



## ProTech™ C/S

# LOW TEMPERATURE BRAZING SOLDER

- For use on non-ferrous and ferrous metals
- Low bonding temperature
- Cools to match Chrome-Silver color
- Consistent high strength
- Non-Toxic, contains no lead or cadmium
- Will bond to precious, semi-precious and many non-precious metals

ProTech™ C/S is a unique 85% silver, low temperature construction and repair material that will give you professional quality results when used according to the following procedures:

Be sure to use a sufficient amount of material to completely fill the joint. Store the syringe in a cool location when not in use. Do not refrigerate. If syringe has not been used for a time, roll for one minute on a vibrating pad to stir contents.

### TORCH APPLICATION

Torch must be capable of producing 1300° to 1400° F. Make sure that the joint is clean and free of contaminants. We suggest rubber wheeling the joint as a final cleaning step. Apply pressure to plunger until desired amount of material has been deposited in the joint. To stop the material from exiting the syringe, gently pull back on the plunger. Using a "neutral" flame, heat both sides of joint back and forth, as evenly as possible. Do not heat the solder directly! When solder reaches 1250° F, it will flow. Then remove heat. Allow part to cool slowly. Replace cap.

### RESISTANCE MACHINE APPLICATION

Make sure that the joint is clean and free of contaminants. We suggest rubber wheeling the joint as a final cleaning step. Remove the cap from the syringe. Apply pressure to plunger until desired amount of material has been deposited in the joint. To stop the material from exiting the syringe, gently pull back on the plunger. Adjust machine to produce 1350° F to 1400° F. (Second setting on most machines.) Moisten the electrodes with water. Place the carbon tip on the side of the solder. Place metal tip ground wire from the machine too base the metal, approximately 10-mm away from the carbon tip. When the solder flows (at 1250° F), gently run the carbon tip through the solder, using sufficient downward pressure to ensure a completed circuit. Allow the solder to cool slowly. Replace cap onto syringe.