



Soldering Machine Specifications

- Assembly: Two-piece steel cylinder/bracket; left and right hand styles.
- Paste Filler Metal: Fusion LHK-1205-650 (Bag 7), 1205°F (651°C) liquidus.
- **Production Rate:** 450 parts per hour, one operator.
- Dimensions: 64" X 60" welded steel base, 36" dia. aluminum tool plate, stainless water trough, Weiss TC 220 indexer.
- Utilities: Electrical 460/3/60, Control voltage 24VDC, Gas 155 CFH, Water 1 GPM, Compressed Air 28 CFM.
- PLC: Allen Bradley SLC 5/03 with PanelView 550
 Interface Panel.
- Tooling: Two sets of fixtures for each part style. Two interchangeable heating manifolds for ease of conversion.
- Options: Two-axis adjustment on paste applicator; device permits incremental movement up to 2 ¹/₂" in both (XY) axes; for machine changeover.

Sequence:

Station 1	-	Load/Unload Assembly
Station 2	-	Open
Station 3	-	Paste
Station 4	-	Heat
Station 5	-	Heat
Station 6	-	Heat
Station 7	-	Heat
Station 8	-	Heat
Station 9	-	Air Cool
Station 10	-	Water Cool
Station 11	-	Water Cool
Station 12	-	Air Blow Off



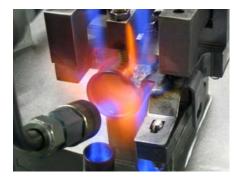
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Applicator gun dispenses preset deposit of paste filler metal to joint area.





Precision heat pattern distributes filler metal evenly throughout joint interface.