

**FORCE
INDUSTRIES
DIVISION**

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PRODUCT INFORMATION

**AMCO 300
ALUMINUM BRAZING FLUX**

(586)

GENERAL CHARACTERISTICS & USES: AMCO 300 consists of inorganic chlorides and fluorides, and is a high activity, low staining flux for furnace brazing of aluminum in the 3000, 5000 and 6000 series. It is particularly suited to low moisture atmosphere brazing using 713 or 718 filler alloys.

PHYSICAL DATA

Color	White powder
Density, bulk	43.9 lbs/ft ³
Melting range	920 - 1020 °F
Brazing Temperature Range:	1080-1140 °F

APPLICATION: AMCO 300 is normally used as a 70-75% slurry of distilled or deionized water. A 5% slurry can be used for controlled atmosphere brazing. Flux mixtures should be held in non-metal containers to avoid contamination. Aluminum parts to be brazed can be immersed into the flux slurry or the flux can be sprayed or brushed onto the assembly.

Furnace brazing with AMCO 300 can be accomplished in electrical resistance, forced air, radiant tube, infrared or controlled temperature furnaces. For consistent results, the temperature should be held closely to within +/- 5°F. Normal brazing temperature should be maintained 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 300 is easily removed by water.

PACKAGING: 35 lb bags, 50 lb pails, and 150 pound drums.

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 sealed airtight container until used and when not in use.

While we believe the information presented herein is accurate and reliable, it should not be taken as a guarantee or representation of any kind for which the company assumes legal responsibility. They are offered solely for your consideration investigation and verification.