

**FORCE  
INDUSTRIES  
DIVISION**

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**PRODUCT INFORMATION**

**AMCO 105-20**

(806)

**DISPENSABLE ALUMINUM BRAZING FLUX - Non staining. Contains no zinc chloride or potassium fluoride. The safest chloride based aluminum brazing flux available with exceptional brazing performance.**

**GENERAL CHARACTERISTIC AND USES**

**Amco 105-20** is a dispensable aluminum brazing flux formulated from AMCO 5137 that are least hazardous alkali chlorides and safe cryolite. When used on brazeable aluminum, it removes oxides, protects surfaces, and provides wetting in the joint area by the filler metal alloy, producing excellent fill in properly gapped shallow deep joints. The product conforms to AMS 3412D.

This flux represents the safest chloride based brazing fluxes available, containing no corrosive zinc chloride, toxic potassium fluoride, or other strong fluorides. It does not stain brazeable aluminum, but breakdown under heat as readily as the high concentration zinc chloride type aluminum brazing fluxes.

**PHYSICAL DATA**

<	Form:	White slurry to paste
<	Odor:	None
<	Specific gravity:	1.60 - 1.66 @ 72°F
<	Working Temp:	1150 - 1250 °F
<	Solubility in water:	Partial - with excellent after braze residue water removal

**APPLICATION**

- < Using dispensing machine, or apply manually with brush or stick.
- < Heat source: Torch, Furnace, or induction
- < Recommended Filler Metal: BAISi
- < Working range: 1150 - 1250 °F
- < **Caution:** Brazing may generate toxic fumes. Brazing should only be done in a place where any fumes generated can be exhausted

**RESIDUE**

- < Residue easily removed with water while the joint is hot.

**STORAGE AND HANDLING**

- < Store in sealed watertight container. Specks of dirt or metal in the flux may cause pinholes in brazed joints.

**PACKAGING**

- < 10 pound, 20 pound, 35 pound and 50 pound containers

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