

Handy Flux[®] TEC

GENERAL DESCRIPTION

Handy Flux TEC is a liquid active zinc chloride flux which has been specially formulated for use with Easy-Flo[®] 053 (TEC) high temperature soft solder alloy.

PRODUCT APPLICATION

Handy Flux TEC is primarily used as a general purpose brazing flux in brazing applications involving joining of steel, stainless steel, copper, copper alloys, nickel, and nickel alloys. It is not recommended to use in aluminum bronze or other aluminum alloy brazing applications.

POST CLEANING

This product is corrosive and a special post soldering cleaning or rinsing operation is required. Water rinse is not adequate for removal of this flux. The following is a recommended practice for removal of TEC flux residue:

- a. Hot water rinse
- b. 5% phosphoric warm bath or 2% hydrochloric warm bath rinse
- c. Hot water rinse
- d. Neutralizing with baking soda or soda ash
- e. Hot water rinse

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Water Based Fluxes for twelve months 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), cool and dry.

Twelve months should not be interpreted as the shelf or useful life of the product unless actual test results indicate unsatisfactory performance for the intended application. Flux beyond the warranty may be reconstituted to a working consistency by warming in a water bath and or by additions of distilled or de-ionized warm water.

Flux may require mixing, dilution or warming to regain its normal consistency prior to use. Flux, when placed on a U.S. standard 40 mesh (425 micron) sieve conforming to ASTM E11 and worked lightly with a brush shall pass completely through the sieve. If the flux has partially coagulated in the container, the flux may, before conducting the test, be warmed in a water bath until it has returned to its normal consistency.

AVAILABLE PACKAGING

Handy Flux TEC is available in a variety of packaging options including pint, quart, and gallon containers.

SPECIFICATIONS

Handy Flux TEC conforms to the following specifications: N/A

APPLICABLE PRODUCT CODE(S)

The applicable Lucas-Milhaupt product code(s) for this technical data sheet: 82-059.

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 Flux TEC.

WARRANTY CLAUSE

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