complies to CA & VT  
lead legislation

PRODUCT NUMBER	DESCRIPTION	PACK	CARTON WEIGHT
30011	1.7 oz. No. 5 Paste Flux	12	2 lbs.
53017	1.7 oz. No. 5 Paste Flux with Brush – Display Carton	12	2 lbs.
53200	1.7 oz. No. 5 Paste Flux with Brush – Carded*	12	2 lbs.
30013	4 oz. No. 5 Paste Flux	24	7 lbs.
30038	8 oz. No. 5 Paste Flux	24	15 lbs.
30014	8 oz. No. 5 Paste Flux	24	15 lbs.
30041	16 oz. No. 5 Paste Flux	12	14 lbs.
30041D	16 oz. No. 5 Paste Flux – Display Carton	12	14 lbs.