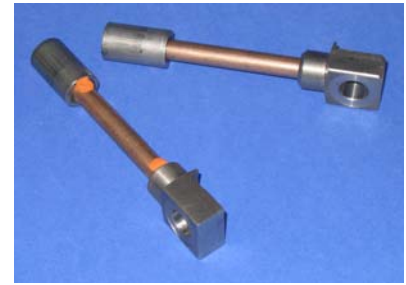


# Brazing & Soldering

## APPLICATION DATA

No. 530 – Antilock Brake Assembly

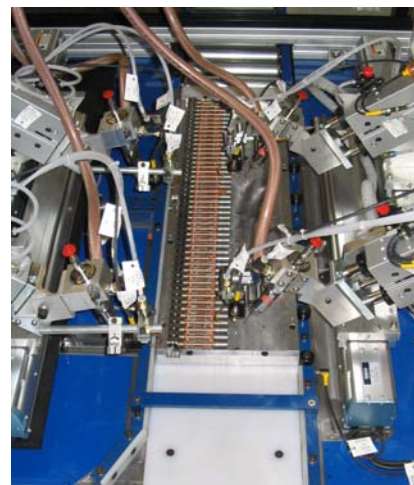


### Automatic Paste Application System Specifications

- ❑ **Assembly:** 5/16" (8 mm) steel tube to two connectors.
- ❑ **Paste Filler Metal:** Fusion EXO-1900W-710, fluxless copper (AWS BCu-1a) 1980°F liquidus.
- ❑ **Production Rate:** 6,200 assemblies per hour
- ❑ **Dimensions:** 50" x 52" welded steel frame with casters; 37" load height.
- ❑ **Utilities:** Electrical 220 VAC, 1 Phase; Compressed air (10 CFM)
- ❑ **PLC:** Allen Bradley Panel View 300 with operator interface.
- ❑ **Safety Features:** Sliding Lexan® guards on 3 sides of machine with Interlock switches; light curtain for E-Stop function.
- ❑ **Options:** Low-level paste sensing device mounted to 6 gallon reservoir alerts operator with visual signal. Entry and exit roller conveyors.

#### Sequence:

1. Operator loads 46 brake assemblies into locating fixture.
2. Fixture is positioned under four, single-axis robots. FE-71 applicator gun mounted to each robot; robots/guns parallel to each other.
3. Touch button actuates pasting sequence; 92 deposits of paste applied to assemblies in 23 seconds.
4. Operator pushes fixture out of pasting machine onto gravity conveyor to second operator who transfers parts to atmosphere furnace.



*Single axis robots guide applicator guns to dispense paste filler metal to tube joints.*



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