

Technical Data Sheet BrazeTec CSF 600 TD

Solvent based brazing paste

BrazeTec CSF 600 TD is especially developed for the copper-brass radiator brazing process (CuproBraze). It is especially designed for application on the fin tips with special equipment. The binder system is solvent based and ensures fast drying, good adhesion and a residue free burnout under protective atmosphere.

Standard

BrazeTec Standard CPO 600 (OKC 600, Patent US 5 378 294)

Nominal composition [wt.-%]

Permitted impurities max. [wt.-%]

Cu Rem.; Sn 15.6; P 5.3; Ni 4.2

Al 0.010; Bi 0.030; Cd 0.010; O 0.050; Pb 0.025;

Zn 0.050; Zn + Cd 0.050

Technical data

Melting range of brazing alloy

approx. 590 - 610 °C

Working temperature

approx. 650 °C

Metal content

> 85 wt.-%

Density of brazing paste

approx. 4.1 g/cm³ (20 °C)

Grain size of brazing alloy powder

< 90 µm

Viscosity

3,4 ± 0,4 Pa s (Cone-Plate; 150 µm; D= 50/s; 20 °C)

Drying temperature

about 100 - 120°C, at workpiece

Cleaning agent

BrazeTec Cleaning Agent TD

Shelf life

min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C. stir well before use

Packaging

Standard

10; 25 kg

Applications

BrazeTec CSF 600 TD is applied with special application equipment (fin tip machines) on the fin tips. The coated fins can then be dried at temperatures between 100 °C and 120 °C at the fins with standard drying processes (hot air, infrared). After drying the cores can be assembled.

The brazing process has to be carried out in protective atmosphere using nitrogen at a brazing temperature of about 650 °C depending on brazing furnace, furnace cycle, size of parts etc. The brazing time above 600 °C should be as short as possible and not longer than 4 minutes in case of brazing radiators to avoid critical tin-alloying of the thin fin material.

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