



Brazing & Soldering

APPLICATION DATA

No. 525 – Carbide Burr Assembly

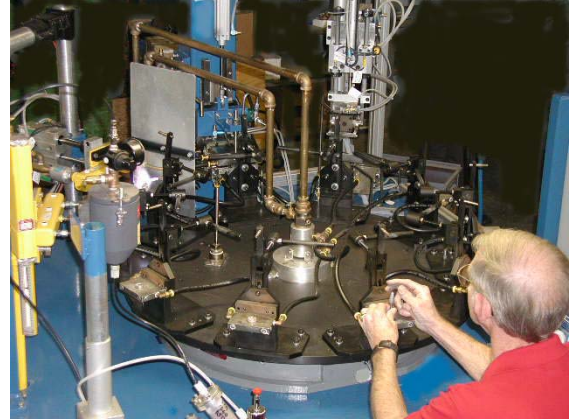


Brazing Machine Specifications

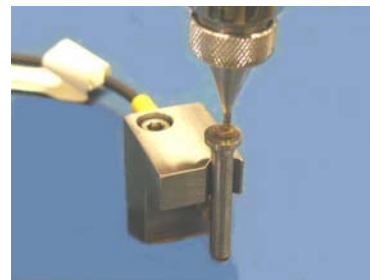
- ❑ **Assembly:** Tungsten carbide blank (cylinder, barrel cone, ball shapes) to 1/4" and 6mm steel shank, 37 different shapes and sizes.
- ❑ **Joint Specs:** T.I.R. of 0.005" maximum, 40 psi pneumatic hammer test.
- ❑ **Paste Filler Metal:** Fusion STK-1260-650 (BAg 24) cadmium-free, 1305°F liquidus.
- ❑ **Production Rate:** 400 parts per hour, one operator.
- ❑ **Dimensions:** 72" X 72" welded steel base, 38" dia. anodized tooling plate mounted to PDC 18" electric direct drive indexer.
- ❑ **Utilities:** Electrical (440 VAC, 3PH), Control voltage 24VDC, Gas (40 CFH), Oxygen (90 CFH), Water (1 gallon/minute), Compressed air (2 CFM).
- ❑ **PLC:** Allen Bradley SLC 503 with DTAM operator interface.
- ❑ **Options:** Fixtures internally water cooled, stainless steel vent hood, optical pyrometer monitors part temperature during heat cycle; if limit is exceeded, part is ejected into separate container.

Sequence:

- | | | |
|------------|---|---|
| Station 1 | - | Paste applied to shank (off-station) and loaded with carbide blank into fixture |
| Station 2 | - | Open |
| Station 3 | - | Open |
| Station 4 | - | Heat |
| Station 5 | - | Heat |
| Station 6 | - | Align and Cool |
| Station 7 | - | Automatic Ejection |
| Station 8 | - | Open |
| Station 9 | - | Open |
| Station 10 | - | Open |



10-station brazing machine operates at 400 parts per hour with one operator.



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

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



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