



SUPERIOR No. 29



LIQUID BRAZING FLUX

- Fluoride-Free Flux
- VOC-Free
- Excellent for eyeglass frames, jewelry, and precious metal applications.

DESCRIPTION

Superior No. 29 is a Fluoride-Free and VOC-Free liquid brazing flux that contains borates and phosphates. It performs well on eyeglass frames, jewelry, and fine metal products. The flux exhibits excellent capillary action, drawing silver filler alloys into narrow joints. It exerts powerful scavenging action on most metal oxides, removing tarnish, scale, and other impurities to yield strong brazed joints.

APPLICATIONS

Superior No. 29 was formulated for the eyewear industry. However, the non-hazardous, non-toxic formulation makes it an ideal candidate for applications that do not require an active or concentrated flux.

DIRECTIONS

Superior No. 29 may be applied manually by brush, spraying, dipping or with automatic dispensing equipment. Recommended heat sources include torches and inductors. The flux is active between 1,020-1,580°F/550-850°C, which makes it an ideal candidate for use with a variety of silver brazing alloys.

- ❶ Remove any oil, grease, or other contaminants from the surface to be brazed.
- ❷ Apply flux to joint by dipping, swabbing, spraying or brushing area being brazed. The flux may be used as supplied or diluted.
- ❸ Apply heat, by torch, induction or other means to area being brazed after flux has been applied to activate the flux.
- ❹ Feed the braze alloy into the joint, unless a brazing preform is already in place.
- ❺ Clean flux residues from brazed joint using hot water (60°C±5°C/140°F±10°F) for best results. If unavailable, room temperature water may also be used.

Superior manufactures quality fluxes. Our business is solving problems.



PHYSICAL PROPERTIES

Form	Clear Liquid
pH	7.95
Flash Point	None
Freezing Point	-3°C
Freezing Effects	None
Active Temperature Range	1,020-1,580°F/550-850°C
Residues	Water-Soluble

SAFETY PRECAUTIONS

Superior No. 29 is a non-hazardous product, but like all chemicals used in industrial manufacturing applications should be handled with care.

Avoid contact with skin, eyes or clothing. Wear NIOSH approved safety goggles, rubber gloves, and rubber apron when handling and brazing. As an added precaution, wash hands thoroughly after use. Brazing should be done in an area of adequate ventilation.

Disposal of raw flux and flux residues must be carried out in accordance with local and federal environmental guidelines.

Superior No. 29 has a two (2) year shelf life when stored properly.

Refer to MSDS for additional safety information.

The information contained herein is based on data considered to be accurate and is intended for use by persons having technical skills at their own discretion and risk. Since conditions of use are outside of Superior Flux & Mfg. Co.'s control, we cannot assume liability for results obtained or damage incurred due to misuse, nor can we assume customer liability.

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