

# Brazing & Soldering **APPLICATION DATA** No. 534 – Tube/Sleeve Assemblies

Ask for

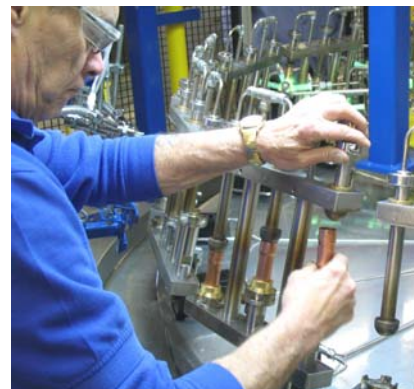
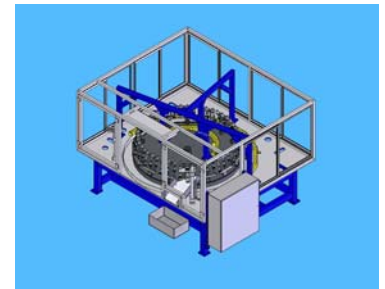


## Brazing Machine Specifications

- **Assembly:** Two-piece copper and brass; six part numbers, tube diameter 1/2" – 7/8".
- **Paste Filler Metal:** Fusion LHK-1306-800 (BCuP4), 1325°F (718°C) liquidus.
- **Production Rate:** 1,300 parts per hour, one operator; 11 second cycle time, 16 fixtures.
- **Dimensions:** 106" X 114" welded steel base, 60" dia. (stainless covered) tool plate, Weiss TR 750 "ring" indexer.
- **Utilities:** Electrical 460/3/60, Control voltage 24VDC, Gas 336 CFH, Compressed Air 66 CFM, Water 1 GPM.
- **PLC:** Allen Bradley SLC 550 with Panel View operator interface.
- **Safety Features:** Wire mesh perimeter guarding with safety interlocks; light curtain for E-stop function.
- **Options:** Nitrogen purge interior tube walls; gas flux to reduce copper oxidation during heating.

### Sequence:

- |            |   |                     |
|------------|---|---------------------|
| Station 1  | - | Load (3) Assemblies |
| Station 2  | - | Open                |
| Station 3  | - | Paste               |
| Station 4  | - | Open                |
| Station 5  | - | Heat                |
| Station 6  | - | Heat                |
| Station 7  | - | Heat                |
| Station 8  | - | Heat                |
| Station 9  | - | Heat                |
| Station 10 | - | Heat                |
| Station 11 | - | Heat                |
| Station 12 | - | Air Cool            |
| Station 13 | - | Water Cool          |
| Station 14 | - | Water Cool          |
| Station 15 | - | Auto Eject          |
| Station 16 | - | Open                |



*Operator loads 3 parts into each fixture.*

*Inner/Outer heat manifolds achieve strong joints with complete filler metal penetration.*



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