



# Brazing & Soldering

## APPLICATION DATA

No. 547 – Bourdon Tube Assemblies



### Brazing Machine Specifications

- **Assembly:** Three-piece beryllium copper and brass; 2", 2 1/2", 3" sizes".
- **Paste Filler Metal:** Fusion PMS-360-870, 374°F (190°C) liquidus.
- **Production Rate:** 400 parts per hour, one operator; 9 second cycle time, 16 fixtures.
- **Dimensions:** 72" X 72" welded steel base, 42" dia. (stainless covered) tool plate, Weiss TC 220 indexer.
- **Utilities:** Electrical 460/3/60, Control voltage 24VDC, Gas 144 CFH, Water 1 GPM, Compressed Air 30 CFM.
- **PLC:** Allen Bradley MicoLogix with PanelView Plus 600 operator interface.
- **Safety Features:** Polycarbonate perimeter guarding with safety interlocks. Part loading E-Stop shield.
- **Options:** Automatic ejection of soldered assembly.

#### Sequence:

- |            |   |                    |
|------------|---|--------------------|
| Station 1  | - | Load Assembly      |
| Station 2  | - | Open               |
| Station 3  | - | Paste              |
| Station 4  | - | Paste              |
| Station 5  | - | Heat               |
| Station 6  | - | Heat               |
| Station 7  | - | Heat               |
| Station 8  | - | Set Part Position  |
| Station 9  | - | Ambient Cool       |
| Station 10 | - | Forced Air Cool    |
| Station 11 | - | Forced Air Cool    |
| Station 12 | - | Water Cool         |
| Station 13 | - | Water Cool         |
| Station 14 | - | Air Blow Off       |
| Station 15 | - | Automatic Ejection |
| Station 16 | - | Open               |



*Applicator gun dispenses solder paste filler metal to joint area.*



*Gas/air flame heat melts filler metal, resulting in leak-proof joints.*



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