

CX-60

GENERAL DESCRIPTION

CX-60 is a non-corrosive flux slurry designed for use with aluminum brazing filler metals for joining of 1000, 3000, 6000 and some 5000 and 7000 series aluminum alloys in an open air brazing processes. This flux slurry consists of an exclusive combination of fluorides and a binder system. This product is non-corrosive and the flux residue does not need to be removed from the assembly following the brazing operation.

CX-60 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal. This flux system is recommended for use in an open air or torch heating applications.

PRODUCT APPLICATION

CX-60 becomes fully molten and active by 810°F (432°C). It is recommended for use with the lower temperature Aluminum Brazing Alloys; AL 802 and AL 822.

POST CLEANING

CX-60 is a non-corrosive flux and requires no post braze cleaning operation; however, if it is desired to remove the residue, a 50/50 mixture of nitric acid and distilled water will suffice. Agitate the part in the solution for 30 seconds to remove all flux.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their slurry 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 and slurry products are stored away from direct heat. Dispensable fluxes and slurries 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 and slurries may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

CX-60 flux is available in a variety of packaging containers.

SPECIFICATIONS

CX-60 flux conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-761.

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 CX-60.

WARRANTY CLAUSE

Lucas-Milhaupt, Inc. believes the information contained herein to be reliable. However, the information is given by Lucas-Milhaupt, Inc. without charge and the user shall use such information at its own discretion and risk. This information is provided on an "AS IS" AND "AS AVAILABLE" basis and Lucas-Milhaupt, Inc. specifically disclaims warranties of any kind, either express or implied, including, but not limited to, warranties of title or implied warranties of merchantability or fitness for a particular purpose. No oral advice or written or electronically delivered information given by Lucas-Milhaupt, Inc. or any of its officers, directors, employees, or agents shall create any warranty. Lucas-Milhaupt, Inc. assumes no responsibility for results obtained or damages incurred from the use of such information in whole or in part.