



Brazing & Soldering **APPLICATION DATA** No. 533 – Air Bag Brackets



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 ½" 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 |



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



Precision heat pattern distributes filler metal evenly throughout joint interface.



FUSION INCORPORATED

4658 E. 355th St., Willoughby, OH 44094
Phone 1-800-626-9501 • (440) 946-3300
Fax (440) 942-9083 • e-mail: info@fusion-inc.com
Web: www.fusion-inc.com