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.**