

Handy Flo® 881 DF 881

GENERAL DESCRIPTION

Handy Flo DF 881 is a rosin-free, mildly activated flux developed for soldering of copper, brass, nickel and plated base metals. This system is halide-free. The flux residue should be removed following soldering operation, which can easily be accomplished with a hot water, or mild soap and water rinse. Handy Flo DF 881 has been formulated for dispensing applications using automated dispensing equipment. This system is recommended for use in most soldering applications including torch and furnace.

PRODUCT APPLICATION

Handy Flo DF 881 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 Silvacore® and 50/50, 60/40 alloy formulations which include silver-tin, tin-lead, or tin-antimony combinations. Handy Flo DF 881 has been used in various applications including automotive and electrical/electronic industries.

BRAZING CHARACTERISTICS

Handy Flo DF 881 when blended with appropriate solder filler metal will produce satisfactory joints on brass, copper and plated assemblies. This system will slump during the initial phases of heating operation thus the flux deposit should be applied slightly above the joint on vertical assemblies. Handy Flo DF 881 is semi-restrictive while in molten stage.

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. Paste may also be obtained in large containers prepackaged for immediate pneumatic dispensing operations.

SPECIFICATIONS

Handy Flo DF 881 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-881.

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 881/DF 881.

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.