

Handy Flo[®] 826 DF 826

GENERAL DESCRIPTION

Handy Flo 826 is zinc chloride free flux developed for soldering of stainless steel, steel, copper, brass, nickel and plated base metals. This system is corrosive. The flux residue will need to be removed after soldering operation. Cleaning is easily accomplished with hot water, or mild soap and water rinse. Handy Flo 826 has been formulated for dispensing applications using automated dispensing equipment. This system is recommended for use in most soldering applications including torch and furnace.

The Handy Flo series are generally used in paste formulations containing braze filler metal, whereas DF 826 is a dispensable version of Handy Flo 826 distributed as flux formulations only without the braze filler metal content.

PRODUCT APPLICATION

Handy Flo 826 is recommended for use with solder filler metals that flow between 350°F - 500°F (177°C - 260°C). This product is recommended for use with many of the common Silvacrite[®] and 50/50, 60/40 alloy formulations which include silver-tin, tin-lead, or tin-antimony combinations. Handy Flo 826 has been used in various applications including the automotive industry.

BRAZING CHARACTERISTICS

Handy Flo 826 when blended with appropriate solder filler metal will produce satisfactory joints on most steels, brass, copper and plated assemblies. This product is corrosive and a post-braze cleaning or rinsing operation is required. The flux residue is easily dissolved in hot water at temperatures of 120°F (49°C) or higher.

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

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

SPECIFICATIONS

Handy Flo 826 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-826.

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 826/DF 826.

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.