



Brazing & Soldering

APPLICATION DATA

No. 540 – A/C Distributor Assemblies



Rotary Model 120 Brazing Machine Specifications

- **Assembly:** Copper capillary tubes / brass body / copper bulb tube.
- **Paste Filler Metal:** Fusion LHK-1205-650 (Bag 7), 1205°F (651°C) liquidus.
- **Production Rate:** 120 parts per hour, one operator.
- **Dimensions:** 64" X 60" welded steel base, 36" dia. (stainless covered) tool plate, stationary outer/inner heat manifolds, Weiss TC 150 indexer.
- **Utilities:** Electrical 120/1/60, Control voltage 24VDC, Gas 96 CFH, Water 1 GPM, Compressed Air 19 CFM.
- **PLC:** Allen Bradley MicroLogix 300 with Panel View Interface.
- **Safety Features:** Lexan perimeter guarding on three sides of machine with safety interlocks.

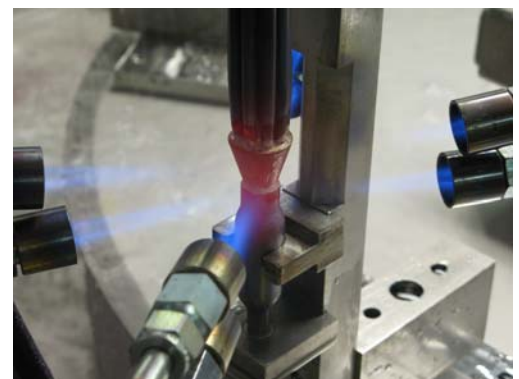
Sequence:

- Station 1 - Load/Unload Assembly*
- Station 2 - Open
- Station 3 - Heat
- Station 4 - Heat
- Station 5 - Air Cool
- Station 6 - Water Cool

* Brazing paste applied off-station prior to loading at Station 1.



Two applicator guns dispense 360° stripes of brazing paste to all joint areas.



Precision heat pattern distributes filler metal, resulting in void-free joints.



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