

# **Instructions for Use**

## **Fixturing Alloy No. 15158**

Material melts at 158° F so that you can heat it in a small pot or ladle either over a burner or in a double boiler (pot in a hot water bath). Pot can be stainless, porcelain lined or cast iron. Aluminum, brass, or copper vessels are not recommended. Thermostatically controlled melting pots are good.

### **PROCEDURE:**

- A. The molten alloy is poured into or around the item to be machined. A simple dam or jug to contain the alloy until solidified is all that is required.
- B. Although the molten alloy can be solidified more quickly with water or a fan, it is not necessary, but it would produce a finer crystalline structure. As the alloy is used at such a low temperature there is no danger of affecting the temper of the work piece.
- C. The part is then machined to the necessary configuration.
- D. Removal of the alloy is accomplished in hot water or with a steambath. Chips that float to the top of the molten alloy are removed by skimming, leaving the alloy sufficiently clean to be reused.

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