



Brazing & Soldering APPLICATION DATA

No. 522 — Medical Gas Valve Assembly



BRAZING MACHINE SPECIFICATIONS

- **Assembly:** Two-piece, ½" O.D. copper tube to brass body.
- **Paste Filler Metal:** Fusion STK-1205-750 (BAG 7)
- **Production Rate:** 250 parts per hour, one operator.
- **Dimensions:** 48" X 48" welded steel base, 26" dia. aluminum tool plate, stainless water trough, PDC 15" direct drive indexer.
- **Utilities:** Electrical (460 VAC, 3PH), Control voltage 24VDC, Gas (144 CFH) Water (1 gallon/minute) Compressed air (28 CFM).
- **PLC:** Allen Bradley MicroLogix 1200 with MicroView operator interface.
- **Options:** Two-axis adjustment on paste applicator slide; device permits incremental movement up to 2 ½" in both (XY) axes.
- **Sequence:**

| | |
|-------------|---------------------------|
| Station 1 - | Load/Unload Assembly |
| Station 2 - | Apply Paste Automatically |
| Station 3 - | Heat |
| Station 4 - | Heat |
| Station 5 - | Heat |
| Station 6 - | Air Cool |
| Station 7 - | Water Cool |
| Station 8 - | Water Cool |

*8-station
brazing
machine
operates at
250 parts per
hour with one
operator.*



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

*Inner and outer
manifolds provide
balanced heat
pattern to bring
filler metal to
1205°F liquidus
and seal joint.*



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