REV.	DESCRIPTION	DRAWN / APPD.	DATE / DATE

THE FOLLOWING BRAZING STEPS ARE TO BE UTILIZED IN ORDER TO ENSURE THE DISTRIBUTION OF THE SILFOS 15 FILLER INTO THE JOINT. (CAPILLARY ACTION).

1. GOOD FIT AND PROPER CLEARANCES

   CARE MUST BE TAKEN TO MAINTAIN A CLOSE CLEARANCE BETWEEN THE CDA 102 COPPER MAKING IT POSSIBLE FOR CAPILLARY ACTION TO WORK AT ITS BEST.

   MAXIMUM JOINT STRENGTH IS ACHIEVED WHEN THE JOINT CLEARANCE IS .0015". A CLEARANCE NO LESS THAN .001" AND NO GREATER THAN .005" IS ACCEPTABLE.

2. CLEANING THE METALS / PARTS REQUIRED FOR ASSEMBLY

   ALL CONTAMINANTS MUST BE REMOVED IN THE FOLLOWING SEQUENCE:

   1) OIL AND GREASE SHOULD BE REMOVED BY VAPOR DEGREASING OR SOLVENT CLEANING.
      ANY CHEMICALS USED MUST BE COMPATIBLE WITH THE CDA 102 COPPER AND THE SILFOS 15. ENSURE THAT NO ACID TRACES REMAIN IN CREVICES OR BLIND HOLES WHEN CLEANING IS COMPLETED.

   2) OXIDE OR SCALE SHOULD BE REMOVED CHEMICALLY OR MECHANICALLY.
      USE EMERY CLOTH, GRINDING WHEEL, FILE OR SANDBLAST FOLLOWED BY A RINSING OPERATION.

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	W. ZIMMERMAN	5/10/94
FRACTIONS	DECIMALS	ANGLES	DRAWN	T. SKWERES	5/10/94
±	±	±	CHECKED	W. Zimmerman	05/10/94
1. BREAK ALL SHARP EDGES 1/64 MAX. 2. DO NOT SCALE DWG. 3. DIMENSIONING IN ACCORD WITH ANSI Y14.5 STD's.			APPROVED	R K Rebel	5/10/94
			USED ON		
√ MAX. ALL MACHINED SURFACES			MATERIAL		

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TS/MAGNET DESIGN & FABRICATION
GENERAL BRAZING SPECIFICATION

SCALE	FILMED	DRAWING NUMBER	PAGE	REV.
N/A		5525-OP-318973	1 OF 3	

REV.	DESCRIPTION	DRAWN / APPD.	DATE / DATE

3. PARTS HANDLING

HANDLING THE PARTS WILL BE DONE IN SUCH A MANNER SO AS NOT TO INTRODUCE NEW OR REINTRODUCE REMOVED CONTAMINANTS.

4. FLUXING PARTS

FLUX THE PARTS IMMEDIATELY AFTER CLEANING TO PREVENT THE FORMATION OF OXIDES.
COVER THE AREA AND SURFACES TO BE BRAZED COMPLETELY. ENOUGH FLUX WILL BE USED TO LAST THROUGHOUT THE ENTIRE HEATING CYCLE.

USE THE FLUX FORMULATED FOR THE SPECIFIC METALS, TEMPERATURES, AND CONDITIONS OF THE BRAZING APPLICATION.

COPPER TO COPPER JOINTS REQUIRE NO FLUX FOR BRAZING. USE ONLY SILFOS 15.

COPPER TO STAINLESS STEEL, USE HANDY & HARMAN HANDY FLUX FOR LOW TEMPERATURE BRAZING.

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	W. ZIMMERMAN	5/10/94
FRACTIONS	DECIMALS	ANGLES	DRAWN	T. SKWERES	5/10/94
±	±	±	CHECKED		
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TS/MAGNET DESIGN & FABRICATION
GENERAL BRAZING SPECIFICATION

SCALE	FILMED	DRAWING NUMBER	PAGE	REV.
N/A		5525-OP-318973	2 OF 3	

REV.	DESCRIPTION	DRAWN / APPD.	DATE / DATE

5. ASSEMBLY FOR BRAZING

CORRECT ALIGNMENT MUST BE MAINTAINED THROUGHOUT THE HEATING CYCLE AND COOLING.

FIXTURES SHALL NOT BE OVERLY BULKY, CUMBERSOME, OR A HEAT CONDUCTOR.

MATERIAL USED WILL HAVE COMPATIBLE EXPANSION RATES.

PRESSURE WILL BE APPLIED TO THE JOINT, BRINGING THE COPPER JOINTS TOGETHER WHEN FLOW IS ACHIEVED.

SHARP EDGES ON BRAZING FIXTURING SHALL NOT DEFORM OR MARK THE COPPER CONDUCTORS.

UNLESS OTHERWISE SPECIFIED			ORIGINATOR	W. ZIMMERMAN	5/10/94
FRACTIONS	DECIMALS	ANGLES	DRAWN	T. SKWERES	5/10/94
±	±	±	CHECKED		
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TS/MAGNET DESIGN & FABRICATION
GENERAL BRAZING SPECIFICATION

SCALE	FILMED	DRAWING NUMBER	PAGE	REV.
N/A		5525-OP-318973	3 OF 3	