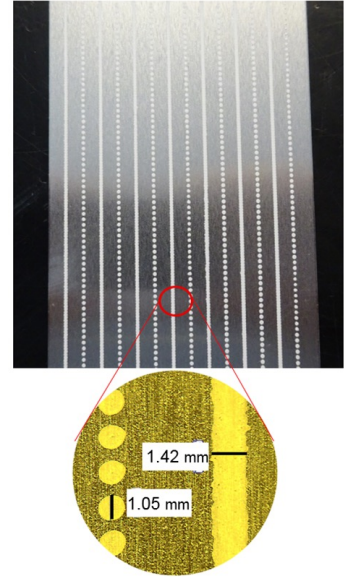


# HONEYWELL JET APPLIED BRAZING FLUX: JETFLUX 40 MF 6.1

## BENEFITS

- Contactless fluxing from small and complex to large cooling plates by high speed and precise dosing.
- Partial fluxing with digital print technology enables lower flux usage and reduced costs.
- Up to 95% reduction in post braze flux residue.
- Ability to control flux dosage reliably for each part therefore reduced risk of corrosion and abrasion of your brazed parts leading to improved product lifetime
- Digital printing, jet valves and piezo assisted dispensers in vertical (top-down and bottom-up) and in horizontal directions allows clean application with high throughput while multiple parts can be simultaneously fluxed.
- Narrow particle size distribution with control of maximum particle size to prevent clogging of jet nozzles.
- A unique multi-constituent phase material with amorphous amounts providing an exceptionally low melting temperature, saving up to 20% brazing time for full surface wetting and improved cleaning and oxide removal before filler metal melt begins. This ensures best possible braze joint preparation and filler metal flow.



## PRODUCT DATA SHEET


Product Name	Honeywell Jet Applied Brazing Flux: Jetflux 40MF 6.1
Description	Non-corrosive Honeywell Jet Assisted Brazing Flux made of Honeywell Potassium Fluoroaluminate (Al-Flux 2805) and water-based carrier system with organic binder
Main use	Brazing of aluminum alloys in the CAB furnace
Method of Application	Partial fluxing using contactless jet dispensers

## TYPICAL PHYSICAL PROPERTIES

Appearance	White paste	Potassium (K)	9.5-11.0 %
Onset of melting (flux)	<555° C / < 1031°F	Aluminium (Al)	6.5-7.2 %
Debinding (organic)	300-400 °C / 572-752 °F	MFFT	0 - 10 °C / 32 - 50 °F

## TYPICAL CHEMICAL PROPERTIES

## APPEARANCE OF PACKING

Type	Net Weight	Dimensions	
Cartridge with Luer Lock adapter	1.2 kg / 2.64 lb	68 x 370 mm (DxH) 2.67 x 14.56 in	

## APPLICATION

- Store in closed container, prevent drying or freezing
- Use a contactless dispenser, e.g. the PICO Pulse system from Nordson EFD for jetting lines or dot patterns
- Apply of 0.01 - 0.05g per running meter with a 10% tolerance
- Recommended settings for 0.035g/m flux load: Use 300 $\mu$ m nozzle, 1 bar media pressure and 250 Hz
- Dry coating weights are very easy to change via the media pressure (1:100 range), the jetting frequency (up to 400 Hz) or the nozzle diameter.
- Jetflux 40MF 6.1 dispense can be varied to generate continuous lines or flexible dot matrix geometries. Contact us for recommendations and flux residue calculations for your design..

## SAFETY

- Please see Material Safety Data Sheet (MSDS) for additional information



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### For more information:

to contact us, please visit:

<https://advancedmaterials.honeywell.com/us/en/applications/brazing-solutions>

### Honeywell Specialty Chemicals Seelze GmbH

Wunstorfer Strasse 40  
D-30926 Seelze  
Germany

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