



# Brazing & Soldering **APPLICATION DATA** No. 546 – Liquid Line Drier Assembly

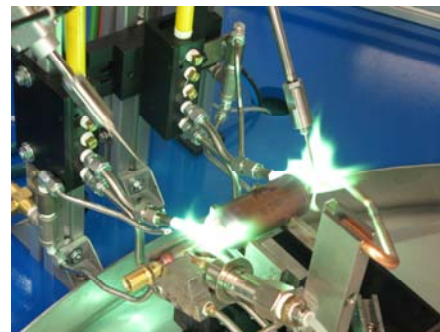
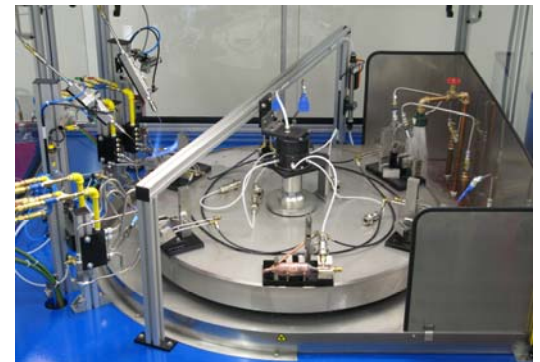


## Wire Feed Brazing Machine Specifications

- ❑ **Assembly:** 25.4 mm dia. copper tube to copper drier and brass valve.
- ❑ **Wire Filler Metal:** Silvaloy 2M, 2Ag/91.50Cu/6.50P, 1190°F (645°C) liquidus.
- ❑ **Production Rate:** 125 parts per hour, one operator.
- ❑ **Dimensions:** 72" X 72" welded steel base, 42" dia. stainless steel tool plate cover, stainless water trough, Weiss TC 220 indexer.
- ❑ **Utilities:** Electrical 460/3/60, 5 amp, Control voltage 24VDC, Gas 96 CFH, Oxygen 192 CFH, Water 1 GPM, Compressed Air 5 CFM.
- ❑ **PLC:** Allen Bradley Micrologix 1500 with PanelView Plus 600 Interface Panel.
- ❑ **Tooling:** Adaptable to accommodate (4) part styles; water cooled.
- ❑ **Options:** Nitrogen purged through assembly during heating to control internal oxidation; sensor detects nitrogen flow. Gas flux to promote filler metal flow and reduce base metal discoloration. 100 gallon Water Recirculating System.
- ❑ **Safety Features:** Perimeter guarding on 3 sides of machine with safety interlocks. Light curtain for E-stop function.

### Sequence:

- Station 1 - Load/Unload Assembly
- Station 2 - Gas-Oxygen Heat
- Station 3 - Gas-Oxygen Heat/Wire Feed
- Station 4 - Air Cool
- Station 5 - Water Cool
- Station 6 - Air Blowoff



*Precision gas/oxygen heat pattern distributes filler metal evenly throughout tube joint areas.*



*Brazed assembly is water cooled for safe operator unloading.*



### FUSION INCORPORATED

4658 E. 355<sup>th</sup> St., Willoughby, OH 44094  
Phone 1-800-626-9501 • (440) 946-3300  
Fax (440) 942-9083 • e-mail: info@fusion-inc.com  
Web: www.fusion-inc.com