

Technical Data Sheet

Handy Flo[®] 756 DF 756

GENERAL DESCRIPTION

Handy Flo 756 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 756 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 756 is a dispensable version of Handy Flo 756 distributed as flux formulation only without the braze filler metal content.

PRODUCT APPLICATION

Handy Flo 756 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 756 and DF 756 will exhibit good flow characteristics during the brazing operation. Handy Flo 756 and DF 756 leave behind some binder residue post-braze, along with flux residue. Both are non-corrosive, and do not have to be removed. Handy Flo 756 and DF 756 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 756 conforms to the following specifications: N/A

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WARRANTY CLAUSE

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