

Handy Flo[®] 801 DF 801

GENERAL DESCRIPTION

Handy Flo 801 is an intermediate flux which, when active, becomes very fluid and enables solder alloys to fill joints in large assemblies. Ideal for soldering copper, brass, steel and plated surfaces, this flux residue is corrosive, and will need to be removed after soldering operation. Cleaning is easily accomplished with hot water, or mild soap and water rinse. Handy Flo 801 has been formulated for dispensing applications using automated dispensing equipment. This system is recommended for use in most soldering applications including torch, induction and furnace. Handy Flo 801 exhibits semi-restrictive properties during the initial phase of heating (flux should be applied slightly above the joint on vertical assemblies) but is very fluid when molten.

The Handy Flo series are generally used in paste formulations containing braze filler metal, whereas DF 801 is a dispensable version of Handy Flo 801 distributed as flux formulations only without the braze filler metal content.

PRODUCT APPLICATION

Handy Flo 801 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 Silvacrite[®] and 50/50, 60/40 alloy formulations which include silver-tin, tin-lead, or tin-antimony combinations. Handy Flo 801 has been used in various applications including the automotive industry.

BRAZING CHARACTERISTICS

Handy Flo 801 when blended with appropriate solder filler metal will produce satisfactory joints on most steels, brass, copper and plated assemblies. This product is not recommended for soldering of stainless steel components. 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 (49°C) or higher.

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 801 conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-801.

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 801/DF 801.

WARRANTY CLAUSE

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