

## Handy Flo® 751 DF 751

### ***GENERAL DESCRIPTION***

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Handy Flo 751 is a non-corrosive flux system 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 dispensable flux consists of an exclusive combination of fluoride compounds only. This product is non-corrosive and the flux residue does not need to be removed from the assembly following the brazing operation.

Handy Flo 751 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal. This product has been formulated to provide consistent dispensing features from either manual or automatic dispensing equipment. This flux system is recommended for use in an open air or torch heating applications.

The Handy Flo series are generally used in paste formulations containing braze filler metal, whereas DF 751 is a dispensable version of Handy Flo 751 distributed as flux formulation only without the braze filler metal content.

### ***PRODUCT APPLICATION***

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Handy Flo 751 becomes fully molten and active by 900°F (482°C). It is recommended for use with AL 716 (American Welding Society (AWS) A5.8/A5.8M BA1Si-3), AL 718 (AWS A5.8/A5.8M BA1Si-4) and AL 719 braze filler metals in a ring or wire form.

### ***BRAZING CHARACTERISTICS***

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Handy Flo 751 and DF 751 will exhibit fast flow characteristics during the brazing operation.

### ***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 and DF products are available in various size syringes, jars and cartridges. Dispensable flux may also be obtained in large containers prepackaged for immediate pneumatic dispensing operations.

### ***SPECIFICATIONS***

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Handy Flo DF 751 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: 83-751.

## ***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 751/DF 751.

## ***WARRANTY CLAUSE***

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