

Handy Flo[®] 600

GENERAL DESCRIPTION

Handy Flo 600 is a clean burning fluxless binder system used in controlled atmosphere furnace brazing of ferrous, non-ferrous, and non-metallic substrates with conventional and active metal braze alloys. This system is recommended for use in dry atmospheres such as hydrogen, dissociated ammonia with a maximum dew point of -60°F or a vacuum with minimum vacuum level of 10⁻⁴ Torr. Nitrogen and hydrogen bearing atmospheres are not recommended for active metal brazing. Handy Flo 600 has been formulated for applications where spraying or brushing is required.

PRODUCT APPLICATION

Handy Flo 600 is recommended for use with high silver VTG braze filler metals (Silvaloy 721, Silvaloy 716), active braze alloys (AgCuTi, AgCuInTi), Copper (and CuSn) and Nickel based (BNi-2, BNi-5, BNi-6) brazing filler metals.

BRAZING CHARACTERISTICS

Handy Flo 600 is a slurry and will generally require preheating to keep the paste from running away from the joint; it dries to a hard coating when heated to 250°F (120°C) - 300°F (150°C) 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 600 is exceptionally clean burning and leaves minimal to no residues that are commonly observed with paste systems available elsewhere. This product is not for use with fluxes. The paste made with Handy Flo 600 cleans readily with mineral spirit type aliphatic hydrocarbon solvents.

WARRANTY & STORAGE

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.

AVAILABLE PACKAGING

Pastes are available in various size jars.

SPECIFICATIONS

Handy Flo 600 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-650

SAFETY INFORMATION

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 660.

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.