



Brazing & Soldering

APPLICATION DATA

No. 516 - EGR
(Exhaust Gas Recovery) Assembly



Automatic Paste Application System Specifications

- **Assembly:** Stainless steel tube bundle and two headers.
- **Paste Filler Metal:** Fusion CNT-4777-870, nickel-bearing (BNi2) 1830°F liquidus.
- **Production Rate:** 120 assemblies per hour, one operator.
- **Dimensions:** 64" x 48" welded steel base, 33" load height.
- **Utilities:** Electrical 220 VAC, 1 Phase, 50 Hz, Built to CE specifications.
- **PLC:** Allen Bradley SLC 500 with DTAM access panel.
- **Safety Features:** Sliding Lexan ® guards on 3 sides of machine with interlock switches; light curtain for E-Stop function.



Sequence

1. Load top header into fixture under (left side) FE-71 Applicator Gun#1.
 2. Load bottom header into fixture under (right side) FE-71 Applicator Gun #2.
 3. Load tube bundle into fixture under (center) robot-controlled, FE-71 Applicator Gun.
 4. Operator presses palm buttons; complete rings of paste applied to inner lip of each header, and paste pattern applied to tube bundle.
 5. Remove striped headers, invert tube bundle, and same paste pattern applied to opposite end of tube bundle.
 6. Tube bundle removed, assembled with headers, and load into separate vacuum brazing furnace.
- **Robot:** Paste pattern is programmable for future product design changes. With hand-held teach pendant, robot is capable of storing up to 99 different programs.



Robot applies Fusion nickel paste accurately around the 37 tube bundle.



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