



Brazing & Soldering

APPLICATION DATA

No. 513 – Rifle Bolt Assembly

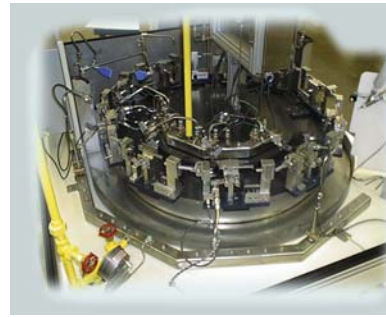


Brazing Machine Specifications

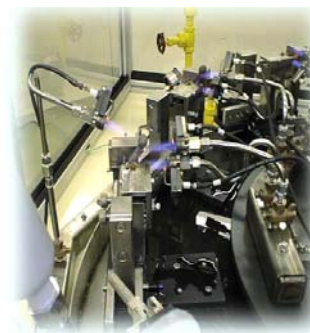
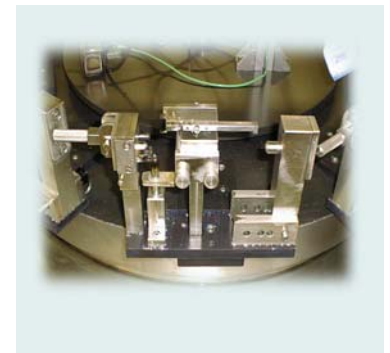
- ❑ **Assembly:** Two-piece bolt body to handle (carbon steel and stainless styles).
- ❑ **Paste Filler Metal:** Fusion LHK-1205-650
- ❑ **Production Rate:** 200 parts per hour.
- ❑ **Dimensions:** 65" X 65" welded steel base, 42" aluminum tool plate, PDC 18" direct drive indexer.
- ❑ **Utilities:** Electrical (460V) Gas (133 CFH) Water (1-2 gallons/minute) Compressed Air (57 CFM)
- ❑ **PLC:** Allen Bradley SLC 500 with operator interface.
- ❑ **Safety Features:** Lexan guards on 3 sides of machine with safety interlocks; light curtain-front of machine.
- ❑ **Options:** Vent hood, electronic flame ignition.
- ❑ **Sequence:**

- | | |
|------------|-------------------------------------|
| Station 1 | - Load/Unload assembly |
| Station 2 | - Apply paste automatically |
| Station 3 | - Heat |
| Station 4 | - Heat |
| Station 5 | - Heat |
| Station 6 | - Heat |
| Station 7 | - Air Cool |
| Station 8 | - Air cool part/water cool fixture |
| Station 9 | - Water cool part and fixture |
| Station 10 | - Air blast fixture to remove water |

10-station brazing machine operates at 200 parts per hour with one operator.



Stainless steel fixtures accommodate three bolt body lengths.



Inner and outer heat manifolds distribute filler metal throughout joint area.



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