



Brazing & Soldering ROTARY INDEX

Model 100

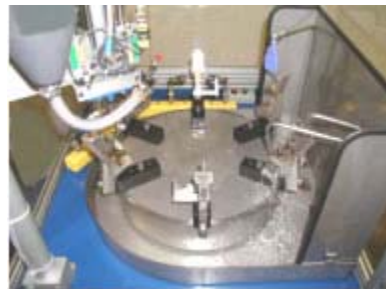
SEQUENCE OF OPERATION:

- Operator loads assembly into stainless steel fixture.
- Deposit of paste alloy is applied automatically (or manually) to the joint area.
- Assembly indexes through a series of natural gas/air heat stations.
- Compressed air and water quench cools both the part and fixture for safe operator unloading.



BRAZING MACHINE SPECIFICATIONS

- **Construction:** Structural aluminum frame with clear acrylic guarding on three sides; 20" dia. stainless steel dial with stainless water trough.
- **Dimensions:** 36"W x 48"D x 38" load height; guarding extends 40" beyond load height.
- **Indexer:** Weiss Barrel Cam TC 150, 6 or 8-station.
- **Paste Applicator:** Three modes available: automatic, hand-held, or off-station mounted.
- **Heating:** Three-station capacity; rigid steel gas train includes air pressure switch, gas flow meter, and manifold pressure gauges. High/Low gas/air system transitions to low flame when machine detects no parts have been loaded into fixture.
- **Cooling:** Timed air and water sequence cools parts and fixtures; optional water recirculating system available.
- **Control:** PLC (A-B MicroLogix 1000) with MicroView Operator Interface Panel to change timers and counters.
- **Utilities:** 120 volts, single phase, 5 amp; 24 VDC control voltage; natural gas or propane; 80 psi air, water and drain.
- **Rate:** 100 - 200 parts per hour; dependent on assembly mass and configuration.



Applicator gun dispenses two deposits of paste filler metal to joint area.



Precision heat pattern distribute filler metal evenly throughout joint area.



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