

## Handy Flo<sup>®</sup> 753 DF 753

### ***GENERAL DESCRIPTION***

---

Handy Flo 753 is a non-corrosive flux system designed for use with aluminum brazing filler metals for joining of 1000, 3000, 6000 and some 5000 and 7000 series aluminum alloys in an open-air brazing processes. This product is non-corrosive and the flux residue does not need to be removed from the assembly following the brazing operation. If it is desired to remove the flux residue, a 50/50 mixture of nitric acid and distilled water will remove residue. Agitate the part in the solution for 30 seconds to remove all flux.

Handy Flo 753 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal. This product has been formulated to provide consistent dispensing features from either manual or automatic dispensing equipment. This flux system is recommended for use in an open air or torch heating applications.

The Handy Flo series are generally used in paste formulations containing braze filler metal, whereas DF 753 is a dispensable version of Handy Flo 753 distributed as flux formulation only without the braze filler metal content.

### ***PRODUCT APPLICATION***

---

Handy Flo 753 becomes fully molten and active by 1000°F (540°C). It is recommended for use with AL 713, AL 714, AL 716, and AL 718 braze filler metals.

### ***BRAZING CHARACTERISTICS***

---

Handy Flo 753 and DF 753 will exhibit good flow characteristics during the brazing operation. Handy Flo 753 and DF 753 leave behind some binder residue post-braze, along with flux residue. Both are non-corrosive, and do not have to be removed. Handy Flo 753 and DF 753 both exhibit some slight slump, and thus should be used with caution on vertical joints.

### ***WARRANTY & STORAGE***

---

Lucas-Milhaupt, Inc. warrants their Dispensable Flux products for 90 days from the date of shipment if stored in the original unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry. It is recommended that the dispensable flux products are stored away from direct heat. Dispensable fluxes may require mixing to regain a homogenous mixture before application.

The 90 day warranty should not be interpreted as the shelf or useful life of the product. Dispensable fluxes may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

### ***AVAILABLE PACKAGING***

---

Handy Flo and DF products are available in various size syringes, jars and cartridges. Dispensable flux may also be obtained in large containers prepackaged for immediate pneumatic dispensing operations.

### ***SPECIFICATIONS***

---

Handy Flo DF 753 conforms to the following specifications: N/A

# Technical Data Sheet

## ***WARRANTY CLAUSE***

---

Lucas-Milhaupt, Inc. believes the information contained herein to be reliable. However, the information is given by Lucas-Milhaupt, Inc. without charge and the user shall use such information at its own discretion and risk. This information is provided on an "AS IS" AND "AS AVAILABLE" basis and Lucas-Milhaupt, Inc. specifically disclaims warranties of any kind, either express or implied, including, but not limited to, warranties of title or implied warranties of merchantability or fitness for a particular purpose. No oral advice or written or electronically delivered information given by Lucas-Milhaupt, Inc. or any of its officers, directors, employees, or agents shall create any warranty. Lucas-Milhaupt, Inc. assumes no responsibility for results obtained or damages incurred from the use of such information in whole or in part.