

Brazing & Soldering

APPLICATION DATA

No. 520 – Tube/Bracket Assembly



Brazing Machine Specifications

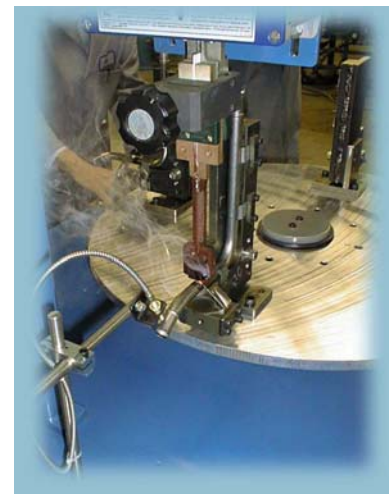
- ❑ **Assembly:** Two-piece steel tube to steel mounting bracket
- ❑ **Paste Filler Metal:** Fusion STN-1260-650, cadmium-free, (AWS BAg 24) 1305°F liquidus.
- ❑ **Production Rate:** 250 parts per hour, one operator.
- ❑ **Dimensions:** 46" X 55" welded steel base, 24" dia. aluminum tooling plate, mounted to PDC 12" electric direct drive indexer.
- ❑ **Utilities:** Electrical 230 VAC, 3PH, Control voltage 24VDC, Compressed air (80 psi).
- ❑ **PLC:** Allen Bradley SLC 500 with DTAM operator interface panel.
- ❑ **Sequence:**
 - Step 1 - Paste automatically applied to mounting bracket off-station.
 - Station 1 - Load pasted bracket and tube into fixture / unload brazed assembly.
 - Station 2 - Open
 - Station 3 - Induction Heat
 - Station 4 - Air Cool

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



Stainless steel fixture positions assembly in proper alignment.

5 KW induction coil brings silver brazing filler metal to 1305°F liquidus temperature.



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