

FORCE INDUSTRIES DIVISION

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PRODUCT INFORMATION

AMCO 105 ALUMINUM BRAZING FLUX

(585)

GENERAL CHARACTERISTICS AND USES

AMCO 105 is a brazing flux developed by ALCOA for all types of brazeable aluminum alloys. It is a specially compounded low-staining furnace brazing flux with greater activity.

PHYSICAL DATA

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| Appearance: | White powder |
| Particle size: | min 80% mesh |
| Melting range: | 1025 - 1065°F |
| Brazing range: | 1060 - 1140°F |

APPLICATION

AMCO 105 is normally mixed with distilled or deionized water to form a 50-75% by weight slurry. Flux mixtures should be held in rubber, plastic, glass or porcelain containers to avoid contamination of the flux. Aluminum parts to be brazed can be immersed into the flux slurry or the flux can be sprayed or brushed onto the assembly.

Brazing with AMCO 105 flux can be accomplished using several methods of furnace heating. These include electrical resistance, forced air circulation, radiant tube, infrared or controlled atmosphere furnaces. For consistent results, furnaces should have the ability to maintain temperature within a $\pm 5^\circ\text{F}$ range. Normal furnace operating temperature range should be between 1065-1190°F, depending on the alloy being brazed.

RESIDUE

Flux will promote corrosive attack if residue is left on brazed aluminum assemblies. Good brazing practices dictate that all flux residue be removed from brazed parts. The residue of AMCO 105 is easily removed by water.

STORAGE AND HANDLING. Store in sealed airtight container until used and when not in use.

AMCO 105 flux is manufactured in a closely controlled, low-humidity environment. The dry powdered flux is hygroscopic. It will absorb moisture and cake into hard lumps if exposed to ambient air for extended periods. The flux container should be kept sealed until used and when not in use.

Caution. Brazing may generate toxic fumes. Brazing should only be done in a place where any fumes generated can be exhausted.

PACKAGING

35 pound pail and 150 pound drum

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