

**FORCE
INDUSTRIES
DIVISION**

American Solder & Flux Co., Inc. • 28 Industrial Boulevard • Paoli, PA 19301-0947 • (800) 647-3575 • FAX (800) 647-2375

PRODUCT INFORMATION

AMCO 4690

(567)

ALUMINUM BRAZING FLUX

GENERAL CHARACTERISTICS & USES

AMCO 4690 is an aluminum brazing flux formulated from various alkali chlorides and fluoride. When used on brazeable aluminum, the flux displaces the oxide layer and protects the metal from oxidation. It lowers the metal's surface tension and enhances the wetting of the surface by the filler alloy.

PROPERTIES

Form	White, fine powder.
Odor	None
Bulk Density:	136 lbs. cu.ft.
Working Temp.	1180-1250
Solubility in Water:	Moderate
Effects of Exposure to:	
Air	None
Water	None, but absorbs moisture from air
Strong Oxidizers	None
Heat and Fire	Metal halide fume
Corrosivity	Corrosive to steel, brazed joints and surrounding metal
Recommended Filler Metal:	BA1Si

APPLICATION

AMCO 4690 is best applied as a slurry. To make the slurry mix 3 parts flux with 2 part water. Use of non-metal tools and container, such as plastic is recommended. Apply the flux to the cleaned aluminum surface by brushing or via a dispenser on to the area to be brazed.

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

STORAGE AND HANDLING

Store in a sealed watertight container. Specks of dirt or metal in the flux may cause pin holes in brazed joints.

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