



HI-ALLOY 53 PLYMETAL

SILVER ALLOY BRAZING STRIP

DESCRIPTION: Hi-Alloy 53 Plymetal strip consists of a layer of copper, clad on both sides with a layer of 50% silver alloyed with cadmium and nickel. 53 Plymetal strip was designed primarily for low temperature brazing of carbide inserts onto tool shanks. The silver alloy joins the shank and insert together while the copper provides essential stress and shock absorbing qualities.

PROCEDURES: Remove the damaged insert from the shank, clean any residual brazing material from the shank, precut the 53 Plymetal to the required shape and size, flux the shank with Hi-Alloy Ultra Crème Flux, place the precut Plymetal onto the shank, use 1 thickness for smaller inserts, use 2 thicknesses for inserts over 3/8", add additional flux to all joint surfaces, place the carbide insert into position, keep the insert in place with a hold down rod while heating, heat broadly and uniformly with torch set to a neutral flame, apply pressure to the insert with hold down rod while heating. When Plymetal melts press the insert into place, smooth fillets of brazing alloy should be visible at the edges of the joint when the procedure is completed. Allow the part to cool slowly in still air. Remove flux residue with hot water and a stainless steel brush.

AVAILABLE SIZE: .010" X 3/4" X 16" Strips. 6 Strips per 1/4 lb Package

TENSILE STRENGTH: Up to 55,000 psi

BRAZING TEMPERATURE: 1270° - 1500° F