




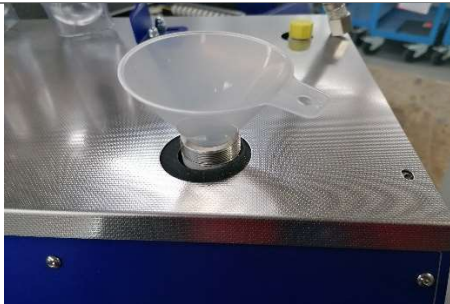


### Instructions for producing electrolyte, made of potassium hydroxide flakes

<b>CAUTION!</b>	<b>Read and observe the safety instructions before you work with electrolyte!</b>
  <p><b>GHS05</b>    <b>GHS07</b> Corrosion    Exclamation mark</p>  	<p>Electrolyte is a strong caustic solution! Risk of causticization on skin, mucous membranes and eyes!</p> <p>Risk of chemical burns of the mucous membrane caused by inhaling of vapours!</p> <p>Always wear protective gloves and goggles when handling electrolytes to prevent chemical burns! Do not inhale the vapours!</p> <p>Store open containers with electrolyte at a safe place and keep them out of reach of unauthorized persons, in particular of children.</p>

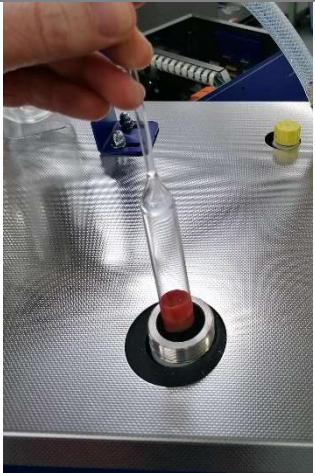
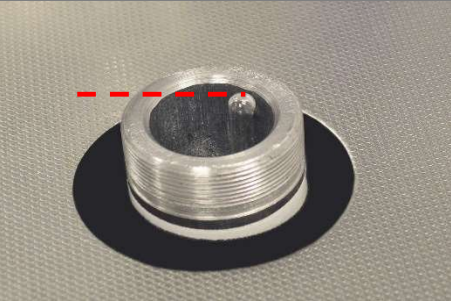
<b>How to produce electrolyte solution from solid potassium hydroxide (KOH)</b>		
<b>1. Production of electrolyte solution</b>	<p>Use the following substances only:</p> <ul style="list-style-type: none"> <li>Potassium hydroxide (cookies or flakes – without water): KOH quality: KOH may be contaminated by potassium carbonate at max. 1.5 %.</li> <li>Distilled water</li> </ul>	
<b>2. Required quantities of KOH and distilled water</b>	<b>microflame 80, microflame 140, Lötstar 80, Lötstar 141, Lötstar 145</b>	<b>microflame 170, microflame 240, microflame 300, Lötstar 175, Lötstar 176, Lötstar 241, Lötstar 245, Lötstar 301</b>
	815 g solid KOH + 1580 g = 1.58 liter distilled water	1855 g solid KOH + 3600 g = 3.6 liter distilled water

<b>3. How to procede</b>	<ol style="list-style-type: none"><li>1. Fill the required quantity of distilled water into a temperature-resistand and alkaline-resistant container.</li><li>2. Add the correctly measured quantity of potassium hydroxide carefully and slowly, keep stirring the mixture. <b>Caution!</b> The liquid may splash. Strong reactions due to self-heating and the forming of vapours are possible. Observe the safety warnings indicated above!</li><li>3. Keep stirring the liquid until the potassium hydroxide has completely dissolved.</li><li>4. Let the heated alkaline solution cool down before filling.</li></ol>
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<b>How to fill electrolyte solution</b>	
1. Unscrew the closing cap from the filling duct at the electrolyte reactor.	
2. Place the clean funnel (included in the delivery volume) onto the filling duct.	

Technical note 110: **Electrolyte made of potassium hydroxide flakes for MIG-O-MAT microflame/Lötstar series**



<p>3. Carefully pour approx. 4/5 of the electrolyte (total quantity see table in this section) into the filling duct of the reactor.</p>	
<p>4. Carefully insert the glass float into the filling duct of the reactor, with the thin end up.</p>	 A close-up photograph showing a person's hand holding a glass float with a red tip, carefully inserting it into a circular filling duct on a metallic surface. The float is partially submerged in a liquid.
<p>5. The tip of the float must be flush with the edge of the duct. If necessary refill liquid. The glass floating body must not stand out from the edge of the duct by more than 5 mm. <b>Caution!</b> In case of an overfilling there is a risk of damage to the unit. If the reactor has been overfilled the excess electrolyte must be removed from the reactor (for this carefully read and observe the relevant safety and procedure instructions in the operating manual!</p> <p>The glass float remains in the filling duct for future filling level checks.</p>	 A top-down view of the filling duct assembly. A glass float is visible inside the duct, with its red tip flush with the top edge. A horizontal red dashed line is drawn across the top of the duct to indicate the correct liquid level.
<p>6. Screw the closing cap back onto the filling duct and tighten it.</p>	
<p>7. The filling process is now finished.</p>	