

# Technical Data Sheet

## Handy Flo<sup>®</sup> 760 DF 760

### ***GENERAL DESCRIPTION***

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Handy Flo 760 and DF 760 are non-corrosive flux systems designed for use with aluminum brazing filler metals for joining of 1000, 3000, 6000 and some 5000 and 7000 series aluminum alloys in 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 760 and DF 760 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal.

The Handy Flo series are generally used in paste formulations containing braze filler metal, but can be distributed as flux formulation only without the braze filler metal content.

### ***PRODUCT APPLICATION***

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Handy Flo 760 and DF 760 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***

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Handy Flo 760 and DF 760 will exhibit fast flow characteristics during the brazing operation. Handy Flo 760 and DF 760 leave behind no binder residue post-braze, with only flux residue present. Handy Flo 760 and DF 760 both exhibit restrictive slump characteristics, and thus can be used on vertical joints.

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

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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***

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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***

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Handy Flo DF 760 conforms to the following specifications: N/A

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## ***WARRANTY CLAUSE***

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