



# Brazing & Soldering APPLICATION DATA

No. 537 – Carbide Tipped Tool Bits

Ask for



Video



## Brazing Machine Specifications

- **Assembly:** Two-piece carbide and steel; 173 part numbers – 32 different carbide inserts, 1/4", 3/8", 5/16", 7/16", 1/2", 5/8", 3/4" steel shanks.
- **Paste Filler Metal:** Fusion STK-1260-750, cadmium-free (BAg 24), 1305°F (707°C) liquidus.
- **Production Rate:** 200 - 400 parts per hour, one operator.
- **Heat System:** Gas/Oxygen, 4-stations, independently controlled (no common manifold).
- **Dimensions:** 75" X 75" welded steel base, 42" dia. (stainless covered) tool plate, Weiss TC 220 indexer.
- **Utilities:** Electrical 460V/3PH/60Hz, Control voltage 24VDC, Gas 64 CFH, Oxygen 128 CFH, Water 1 GPM, Compressed Air 5 CFM.
- **PLC:** Allen Bradley SLC 550 with PanelView operator interface.
- **Safety Features:** Polycarbonate perimeter guarding with safety interlocks.
- **Options:** Three-axis adjustment on paste applicator; device permits incremental movement up to 2 1/2" in XYZ axes for part changeover. Part takeaway, stainless mesh belt conveyor. 100 Gallon Water Recirculating Cooling System. Vent Hood.

### Sequence:

- |            |   |   |
|------------|---|---|
| Station 1  | - | Paste applied to shank (off-station) and loaded with carbide insert into fixture. |
| Station 2  | - | Open (Sense Parts)  |
| Station 3  | - | Heat  |
| Station 4  | - | Heat  |
| Station 5  | - | Heat  |
| Station 6  | - | Heat  |
| Station 7  | - | Air Cool  |
| Station 8  | - | Air Cool  |
| Station 9  | - | 5-Axis Automatic Pick & Place Unload  |
| Station 10 | - | Water Cool (Fixtures)   |
| Station 11 | - | Water Cool/Air Blast  |
| Station 12 | - | Open  |



*Applicator gun dispenses premeasured deposit of paste filler metal to shank.*



*Precision, gas/oxygen burner pattern distributes filler metal throughout joint area.*



## FUSION INCORPORATED

4658 E. 355<sup>th</sup> St., Willoughby, OH 44094  
Phone 1-800-626-9501 • (440) 946-3300  
Fax (440) 942-9083 • e-mail: info@fusion-inc.com  
Web: www.fusion-inc.com