ROTARY INDEX Brazing/Soldering Model 100 Machine

SEQUENCE OF OPERATION:

- Operator loads assembly into stainless steel fixture.
- Deposit of paste alloy is applied automatically (or manually) to the joint area.
- Assembly indexes through a series of natural gas/air heat stations.
- Compressed air and water quench cools both the part and fixture for safe operator unloading.

SPECIFICATIONS

CONSTRUCTION: Structural aluminum frame with clear acrylic guarding on three sides; 20” dia. stainless steel dial with stainless water trough.

DIMENSIONS: 48”W x 48”D x 38” load height; guarding extends 40” beyond load height.

INDEXER: Cam-Driven indexer, 6 or 8-station.

PASTE APPLICATOR: Three modes available: automatic, hand-held, or off-station mounted.

HEATING: Three-station capacity; rigid steel gas train includes air pressure switch, gas flow meter, and manifold pressure gauges. High/Low gas/air system transitions to low flame when machine detects no parts have been loaded into fixture.

COOLING: Timed air and water sequence cools parts and fixtures; optional water recirculating system available.

CONTROL: PLC (A-B MicroLogix 1000) with MicroView Operator Interface Panel to change timers and counters.

UTILITIES: 120 volts, single phase, 5 amp; 24 VDC control voltage; natural gas or propane; 80 psi air, water and drain.

RATE: 100 – 200 parts per hour; dependent on assembly mass and configuration.

See Reverse Side for More Information
ROTARY INDEX
Model 100

STANDARD FEATURES

- Operator Station with PLC Interface makes part changes quick and easy while providing machine diagnostics for quick troubleshooting
- Heat manifolds are powder coated
- Gas Flowmeter and Manifold Manometer to verify process settings
- Heat, Air Cooling, and Water Cooling time adjustable through Operator Interface
- Needle Valves installed on all air and water cooling outlets
- Individual gas cock 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

- Guarding provides safety and process stability by shielding from air currents
- Guarding doors allow for easy maintenance
- Polycarbonate windows allow for good visibility
- 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
- Isolation valves installed on incoming air and fuel source lines
- 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
- 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 adjustment through the PLC
- Manual paste purge pushbuttons supplied for each paste gun
- 1 spare paste gun supplied for each paste gun used
- Free servicing of paste guns when Fusion paste products are used
- Allen-Bradley ControlLogix PLC with a PanelView Operator Interface
- 24VDC control voltage
- Quick Disconnect on proximity switches, pressure switches, and solenoid valves to make maintenance quick and simple.
- Leveling Feet
- Cam-Driven Indexer
- 0.75” Thick Aluminum Toolplate
- Stainless Steel Toolplate Cover
- Stainless Steel Water Trough