



Brazing & Soldering **APPLICATION DATA** No. 539 – Brass Faucet Assemblies



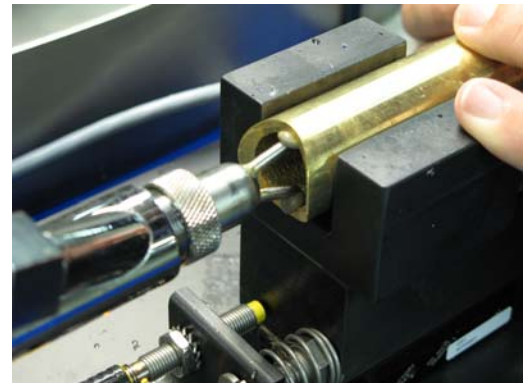
Brazing Machine Specifications

- **Assembly:** Two-piece brass/brass faucet body.
- **Paste Filler Metal:** Fusion LHK-1205-650 (Bag 7) 1205°F (651°C) liquidus.
- **Production Rate:** 50 parts per hour, one operator.
- **Dimensions:** 72" X 72" welded steel base, 42" dia. (stainless covered) tool plate, stationary outer/inner heat manifolds, Weiss TC 220 indexer.
- **Utilities:** Electrical 480/3/60, Control voltage 24VDC, Gas 192 CFH, Water 1 GPM, Compressed Air 37 CFM.
- **PLC:** Allen Bradley SLC 500 with Panel View Interface Panel.
- **Safety Features:** Lexan perimeter guarding on three sides of machine with safety interlocks.

Sequence:

- Station 1 - Load/Unload Assembly*
- Station 2 - Open
- Station 3 - Heat
- Station 4 - Heat
- Station 5 - Heat
- Station 6 - Heat
- Station 7 - Air Cool
- Station 8 - Water Cool
- Station 9 - Water Cool
- Station 10 - Open

* Brazing paste applied off-station prior to loading at Station 1.



Applicator gun dispenses two deposits of brazing paste to joint area.



Precision heat pattern distributes filler metal throughout the joint, resulting in leak-free joints.



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