



Brazing & Soldering

APPLICATION DATA

No. 515 – Discharge Header Assembly



Brazing Machine Specifications

- ❑ **Assembly:** Three-piece copper tubular (2 tube joints; seal small hole in spun tube end).
- ❑ **Paste Filler Metal:** Fusion LHK-1302-750 (BcuP 6 paste) 1445°F liquidus
- ❑ **Production Rate:** 350 parts per hour, one operator.
- ❑ **Dimensions:** 72" X 72" welded steel base, 42" dia. Stainless steel tool plate cover, stainless water trough, PDC 18" direct drive indexer.
- ❑ **Utilities:** Electrical 220/440 VAC, 3PH, Control voltage 24VDC, Gas (120 CFH) Water (1 gallon/minute) Compressed air (30 CFM)
- ❑ **PLC:** Allen Bradley SLC 500 with DTAM access panel.
- ❑ **Safety Features:** Sliding Lexan ® guards on 3 sides of machine with safety interlock switches; stainless vent hood.
- ❑ **Options:** Nitrogen purge interior tube walls; Gas Flux to reduce copper oxidation during heating; 110 gallon Cooling Water Recirculating System.
- ❑ **Sequence:**
 - Station 1 - Load/Unload assembly
 - Station 2 - Open
 - Station 3 - Apply Paste Automatically
 - Station 4 - Open
 - Station 5 - Heat
 - Station 6 - Heat
 - Station 7 - Heat
 - Station 8 - Air Cool
 - Station 9 - Water Cool Part & Fixture
 - Station 10 - Open

10-station brazing machine operates at 350 parts per hour with one operator.



Three applicator guns dispense premeasured paste deposits onto assembly joints.

Precision heat pattern melts filler metal at 1445°F, sealing joints.



As seen at



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