

Brazing & Soldering **APPLICATION DATA** No. 546 – Liquid Line Drier Assembly

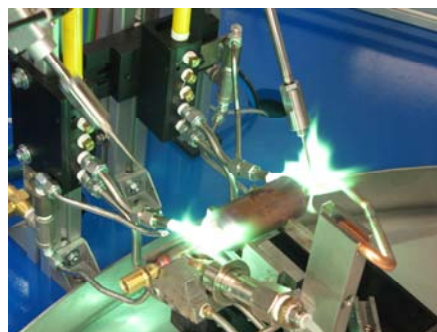
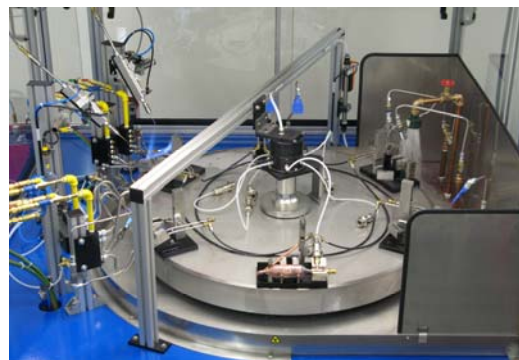


Wire Feed Brazing Machine Specifications

- ❑ **Assembly:** 25.4 mm dia. copper tube to copper drier and brass valve.
- ❑ **Wire Filler Metal:** Silvaloy 2M, 2Ag/91.50Cu/6.50P, 1190°F (645°C) liquidus.
- ❑ **Production Rate:** 125 parts per hour, one operator.
- ❑ **Dimensions:** 72" X 72" welded steel base, 42" dia. stainless steel tool plate cover, stainless water trough, Weiss TC 220 indexer.
- ❑ **Utilities:** Electrical 460/3/60, 5 amp, Control voltage 24VDC, Gas 96 CFH, Oxygen 192 CFH, Water 1 GPM, Compressed Air 5 CFM.
- ❑ **PLC:** Allen Bradley Micrologix 1500 with PanelView Plus 600 Interface Panel.
- ❑ **Tooling:** Adaptable to accommodate (4) part styles; water cooled.
- ❑ **Options:** Nitrogen purged through assembly during heating to control internal oxidation; sensor detects nitrogen flow. Gas flux to promote filler metal flow and reduce base metal discoloration. 100 gallon Water Recirculating System.
- ❑ **Safety Features:** Perimeter guarding on 3 sides of machine with safety interlocks. Light curtain for E-stop function.

Sequence:

- | | |
|-----------|-----------------------------|
| Station 1 | - Load/Unload Assembly |
| Station 2 | - Gas-Oxygen Heat |
| Station 3 | - Gas-Oxygen Heat/Wire Feed |
| Station 4 | - Air Cool |
| Station 5 | - Water Cool |
| Station 6 | - Air Blowoff |



Precision gas/oxygen heat pattern distributes filler metal evenly throughout tube joint areas.



Brazed assembly is water cooled for safe operator unloading.



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