

Brazing & Soldering **APPLICATION DATA** No. 544 - Medical Components



Rotary Model 100 Brazing Machine Specifications

- Assembly: Two solid stainless steel pieces, .375" dia. X 2.25" length.
- Paste Filler Metal: Fusion APW-1205-750 (BAg 7), 1205°F (651°C) liquidus.
- **Production Rate:** 150 parts per hour, one operator.
- **Dimensions:** 48" X 48" aluminum extrusion frame, 23" dia. stainless tool plate, Stainless water trough, Weiss TC 150 indexer, 8 station.
- Heating System: Three station, gas/air, rigid steel network includes air pressure switch, gas flow meter, and manifold pressure gauges. High/Low system transitions to low flame when machine detects no parts have been loaded into fixture.
- Utilities: Electrical 120/1/60, Control voltage 24VDC, 5 Amps, Water (1 GPM), Propane (64 CFH), Compressed Air (12 CFM).
- PLC: Allen Bradley MicroLogix 1200 with PanelView Plus 400 Interface.
- Safety Features: Lexan perimeter guarding on three sides of machine with safety interlocks. Light curtain for E-stop function. Vent hood for fume extraction.

Sequence:

Station 1	-	Load/Unload Assembly
Station 2	-	Apply Braze Paste
Station 3	-	Heat
Station 4	-	Heat
Station 5	-	Heat
Station 6	-	Air Cool
Station 7	-	Water Cool
Station 8	-	Air Blow Off



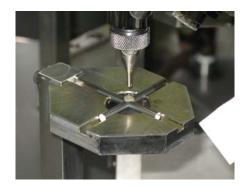
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8-station brazing machine operates at 150 parts per hour with one operator







Applicator gun dispenses premeasured deposit of brazing paste to joint area

Gas/air burners bring filler metal to 1205°F liquidus to bond the stainless pieces

