

Handy Flux® Hot Rod

GENERAL DESCRIPTION

Handy Flux Hot Rod is an active fluoride-type flux in the form of powder which begins to melt and dissolve oxides at 600°F (320°C). Fully molten at 1100°F (600°C), it provides excellent protection of parts up to 1600°F (870°C).

PRODUCT APPLICATION

Handy Flux Hot Rod is primarily used as a “Hot Rod Flux” where the braze rod is heated to a temperature of 400°F - 800°F and dipped into the dry powder flux. The flux adheres readily to the braze rod leaving a smooth uniform coating. Thicker coatings of flux can be achieved by additional heating and dipping. Handy Flux Hot Rod is ideally suited for high production/assembly line applications where the braze rod can quickly be dipped after each braze joint. By maintaining a predetermined depth of flux, the coating can be used as a marker assisting the brazer in feeding a consistent length of braze rod and flux into the joint. Handy Flux Hot Rod has also found a place in the refrigeration industry where eliminating flux residue within the closed loop refrigeration system is critical. Using the “hot rod” technique the flux and alloy are introduced externally minimizing flux residue within the refrigeration system.

Additional benefits of Handy Flux Hot Rod include non-clumping formulation even in humid conditions, reduced flux consumption compared to water-based fluxes where flux is lost due to spatter and run off, reduced flux consumption may also minimize wastewater treatment. Handy Flux Hot Rod is also stable when stored in areas of temperature extremes such as a utility vehicle where a water-based flux may freeze, dried out or become “gritty”. If a paste type flux is preferred, Handy Flux Hot Rod may be thinned with water to a smooth uniform consistency for brushing or dipping. If a fast drying flux is preferred, or if water vapor is objectionable such as with furnace applications, Handy Flux Hot Rod may be thinned with isopropyl alcohol.

POST CLEANING

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 (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 Hot Rod is available in a variety of packaging options including 1/2 lb, 1 lb, 5 lb, 25 lb and 50 lb containers.

SPECIFICATIONS

Handy Flux Hot Rod conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-088.

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 Hot Rod.

WARRANTY CLAUSE

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