Pattern Coating Process of Brazing Paste

Our brazing paste corresponds to pattern coating used in atmosphere furnace or vacuum brazing. Pattern coating is applicable for any brazing alloys in powder as of Ni, Ag, Al and phosphorous copper.

- **Merits of printing process application**
  - Where difficult to fix preform fillers properly on the location to be required.
  - Printing by pattern coating process takes less time than coating by a dispenser feeding.
  - Pattern coating of brazing plates to fins or tubes costs you less time than brazing with setting rings and rods.
  - Less use of filler metal by 30% or so than conventional application.

- **Example of Ni paste printing thickness**

<table>
<thead>
<tr>
<th>Type of printing plate</th>
<th>Printing thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thick coating Type A</td>
<td>120 ~ 170 μm</td>
</tr>
<tr>
<td>Thin coating Type B</td>
<td>about 70 μm</td>
</tr>
</tbody>
</table>

- **Ready to meet your printing test request**
  - To prepare the same figure of printing plate with the one given in your drawing.
  - To inspect the thickness, the width and the uniformity of the print-coated paste.
  - To make vacuum brazed assemblies and confirm the joint state. The qualification records would be reported to you.

- **Select a pattern coating equipment according to your production quantity and precision.**
  Consult our brazing engineers for pattern coating process and coating equipment.

- **Binder types to meet pattern coating**

<table>
<thead>
<tr>
<th>Trade name</th>
<th>Type</th>
<th>Features</th>
<th>Dried adhesive</th>
<th>Washable by</th>
</tr>
</thead>
<tbody>
<tr>
<td>VB-15</td>
<td>Water-soluble</td>
<td>△</td>
<td>◯ (water)</td>
<td></td>
</tr>
<tr>
<td>VB-24</td>
<td>Oil-based</td>
<td>◯</td>
<td>◯ (organic solvent)</td>
<td></td>
</tr>
</tbody>
</table>

- **Application examples**: SUS304/Ni brazing
  - Coating plain boards
  - Coating a corrugated sheet
  - Coating a plate with sides folded
  - Coating 2mm wide