



## Brazing & Soldering

# APPLICATION DATA

## No. 518 – Aluminum Heater Core Assembly



### Brazing Machine Specifications

- ❑ **Assembly:** Two (3003) inlet/outlet tubes to header plate and bracket; (3 joints total).
- ❑ **Paste Filler Metal:** Fusion GNC-1070-400, non-corrosive flux, 1080°F liquidus.
- ❑ **Production Rate:** 180 parts per hour, one operator.
- ❑ **Dimensions:** 72" X 72" welded steel base, 42" dia. stainless toolplate cover, 30" dia. stationary plate for inner heat manifold, stainless water trough, PDC 18" direct drive indexer.
- ❑ **Utilities:** Electrical 440 VAC, 3PH, Control voltage 24VDC, Gas (58 CFH) Water (1 gallon/minute) Compressed air (28 CFM).
- ❑ **PLC:** Allen Bradley SLC 503 with DTAM operator interface.
- ❑ **Safety Features:** Sliding Lexan® guards on 3 sides of machine with safety interlock switches; stainless vent hood.
- ❑ **Options:** Air blower with variable speed drive for heat control, automatic port valve, and thermocouple heat feedback.
- ❑ **Sequence:**
  - Station 1 - Load assembly
  - Station 2 - Open
  - Station 3 - Apply paste automatically
  - Station 4 - Heat
  - Station 5 - Heat
  - Station 6 - Heat
  - Station 7 - Ambient Cool
  - Station 8 - Water Cool
  - Station 9 - Air blow-off part and fixture
  - Station 10 - Unload brazed assembly

*10-station  
brazing  
machine  
operates at  
180 parts per  
hour with one  
operator.*



*Three  
applicator  
guns dispense  
premeasured  
paste deposits  
onto assembly  
joints.*

*Precision heat  
pattern melts  
filler metal at  
1080°F, sealing  
joints.*



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