



Brazing & Soldering

APPLICATION DATA

No. 544 – Medical Components



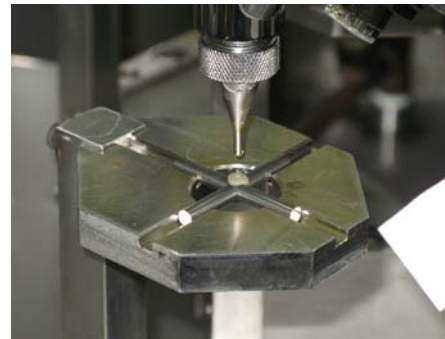
Rotary Model 100 Brazing Machine Specifications

- **Assembly:** Two solid stainless steel pieces, .375" dia. X 2.25" length.
- **Paste Filler Metal:** Fusion APW-1205-750 (BAg 7), 1205°F (651°C) liquidus.
- **Production Rate:** 150 parts per hour, one operator.
- **Dimensions:** 48" X 48" aluminum extrusion frame, 23" dia. stainless tool plate, Stainless water trough, Weiss TC 150 indexer, 8 station.
- **Heating System:** Three station, gas/air, rigid steel network includes air pressure switch, gas flow meter, and manifold pressure gauges. High/Low system transitions to low flame when machine detects no parts have been loaded into fixture.
- **Utilities:** Electrical 120/1/60, Control voltage 24VDC, 5 Amps, Water (1 GPM), Propane (64 CFH), Compressed Air (12 CFM).
- **PLC:** Allen Bradley MicroLogix 1200 with PanelView Plus 400 Interface.
- **Safety Features:** Lexan perimeter guarding on three sides of machine with safety interlocks. Light curtain for E-stop function. Vent hood for fume extraction.

Sequence:

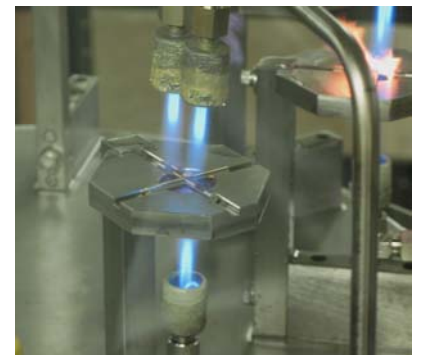
- Station 1 - Load/Unload Assembly
- Station 2 - Apply Braze Paste
- Station 3 - Heat
- Station 4 - Heat
- Station 5 - Heat
- Station 6 - Air Cool
- Station 7 - Water Cool
- Station 8 - Air Blow Off

8-station brazing machine operates at 150 parts per hour with one operator



Applicator gun dispenses premeasured deposit of brazing paste to joint area

Gas/air burners bring filler metal to 1205°F liquidus to bond the stainless pieces



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