



## Technical Data Sheet BrazeTec CTF 600

TD BT 1309 E.07



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#### Thermoplastic brazing paste

**BrazeTec CTF 600** is especially developed for the copper-brass radiator brazing process (CuproBraze). It is especially designed for coating fin tips or header plates. **BrazeTec CTF 600** composes finely divided brazing powder in a homogenous mixture of a thermoplastic polymer. Solid at ambient temperatures, this material becomes liquid at 60 °C and rapidly solidifies during cooling.

#### Standard

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

#### Nominal composition [wt.-%]

Cu Rest; Sn 15,5; P 5,0; Ni 4,0

#### Permitted impurities max. [wt.-%]

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
Application temperature	approx. 60 °C - 120 °C
Drying behaviour	solidifies below 50 °C
Density of brazing paste	approx. 4,4 g/cm <sup>3</sup> (20 °C)
Metal content	approx. 85 - 95 wt.-%
Grain size of brazing alloy powder	< 90 µm
Viscosity	9,2 ± 1,4 Pa s (Cone-Plate; 150 µm; D= 5/s; 60 °C)
Cleaning agent	BrazeTec Cleaning Agent P
Shelf life	min. 6 months, but only in the original sealed container at storage temperatures between +5 to +30°C

#### Packaging

Standard Solid paste rod, net. weight 2,5 kg

#### Applications

**Melt BrazeTec CTF 600** at 60 °C and stir until the mixture is homogenous. The thermoplastic paste can be easily applied by dipping the fins into the molten paste or using a roller coating method. Viscosity of the paste can be adjusted to different application techniques via temperature.

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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