

## Handy Flo<sup>®</sup> 740

### ***GENERAL DESCRIPTION***

---

Handy Flo 740 system is a mixture of powdered aluminum silicon filler metal and fluoride salts for use in molten salt bath dip brazing operation. This product has been formulated to provide consistent dispensing features from either manual or automatic dispensing equipment.

### ***PRODUCT APPLICATION***

---

This system is especially useful in brazing of irregular and complex shapes. Handy Flo 740 is typically offered in a paste form containing American Welding Society (AWS) A5.8/A5.8M BAlSi-4 braze filler metal.

### ***BRAZING CHARACTERISTICS***

---

Handy Flo 740 paste system will exhibit excellent adhesive and flow characteristics during the brazing operation. Typical, application involves pre-drying of the braze assembly including paste deposit followed by salt bath dip brazing. The pre-heating ensures the removal of all moisture and brings the entire braze assembly to a temperature high enough to avoid thermal shock once assembly is introduced to the salt bath. Both the braze assembly including fixturing can be heated up 900 - 1000° F (482°C - 538°C). The pre-heat operation can take place in an electrically heated oven. The pre-heat time should be kept to minimum and will depend on the size of the braze assembly. The final assembly should be air cooled after dip braze operation. The paste residue can be cleaned off with water or other commercially available products used to remove salt residue generated during the dip brazing operation.

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

---

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***

---

Handy Flo products are available in various size jars and cartridges.

### ***SPECIFICATIONS***

---

Handy Flo 740 conforms to the following specifications: N/A

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

---

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 83-740.

### ***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 740.

## ***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.