



## Vitta Braz-Binder Gel Grade ST

Classification	Brazing Binder	Issued July 2019 Revision 1.0
Overview	<p>Vitta-Braz Binder Gel Grade ST is a water-based binder gel used to mix and suspend powdered brazing filler metals in smooth, stable and uniform pastes for furnace brazing applications.</p> <p>The Braz-Binder gel is a viscous gel made from non-hazardous polymers and water. There are no ozone depleting substances, toxic or flammable materials or fumes to cause potential issues in the mixing or application areas.</p>	
CSS189 Approved	Yes	
Available Alloys	Braz-Binder Gel can be used with all brazing alloy powders.	
Clean-Up	Braz-Binder Gel is designed to burn off well below working/brazing temperatures to leave little or no residue. Any remaining residue can be removed by simple brushing, air-blowing or washing with a jet of water. No chemical cleaning or grinding is required.	
Typical Application	<p>Braz-Binder Gel can be used in furnace applications without any concern of contamination of either the filler or base metals. It is recommended that the brazing paste be allowed to dry at room temperature (30-60 minutes depending on thickness) prior to furnace cycling so that rapid evaporation of water in the gel does not cause cracking or pitting of the filler metal paste surface.</p> <p>8-15% by weight of the gel can be mixed with 82-92% of powdered filling metal, typically with -140 mesh size to produce pastes of various viscosities. The final paste viscosity can be adjusted by adding small amounts of water or brazing powder.</p> <p>Pastes made with Braz-Binder Gel can be applied by brushing, syringe, cartridge or needle tips depending upon viscosity.</p> <p>Pastes should be thoroughly mixed (5-15 minutes) before use or packaging. Small amounts of paste can be made by hand mixing with a spatula and wide mouth jar or beaker. Intermediate paste batches (between 2-5lbs) may be mixed with the aid of a motor driven stirrer and an appropriate mixer blade. Large scale batches are best prepared with a planetary mixer.</p>	
Braz-Binder Gel Grade ST Availability	Braz-Binder Gel is supplied as standard in a 500g jar. Minimum order quantities apply.	
Storage Recommendations	<ul style="list-style-type: none"> <li>• Store upright in original packaging in a cool and dry environment.</li> <li>• Pastes should be stored tip down in a cool and dry environment</li> </ul>	
Safety Recommendation	Please refer to the specific MSDS (Material Safety Data Sheet) – available from Vitta	

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