

Brazing & Soldering

APPLICATION DATA

No. 549 – Sprinkler Cover Plate Assembly



Soldering Machine Specifications

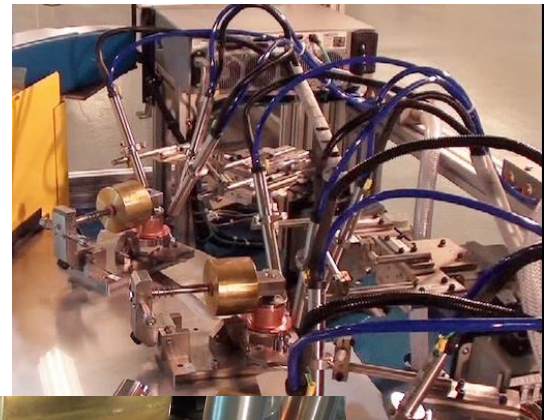
- **Assembly:** Cover plate, spring and skirt; painted and chromed brass (two types, 133°F, 165°F).
- **Filler Metal:** Fusion PAD-133-850 Solder Paste, 133°F (56°C) liquidus; also Fusion PAD-165-852 Solder Paste, 165°F (74°C) liquidus. 0.8 grams solder paste per assembly.
- **Paste Applicator:** Machine has (2) three gun applicator units, one for each paste type.
- **Production Rate:** 600 parts per hour, one operator.
- **Dimensions:** 110" X 94" welded steel base, 36" dia. (stainless covered) aluminum tool plate, barrel cam indexer.
- **Utilities:** Electrical 208/3/60, Control voltage 24VDC, Compressed Air 5 CFM.
- **Heating:** Electric, digital temperature controlled hot air tubes mounted on positioning slides. Cooling with vortex air nozzles.
- **Laser Marker:** Etches up to four lines of text while part is in fixture.
- **PLC:** Allen Bradley Compactlogix 5370 L2 with PanelView Plus 600 Interface Panel, Ethernet capable.
- **Safety Features:** Lexan perimeter guarding on three sides of machine with safety interlocks; light curtain at operator load station with E-stop function.

Sequence:

- | | | |
|------------|---|--------------------------------------|
| Station 1 | - | Auto Unload Soldered Assembly |
| Station 2 | - | Auto Load Cover Plate |
| Station 3 | - | Paste (133°F solder; 136°F optional) |
| Station 4 | - | Paste (165°F solder) |
| Station 5 | - | Manually Load Spring & Skirt |
| Station 6 | - | Laser Marking of Skirt |
| Station 7 | - | Hot Air Heat Slide |
| Station 8 | - | Hot Air Heat Slide |
| Station 9 | - | Hot Air Heat Slide |
| Station 10 | - | Cool Air Nozzle |
| Station 11 | - | Cool Air Nozzle |
| Station 12 | - | Fixture Hold Down Arm Release |



Three applicator guns dispense solder paste filler metal to cover plate



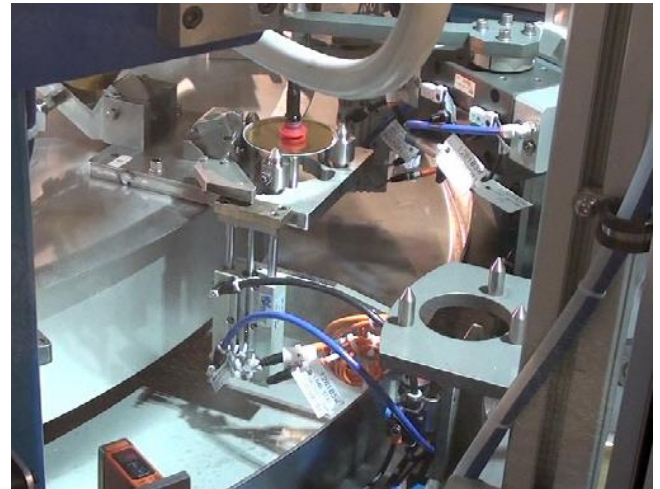
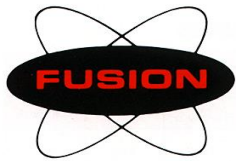
Hot air tubes progressively heat the assembly to solder liquidus temperature



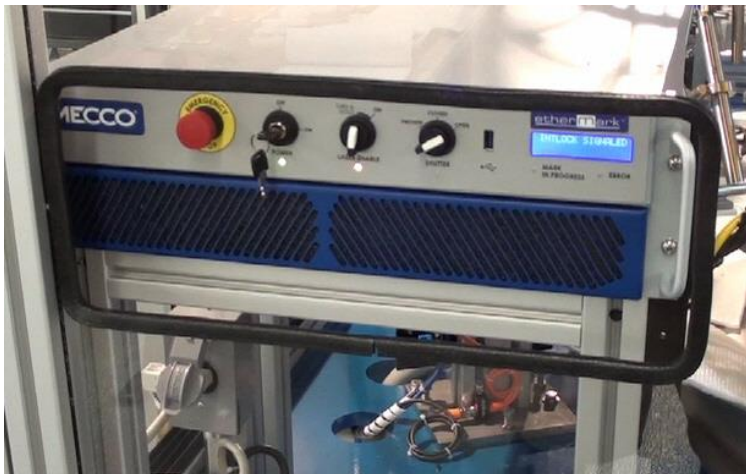
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See Reverse Side for More Information



Auto cover plate loader consists of rotary indexer that supports (4) stacks at 800 part capacity



Laser marker etches skirt with up to (4) lines of text while part is in the fixture



Auto unloader places soldered assembly onto twin rail gravity slide and onto exit conveyor