



# BrazeLet® Stop-off

Water-based  
and without odour

Höganäs BrazeLet Stop-off solutions act as a barrier to the flow of molten brazing filler metals. They should be used when the flow of the molten brazing filler metal must be contained or redirected due to tolerances, following assembly steps, and even to prevent brazed parts from bonding to their furnace fixtures.

To avoid contamination, care must be taken with the parts that will be brazed since the stop-offs are very effective and should not be applied where brazing will take place. It is not possible to completely remove the stop-off once applied.

Directions for use	
<b>Drying temperature</b>	RT – 200 °C (RT – 329 °F)
<b>Working temperature</b>	Up to 1320 °C (2408 °F)
<b>Recommended storage</b>	5–30 °C (41–86 °F) in closed container and well-ventilated space
<b>Recommended uses</b>	<ul style="list-style-type: none"> <li>• All base materials (except reactive metals such as Ti and Zr and their alloys)</li> <li>• Any of Höganäs brazing filler metals</li> <li>• Vacuum and controlled atmosphere brazing</li> </ul>
<b>Post-brazing cleaning</b>	The residual stop-off is easily removed by using a dry or damp cloth

## BrazeLet Stop-off solutions

The stop-off solutions consist of ready-to-use water-based suspensions designed for all-purpose use. They work very well in high-temperature brazing together with any of Höganäs' brazing filler metals and can be used on any ferrous or non-ferrous base material (exception of reactive metals such as Ti and Zr and their alloys),

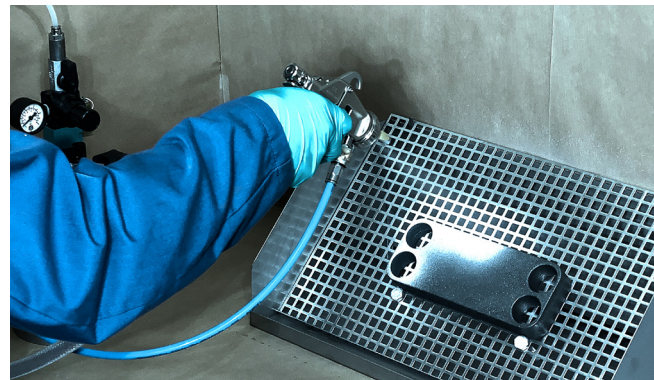
in both vacuum and controlled atmosphere brazing. For best performance, the stop-offs should be dried before entering the furnace, which can be easily achieved in room temperature without any odour formation.

**Three different stop-offs are available depending on the application methods and/or final use.**

### BrazeLet Stop-off 10

- Recommended for general brazing applications.
- Due to its superior adhesion to the applied surfaces, it is specially recommended for application on fixtures.
- Can be applied by different methods, such as brushing, dispensing and spraying.

**Available in 1 kg and 5 kg containers**

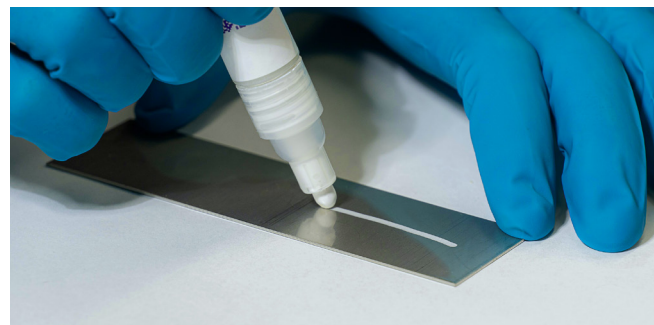


Spraying with BrazeLet Stop-off 10

### BrazeLet Stop-off 11

- Recommended for general brazing applications.
- Specially designed for application with a marker pen.  
**How to use the pen:** Shake it, then press the tip down until stop-off starts flowing. Keep the pen slightly pressed against the surface to ensure an even flow of stop-off while drawing the wanted markings.
- The pen can be reused and coupled with the stop-off refill, which allows for decrease waste in both packaging and stop-off material.

**Available in pens and 1 kg refill container**

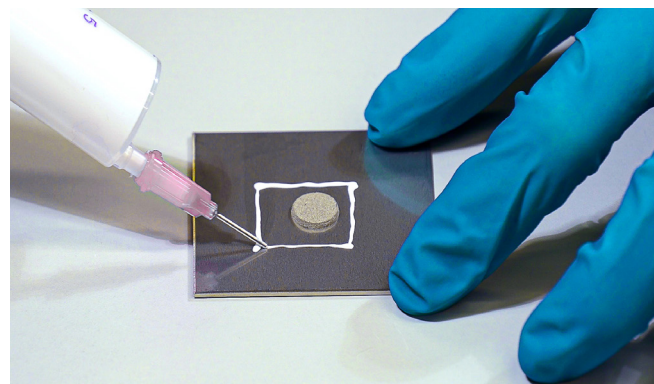


Applying BrazeLet Stop-off 11 with a pen

### BrazeLet Stop-off 20

- Recommended when best surface finish after brazing is needed.
- Due to its easiness of removal, it is specially recommended for application on the brazed parts.
- Can be applied by different methods, such as brushing, dispensing and spraying.

**Available in 1 kg and 5 kg containers**



Dispensing BrazeLet Stop-off 20 on a sample plate