

## Handy Flo® 732 DF 732

### ***GENERAL DESCRIPTION***

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Handy Flo 732 is an aggressive, water soluble, homogenous mixture of different alkali chlorides and fluorides 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 product is corrosive and the flux residue must be removed from the assembly following the brazing operation.

Handy Flo 732 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal.

Some of the performance advantages of Handy Flo 732 include:

- Low to no spatter characteristics
- Reduced flux consumption through controlled application of the product
- Proper post braze cleaning or rinsing with water will eliminate acid post clean-up procedures
- Equipment and utensils can be cleaned with water - no solvent cleaning necessary

### ***PRODUCT APPLICATION***

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Handy Flo 732 becomes fully molten and active by 970°F (521°C). It is recommended for use with AL 716 (American Welding Society (AWS) A5.8/A5.8M BAlSi-3) and AL 718 (AWS A5.8/A5.8M BAlSi-4) braze filler metals in any form.

This flux system is recommended for use in an open air or torch heating applications. It does not require drying prior to brazing and will remain in place and not flake off or blow off the assemblies during the heating cycle of the brazing process. Handy Flo 732 may be thinned with deionized or distilled water. If stored for a long period of time some separation within the flux may occur. In such case stir the flux up until proper consistency is restored.

Paste may be applied by brushing or pneumatic dispensing through syringes. Syringes must be loaded on site prior to use.

The Handy Flo DF 732 is available as dispensable flux formulation only.

### ***BRAZING CHARACTERISTICS***

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Handy Flo 732 will exhibit restrictive slump characteristics and can be used on vertical joints. These products are corrosive and a post-braze cleaning or rinsing operation is required.

### ***WARRANTY & STORAGE***

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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***

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Handy Flo 732 products are available in 1 to 10 lb containers.

## ***SPECIFICATIONS***

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Handy Flo 732 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: 83-732, 82-102 (X6346).

## ***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 Handy Flo 732/DF 732.

## ***WARRANTY CLAUSE***

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