

## X6630

### **GENERAL DESCRIPTION**

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X6630 is a clean burning fluxless binder systems used in controlled atmosphere furnace brazing of steel, stainless steel assemblies. This system is recommended for use in dry atmospheres such as nitrogen, hydrogen, dissociated ammonia and vacuum with minimum vacuum level of  $10^{-4}$  Torr. X6630 is recommended for use in dry atmosphere settings i.e. -40°F to -60°F. X6630 has been formulated for dispensing applications using automated dispensing equipment.

### **PRODUCT APPLICATION**

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X6630 is recommended for use with braze filler metals that flow above 1700°F (927°C) and include: pure copper, nickel base alloys, bronze alloys, copper-nickel alloys and copper/cuprous oxide.

### **BRAZING CHARACTERISTICS**

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X6630 offers excellent vertical slump characteristic. The paste deposit will remain in place and will not spatter during the initial stages of the heating process. X6630 dries slowly and will not flake off the parts prior to heating operation; this allows pre-pasting of assemblies several hours prior to brazing operation. X6630 is exceptionally clean burning.

### **WARRANTY & STORAGE**

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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**

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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**

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X6630 conforms to the following specifications: N/A

### **APPLICABLE PRODUCT CODE(S)**

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The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 84-393.

### **SAFETY INFORMATION**

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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 X6630

## ***WARRANTY CLAUSE***

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