

Brazing & Soldering APPLICATION DATA

No. 548 – Evaporator Assembly

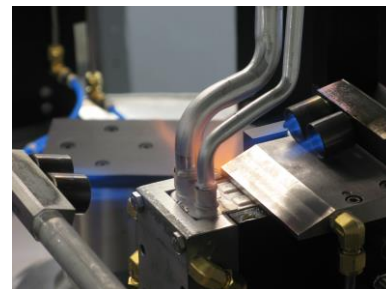


Brazing Machine Specifications

- **Assembly:** Two aluminum tubes to evaporator core (two styles).
- **Filler Metal:** Non-corrosive, flux core Aluminum/Silicon ring (AWS BAISI-4, ASTM 4047), 1080°F (582°C) liquidus.
- **Production Rate:** 125 parts per hour, one operator.
- **Dimensions:** 72" X 72" welded steel base, 36" dia. (stainless covered) aluminum tool plate, barrel cam indexer.
- **Utilities:** Electrical 460/3/60, Control voltage 24VDC, Natural Gas 30 CFH, Compressed Air 5 CFM.
- **Heating:** Gas/Air Blower heat stations on oscillating slides; automatic ignition of burners.
- **PLC:** Allen Bradley MicroLogix with PanelView Plus 600 Interface Panel, Ethernet capable.
- **Fixtures:** Stainless steel, water cooled.
- **Safety Features:** Lexan perimeter guarding on three sides of machine with safety interlocks; light curtain for E-stop function.
- **Options:** Temperature sensor for evaporator core, Programming port with receptacle. Galvanized vent hood.

Sequence:

- | | | |
|-----------|---|----------------------------------|
| Station 1 | - | Load/Unload Assembly |
| Station 2 | - | Sensors Detect Tubes-In-Position |
| Station 3 | - | Heat |
| Station 4 | - | Heat |
| Station 5 | - | Air Cool |
| Station 6 | - | Air Cool |



Precision gas/air burners melt filler metal at 1080°F, sealing joints.

Water cooled and shielded fixture preserves corrosion protective material on core during heat cycle.



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