

Handy Flux® 1166A - BM Dry

GENERAL DESCRIPTION

Handy Flux 1166A - BM Dry is a boron modified, moderate fluidity general purpose fluxing system. When used with appropriate silver bearing braze filler metal, Handy Flux 1166A - BM Dry will provide sufficient fluxing action to join most ferrous and non-ferrous metals providing high strength and hermetically sealed joints. This system is recommended over Handy Flux 1166A Dry when brazing 3XX stainless steels, long heating cycles are used, or large assemblies are brazed.

This system is recommended for use in most brazing applications including torch, induction, resistance and air furnace heating methods. Handy Flux 1166A - BM Dry is not recommended for use in a vacuum or controlled atmosphere furnace brazing operations. This product is an active flux system with a life at temperature similar in comparison to other available low temperature flux systems.

PRODUCT APPLICATION

Handy Flux 1166A - BM Dry is recommended for use with braze filler metals that flow between 1100°F - 1600°F (600°C - 815°C). This product is recommended for use with many of the common Silvaloy® formulations which include silver, copper, zinc and tin or nickel, and Easy-Flo® alloy formulations which include silver, copper, zinc and cadmium. 1166A -BM Dry has been used in various applications including electronic/electrical, automotive, plumbing, and construction industries.

BRAZING CHARACTERISTICS

Handy Flux 1166A - BM Dry 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 (50°C) or higher.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Dry Fluxes for twelve months 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 with a relative humidity of 50% or lower. It is not uncommon for the dry flux constituents to aggregate overtime. This has, however, not shown to affect the performance of the dry flux products.

Twelve months should not be interpreted as the shelf or useful life of the product unless actual test results indicate unsatisfactory performance for the intended application.

AVAILABLE PACKAGING

Handy Flux 1166A - BM Dry available in package sizes depending upon particular customer requirements.

SPECIFICATIONS

Handy Flux 1166A - BM Dry conforms to the following specifications:

- American Welding Society (AWS) A5.31/A5.31M FB3-F

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-117

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 Flux 1166A BM Dry.

WARRANTY CLAUSE

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