

# **SOLDER-IT**

**FAST and EASY to apply with Match. Lighter,  
Soldering Iron or Torch.**

- Five times stronger than ordinary solder, tensile strength: 10,000 to 25,000 PSI.
- Flows freely and smoothly at 430°F. Provides strength without the distortion of high temperature brazing.
- Solders all metals.
- Better electrical conductivity, stress and vibration resistant.

## **How to use SOLDER-IT™**

1. Remove cap from nozzle.
2. Press plunger forward and paste will flow. Bead, strip or spot the **SOLDER-IT™** paste in an adequate amount to obtain a satisfactory joint.
3. Pull back slightly on plunger to stop the flow of paste.
4. Replace cap on nozzle.
5. Place the materials with **SOLDER-IT™** joint directly in the low temperature flames (do not place the **SOLDER-IT™** above the flame as this will tend to smoke or soot blacken the joint — place directly in the flame). If a torch is used, hold flame 2" to 3" from surface, evenly heating the work piece. Avoid playing flame on solder paste until flow temperature is reached, then with top of flame at joint area direct the flow of **SOLDER-IT™** paste the length of joint area. Allow to cool and wash flux residue off, using warm water and a stiff brush from the material and you have a superior silver finish solder joint or connection that will not blacken or tarnish. **NOTE:** Depending on thickness of metals to be soldered, use proper heating source to bring temperature up to 430°F. Not for use with Aluminum, Magnesium, or Pot Metal.

**SOLDER-IT™** should be stored at room temperature (78°F to 60°F or 25°C to 16°C). If stored in heat, material will thin and the flux and binder will tend to separate and a clear fluid will flow from the nozzle. If this occurs, cool the material to room temperature then stand the syringe upright with the plunger down and the nozzle upright. Take a thin wire and insert into the nozzle and push down to penetrate **SOLDER-IT™** material and allow the fluid to be absorbed by the paste. Replace the cap and leave the syringe in the upright position for approximately 10 minutes. The **SOLDER-IT™** should be ready to use. If the paste is difficult to apply from the nozzle, reinsert the thin wire, work in and out of the nozzle, two or three times, and the paste should flow with pressure and ease. If **SOLDER-IT™** is cold or frozen, bring the material to room temperature and use the same instructions as those used above for heat.

**CAUTION** Do not take internally. If taken internally, Do Not induce vomiting and call a physician. Avoid contact of paste with eyes or skin. If contact is made, wash or flush with water. Keep out of the reach of children. Soldering and brazing creates fumes which can be hazardous to your health. Use only in a well ventilated area or with ventilating equipment. Company warrants this material has been manufactured to its standard specification. Defects must be reported within 90 days. Responsibility or liability is limited to replacement of paste.