

Brazing Machine Specifications

- Assembly: Two-piece carbide and steel; 173 part numbers – 32 different carbide inserts, ¼", 3/8", 5/16", 7/16", ½", 5/8", ¾" steel shanks.
- Paste Filler Metal: Fusion STK-1260-750, cadmium-free (BAg 24), 1305°F (707°C) liquidus.
- **Production Rate:** 200 400 parts per hour, one operator.
- Heat System: Gas/Oxygen, 4-stations, independently controlled (no common manifold).
- Dimensions: 75" X 75" welded steel base, 42" dia. (stainless covered) tool plate, Weiss TC 220 indexer.
- Utilities: Electrical 460V/3PH/60Hz, Control voltage 24VDC, Gas 64 CFH, Oxygen 128 CFH, Water 1 GPM, Compressed Air 5 CFM.
- PLC: Allen Bradley SLC 550 with PanelView operator interface.
- Safety Features: Polycarbonate perimeter guarding with safety interlocks.
- Options: Three-axis adjustment on paste applicator; device permits incremental movement up to 2 ½" in XYZ axes for part changeover. Part takeaway, stainless mesh belt conveyor. 100 Gallon Water Recirculating Cooling System. Vent Hood.

Sequence:

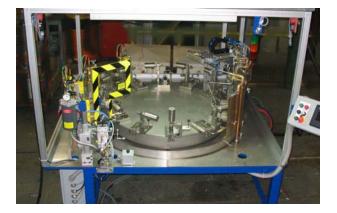
-	Paste applied to shank (off-station) and loaded with carbide insert into fixture.
-	Open (Sense Parts)
-	Heat
-	Air Cool
-	Air Cool
-	5-Axis Automatic Pick & Place Unload
-	Water Cool (Fixtures)
-	Water Cool/Air Blast
-	Open
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FUSION INCORPORATED

4658 E. 355th 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





Applicator gun dispenses premeasured deposit of paste filler metal to shank.





Precision, gas/oxygen burner pattern distributes filler metal throughout joint area.