



Brazing & Soldering

APPLICATION DATA

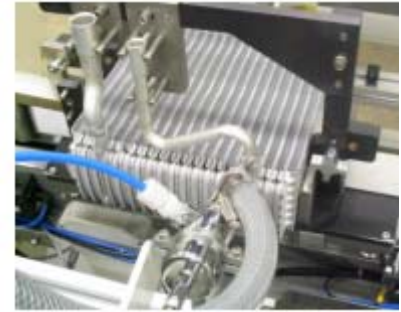
No. 531 - Aluminum Evaporator Core Assembly



Track-Guided Brazing Machine Specifications

- **Assembly:** Two inlet/outlet tubes (3003) to evaporator core.
- **Paste Filler Metal:** Fusion KNC-1040-400, non-corrosive flux, 1040°F liquidus.
- **Production Rate:** 375 parts per hour, one operator.
- **Dimensions:** 240"W x 60"D x 40" load height; variable speed drives transfer fixtures, with sensors and stop pins to move parts station to station.
- **Utilities:** 460V, 3PH, 60Hz; Control voltage 24 VDC; 135 CFH natural gas; 80 psi air; no water.
- **PLC:** Allen Bradley ControlLogix™ with Panel View 600 operator interface.
- **Safety Features:** Polycarbonate guarding for pasting and heating stations with safety interlocks.
- **Options:** Vent hood, electronic flame ignition.

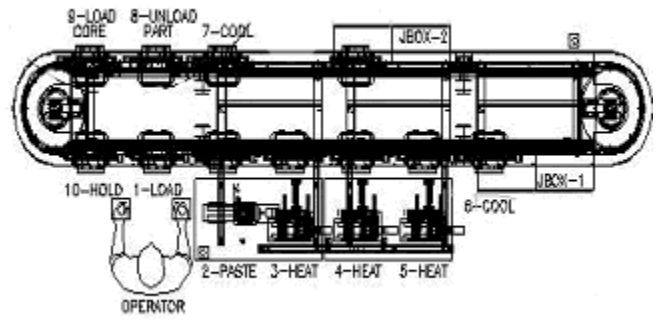
Premeasured deposits of aluminum paste filler metal are applied to both joint areas.



Precision heat pattern melts filler metal at 1040°F, sealing joints.

- Station 9 - Robot loads core into each of 11 fixtures
- Station 10- Open/Hold
- Station 1 - Operator loads tubes into core
- Station 2 - Heat
- Station 3 - Heat
- Station 4 - Heat
- Station 5 - Ambient Cool
- Station 6 - Water Cool
- Station 7 - Vortex air chiller cools part and fixture
- Station 8 - Robot unloads brazed assembly to conveyor





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