

## Handy Flo® 340

### ***GENERAL DESCRIPTION***

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Handy Flo 340 is a clean burning, fluxless binder system used in brazing of assemblies in dry atmospheres such as nitrogen, hydrogen, argon, dissociated ammonia and vacuum. This system, when blended with an appropriate filler metal, will form a paste that exhibits slump when heated. HF 340 can be dispensed through standard dispensing equipment.

### ***PRODUCT APPLICATION***

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Handy Flo 340 is recommended for use with high purity braze filler metals that flow above 1100°F (593°C) and can also be used for high temperature furnace braze alloys.

### ***BRAZING CHARACTERISTICS***

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Handy Flo 340 offers good adhesion to parts during assembly but will tend to slump on the parts during heating. The paste deposit will not spatter during the initial phases of heating process. This system dries slowly and will not flake off the parts prior to heating operation; this allows pre-pasting of assemblies several hours prior to brazing operation. Handy Flo 340 is exceptionally clean burning. There is no residue following the brazing process. This product is especially recommended for dry hydrogen (H<sub>2</sub>) atmosphere or vacuum.

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

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Lucas-Milhaupt, Inc. warrants their Brazing and Soldering Paste 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 paste products are stored away from direct heat. Paste 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. The paste products may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

### ***SPECIFICATIONS***

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Handy Flo 340 conforms to the following specifications: N/A

### ***APPLICABLE PRODUCT CODE(S)***

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The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-340.

### ***SAFETY INFORMATION***

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The operation and maintenance of brazing equipment or facility should conform to the provisions of American National Standard (ANSI) Z49.1, "Safety in Welding and Cutting". For more complete information, refer to the Material Safety Data Sheet for Handy Flo 340.

## ***WARRANTY CLAUSE***

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