



## Physical Properties

Appearance:	white
Flash point:	N/A
pH:	neutral
Odor:	slight
Density:	1.1 – 1.4 g/cm <sup>3</sup>
Viscosity:	1,000 – 17,000 mPas
Melting Range*:	565 – 572 °C

\*refers to NOCOLOK® Flux

\*Addition of CsAlF<sub>4</sub> or CsAlF complex will reduce melting range.

## Chemical Composition

NOCOLOK® Flux:	10 – 60%
Carrier:	Balance
CsAlF <sub>4</sub> :	optional
CsAlF complex:	optional
Li <sub>3</sub> AlF <sub>6</sub> :	optional
UV-active dyes:	optional
Colorants:	optional

NOCOLOK® Flux Pastes are available with an organic carrier system with VOC-free water carrier system or with an oil + polybutene carrier system.

NOCOLOK® 028/XX\*: pastes with organic carrier.

NOCOLOK® 028/XX\* FG: pastes with organic carrier and Fine Grade flux

NOCOLOK® S01 XX\*: pastes with advanced additive system and organic carrier.

NOCOLOK® S03 XX\*: pastes with advanced additive system and VOC-free water carrier.

NOCOLOK® K03 XX\*: pastes with fine grade flux and VOC-free water carrier.

NOCOLOK® ULTRA FLUX: pastes with an oil + polybutene carrier system.

\*XX means flux percentage

## Application

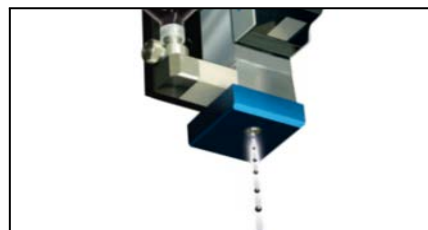
NOCOLOK® Flux Pastes are flux pastes specifically formulated for providing a viscous homogeneous mixture of NOCOLOK® Flux (10 – 60 %) in an organic or water carrier for brazing aluminium cladded interfaces.

Typical applications include but are not limited to interior tube seams (B-tubes), snap over joints (clinch tubes), tube-to-header joints, internal turbulators, or plate heat exchangers.

The paste can be dispensed manually by brush or syringe or with semi automatic or fully automatic dispensing equipment - volumetric pumps, spray nozzles, roll coating machines, jet application systems, various printing systems.

The pastes are available for both, furnace and flame braze process.

CsAlF<sub>4</sub> or CsAlF complex can be added to accommodate materials with Mg of up to approximately 0.6 % in furnace brazing and up to approximately 1.5% in flame brazing. This refers to the combined Mg-level of both components to be joined.



## Packaging

Filling weight 5 kg	
Height	194 mm
Diameter top	208 mm
Diameter bottom	184 mm
Pallet	400 kg, 120 x 80 x 115 cm



Filling weight 10 kg	
Height mm	260 mm
Diameter top	251 mm
Diameter bottom	230 mm
Pallet	480 kg, 120x80x130cm



Filling weight 20 kg	
Height	360 mm
Diameter top	299 mm
Diameter bottom	273 mm
Pallet	480 kg, 120 x 80 x 130cm

## Storage, Handling, Transport

Products are supplied as ready to use products, requiring premixing prior to usage.

Shelf Life: is defined on a label.

Storage and transport conditions: Keep containers tightly closed. Keep in a cool, well-ventilated place, away from heat and direct sunlight.

## Classification

Products are classified as hazardous according to the European regulation (EC) 1272/2008 (GHS)

Detailed information can be found in the relevant Safety Data Sheet (SDS).

## MANAGEMENT SYSTEM

DQS – certified according  
 ISO 9001 : 2015  
 ISO 14001 : 2015  
 ISO 50001 : 2018  
 ISO 45001 : 2018

NOCOLOK® is registered trademark of Solvay Fluor GmbH, Germany

## Solvay Flux GmbH

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# SOLVAY