

FUSION INCORPORATED

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BRAZE MATE **Dual Station** **Model 200** **Brazing/Soldering Machine**

SEQUENCE OF OPERATION:

- Operator loads assembly into stainless steel fixtures.
- Operator applies paste with automatic dispenser gun.
- Dual “touch” buttons actuate automatic heating/cooling cycle.
- Joined assembly unloaded by operator; rates up to 120/hr.



SPECIFICATIONS

CONSTRUCTION: Structural aluminum frame with clear acrylic guarding on three sides.

DIMENSIONS: 72”W x 56”D x 34” load height.

PASTE APPLICATOR: Three modes available: 1) Fully automatic, slide mounted, in-station. 2) Semi-automatic, off-station. 3) Hand held, automatic, in-station.

HEATING: Rigid steel gas train includes air pressure switch, gas flow meter, and manifold pressure gauges. Dual heat stations have independent slides and controls so different assemblies can be brazed or soldered simultaneously. Hi-Lo flame control to conserve fuel when heat manifolds are retracted and idle. Burners oscillate horizontally to provide even heating.

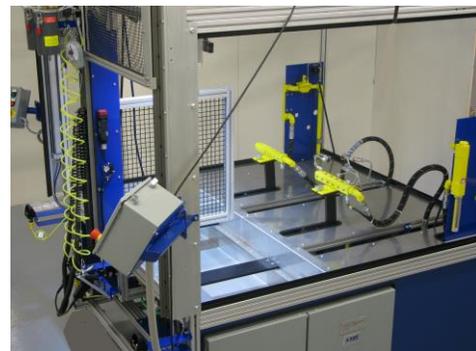
COOLING: Timed air and water sequence; water captured in stainless steel trough; *optional* water recirculating system available. (Water Recirculating System includes air driven pump with solid waste filter and cartridge flux filter.)

FIXTURES: Mounted on stainless steel “unistrut”.
Quotations based on assembly prints and parts.

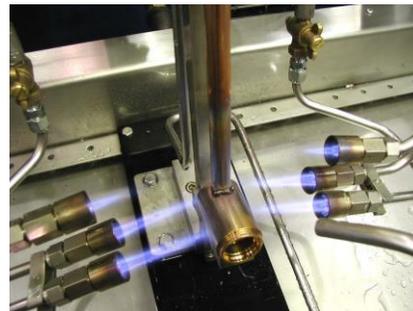
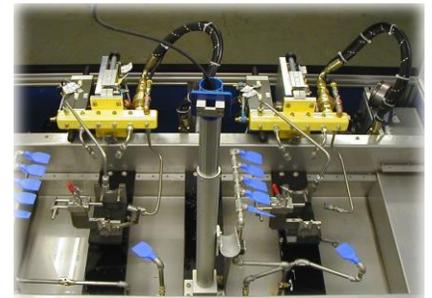
CONTROL: PLC with Operator Interface Panel to change timers and counters.

SAFETY FEATURES: Rigid mesh screens automatically move into position before heating/cooling cycle commences. Safety relays for E-Stop circuits, Electrical Interlocks on all doors.

UTILITIES: 120 volts, single phase, 5 amp; natural gas or propane; 80 psi air, water and drain.



Dual heat stations feature independent control and hi-lo flame to conserve fuel.



Oscillating burners eliminate “hot spots” during heating cycle.

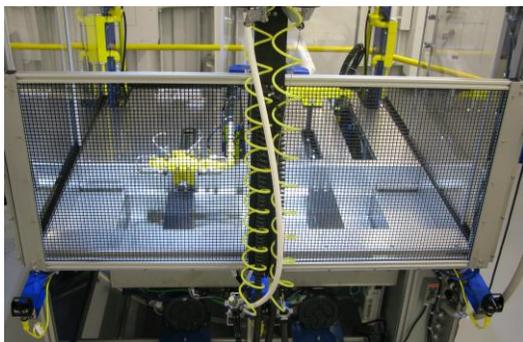
See Reverse Side for More Information

BRAZE MATE Model 200



STANDARD FEATURES

- Quick-disconnect manifolds require no tools to change, making part changeovers quick and easy.
- Fully adjustable manifold position makes machine configurable for most applications.
- Gas flowmeter and manifold manometer to verify process settings.
- Heat, air cool, and water cool time adjustable through operator interface.
- Needle valves installed on all air and water cooling outlets.
- Individual gascocks installed for each burner to allow individual flow adjustments or to turn burners on and off depending on part being processed.
- Stainless steel tubing used for burner pattern provides rigidity.
- Perimeter guarding provides safety and process stability and shielding from air currents.
- Polycarbonate windows allow for good visibility.
- Banner two-hand safety switches assure operator is clear of machine.
- All guard doors hinged for easy maintenance.
- All utility connections located together.
- Color-coded piping for gas lines, air lines, and water lines.
- Air dump valve with lockout for main air supply.
- Hi/Lo heat system conserves fuel by switching to low settings between cycles.
- Heat systems built to NFPA-79.
- CE marking available for European markets.
- Powder coated paint on painted surfaces.
- Isolation valves installed on incoming air and fuel source lines.
- Oscillating heat slide with adjustable stroke spreads heat throughout the joint area evenly.
- Stainless steel water trough.
- Access door for heat system adjustments.
- Safety pressure switches on heat system detect low gas pressure, high gas pressure, and low air pressure.
- Proximity switches installed on extend and retract positions of all slides.
- Quick disconnects on all proximity switches.
- Flow controls installed on all cylinders and slides.
- Air dump valves installed on all slides to assist with setups and adjustments.
- Paste tanks supplied with quick-release lid clamps.
- Paste guns controlled through the PLC to allow paste adjustments.
- Manual paste purge pushbuttons supplied for each paste gun.
- One spare paste gun supplied for each paste gun used.
- Free servicing of paste guns when Fusion paste products are used.
- PLC with human machine interface (HMI).
- Fault messages on HMI.
- Recipe function.
- Remote support hardware.
- 24VDC control voltage.
- Quick disconnect on proximity switches, pressure switches, and solenoid valves to make maintenance quick and simple.
- Leveling Feet.



Rigid safety screens are vertically driven.



Hinged doors provide easy access to utility and heat controls.