

PB-HT1

(Handy Flux FB Dry, LM FB Dry)

GENERAL DESCRIPTION

PB-HT1 is a high fluidity general purpose fluxing system. When used with appropriate silver bearing braze filler metal, PB-HT1 will provide sufficient fluxing action to join most ferrous and non-ferrous metals providing high strength and hermetically sealed joints.

This system is recommended for use in most brazing applications including torch, induction, resistance and air furnace heating methods. PB-HT1 is not recommended for use in a vacuum or controlled atmosphere furnace brazing operations. This product is more active but has a shorter life at temperature in comparison to other available low temperature flux systems and is generally recommended for brazing of small sized assemblies with fast heating cycles.

PRODUCT APPLICATION

PB-HT1 is recommended for use with braze filler metals that flow between 1100°F - 1500°F (600°C - 815°C). This product is recommended for carbide applications such as drill bits, to assist in cleaning braze flux as well as a chilling agent post-braze.

BRAZING CHARACTERISTICS

PB-HT1 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

PB-HT1 available in package sizes depending upon particular customer requirements.

SPECIFICATIONS

PB-HT1 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-151

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 PB-HT1.

WARRANTY CLAUSE

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