



Brazing & Soldering **APPLICATION DATA** No. 543 – Fuse Terminals



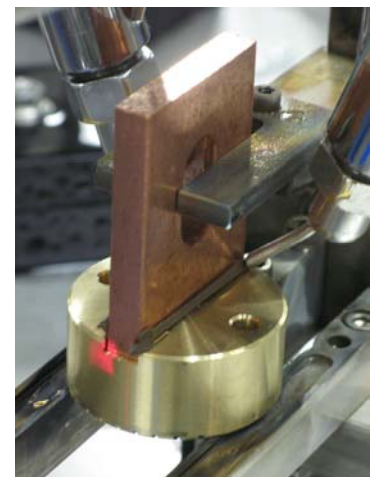
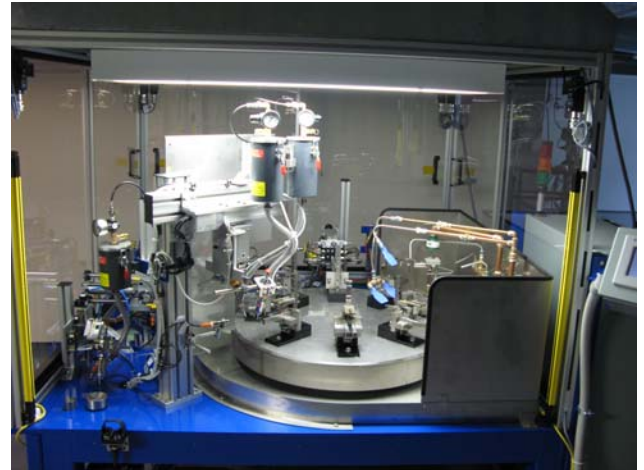
Brazing Machine Specifications

- **Assembly:** Two-piece brass base to copper blade/cylinder.
- **Paste Filler Metal:** Fusion STK-1204-650, 45% silver (BAg 36), 1256°F (680°C) liquidus.
- **Production Rate:** Typical 150 parts per hour, one operator; rate varies with part size.
- **Dimensions:** 72" X 72" welded steel base, 36" dia. (stainless covered) aluminum tool plate, Weiss TC 220 indexer, Stainless water trough.
- **Utilities:** Electrical 480/3/60, Control voltage 24VDC, Propane Gas 144 CFH, Oxygen 576 CFH, Water 1 GPM, Compressed Air 5 CFM, Nitrogen 55 CFH
- **PLC:** Allen Bradley MicroLogix with PanelView Plus 600 Interface Panel.
- **Fixtures:** Stainless steel with inconel details.
- **Safety Features:** Lexan perimeter guarding on three sides of machine with safety interlocks; light curtain for E-stop function.
- **Options:** Gas flux system, driven with nitrogen, to prevent base metal discoloration during heating cycle. 100 gallon Water Recirculating System.

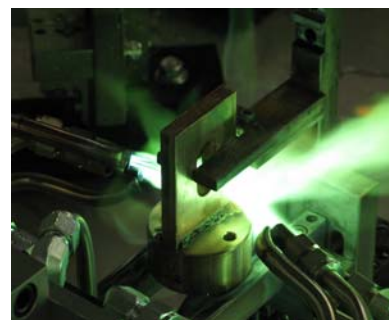
Sequence:

- Station 1 - Load/Unload Assembly
- Station 2 - Paste*
- Station 3 - Heat
- Station 4 - Heat
- Station 5 - Heat
- Station 6 - Air Cool
- Station 7 - Water Cool
- Station 8 - Air Blowoff

*For cylinder part styles, brazing paste applied off station prior to loading.



Two applicator guns dispense paste filler metal along both sides of the terminal blade.



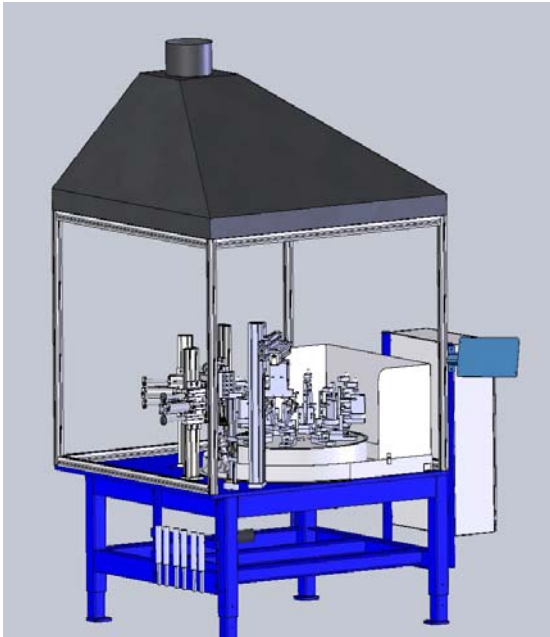
Propane/oxygen heat, enhanced with gas flux, melts filler metal, resulting in strong, void-free joints.



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See Reverse Side for More Information



Three gas/oxygen heat stations, mounted on slides, braze the large range of parts with minimal changes.



Servo-driven, linear positioner guides paste dispensers for blade style fuses.



360° stripe of brazing paste applied to cylinder style fuses with single applicator