



Brazing & Soldering **APPLICATION DATA** No. 537 – Carbide Tipped Tool Bits

Ask for



Video



Brazing Machine Specifications

- **Assembly:** Two-piece carbide and steel; 173 part numbers – 32 different carbide inserts, 1/4", 3/8", 5/16", 7/16", 1/2", 5/8", 3/4" steel shanks.
- **Paste Filler Metal:** Fusion STK-1260-750, cadmium-free (BAg 24), 1305°F (707°C) liquidus.
- **Production Rate:** 200 - 400 parts per hour, one operator.
- **Heat System:** Gas/Oxygen, 4-stations, independently controlled (no common manifold).
- **Dimensions:** 75" X 75" welded steel base, 42" dia. (stainless covered) tool plate, Weiss TC 220 indexer.
- **Utilities:** Electrical 460V/3PH/60Hz, Control voltage 24VDC, Gas 64 CFH, Oxygen 128 CFH, Water 1 GPM, Compressed Air 5 CFM.
- **PLC:** Allen Bradley SLC 550 with PanelView operator interface.
- **Safety Features:** Polycarbonate perimeter guarding with safety interlocks.
- **Options:** Three-axis adjustment on paste applicator; device permits incremental movement up to 2 1/2" in XYZ axes for part changeover. Part takeaway, stainless mesh belt conveyor. 100 Gallon Water Recirculating Cooling System. Vent Hood.

Sequence:

- | | |
|------------|---|
| Station 1 | - Paste applied to shank (off-station) and loaded with carbide insert into fixture. |
| Station 2 | - Open (Sense Parts) |
| Station 3 | - Heat |
| Station 4 | - Heat |
| Station 5 | - Heat |
| Station 6 | - Heat |
| Station 7 | - Air Cool |
| Station 8 | - Air Cool |
| Station 9 | - 5-Axis Automatic Pick & Place Unload |
| Station 10 | - Water Cool (Fixtures) |
| Station 11 | - Water Cool/Air Blast |
| Station 12 | - Open |



Applicator gun dispenses premeasured deposit of paste filler metal to shank.



Precision, gas/oxygen burner pattern distributes filler metal throughout joint area.



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