



Brazing & Soldering

APPLICATION DATA

No. 529 – Multi-Component,
Stainless Fuel Assembly

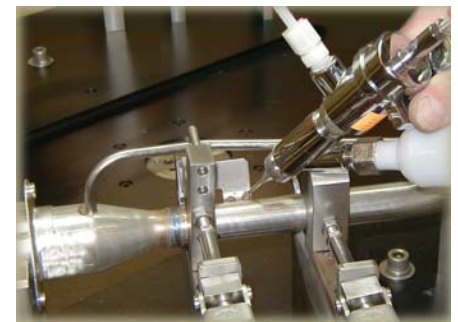
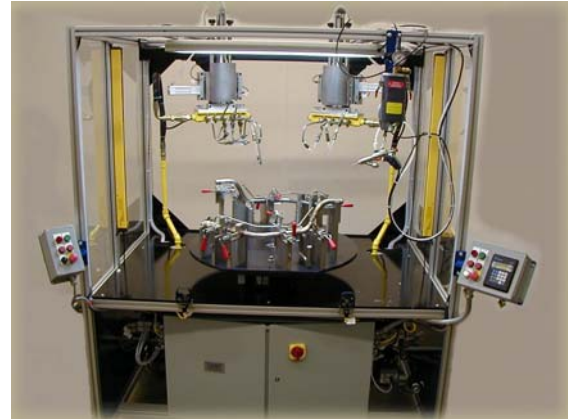


Two-Station "Braze Mate" Model 200 Machine Specifications

- ❑ **Assembly:** 304 stainless vent tube and four brackets to fuel filler neck (total: 6 components, 5 solder joints)
- ❑ **Paste Filler Metal:** Fusion WSU-1260-650, cadmium-free, (AWS Bag 24), 1305°F liquidus.
- ❑ **Production Rate:** 90 parts per hour, one operator.
- ❑ **Dimensions:** 72"W x 56"D x 38" load height; Weiss TC 220 indexer with 36" dia. tooling plate.
- ❑ **Utilities:** 120V, 5 amp, single phase; 120 CFH natural gas; 23 CFM air.
- ❑ **PLC:** Allen-Bradley MicroLogix 1000 with DTAM access panel.
- ❑ **Safety Features:** Polycarbonate perimeter guarding on 3 sides of machine with safety interlocks; light curtain.

Sequence:

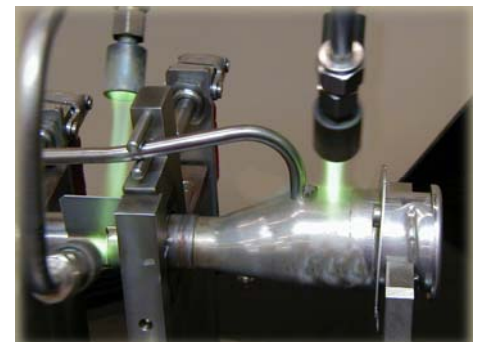
1. Operator loads components into first of two stainless steel fixtures with De-Sta-Co style clamps.
2. Operator dispenses paste filler metal to joint areas with hand-held applicator gun.
3. Operator presses touch buttons to index assembly 180°.
4. Gas/air burners advance into position, adjust to high flame output, and bring filler metal to brazing temperature on all joints.
5. Heat cycle (30 seconds) times out, burners retract into low flame condition.
6. During heat cycle, operator is loading and applying paste to assembly on second fixture.
7. Operator presses touch buttons, table indexes 180°, and brazed assemblies are unloaded.



Premeasured deposits of silver paste filler metal applied to joint areas.



Operator positions vent tube into 27" long filler tube on locating fixture.



Gas flux-enriched burners oscillate to eliminate "hot spots" during heating cycle.



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