



Brazing & Soldering

APPLICATION DATA

No. 521 - Aluminum A/C
Assembly



"Braze Mate" Model 150 Machine Specifications

- **Assembly:** Four, 3/8" O.D. tubes to union block; 28" OAL.
- **Paste Filler Metal:** Fusion KNC-1040-400, non-corrosive flux, 1040°F liquidus.
- **Production Rate:** 60 parts per hour, one operator.
- **Dimensions:** 72"W x 56"D x 38" load height.
- **Utilities:** 120V, single phase, 5 Amp; natural gas or propane, 80 psi air, water and drain.
- **PLC:** Allen Bradley MicroLogix with DTAM access panel.
- **Safety Features:** Perimeter guarding on 3 sides of machine with safety interlocks.

Sequence:

1. Operator loads four tubes and block into stainless steel fixture.
2. Operator depresses touch switches to actuate automatic brazing cycle.
3. Two slide-mounted applicator guns advance to apply 4 identical paste deposits to joint areas, then retract.
4. Gas/air burners advance into position, adjust to high flame output and bring filler metal to brazing temperature.
5. Heat cycle times out, burners retract into low flame condition.
6. Timed air and water cooling.
7. Operator removes brazed assembly



Stainless steel fixture holds assembly in alignment throughout brazing cycle.



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



FUSION INCORPORATED

4658 E. 355th St., Willoughby, OH 44094

Phone 1-800-626-9501 o (440) 946-3300

Fax (440) 942-9083 o e-mail: sales@fusion-inc.com