

Brazing & Soldering **APPLICATION DATA**

No. 542 - Tubular Heating Elements



"Braze Mate" Model 100 **Machine Specifications**

- Assembly: Incoloy tubular heating element to stainless or mild steel flange.
- Paste Filler Metal: Fusion STL-1260-650 (BAg 24), 1305°F/707°C liquidus.
- **Production Rate:** 30 parts per hour, one operator.
- **Dimensions:** 36"W x 48"D x 34" load height.
- Utilities: 120V, single phase, 5 Amp, 24VDC; natural gas (48 CFH); 80 psi air (9 CFM); water (1 gallon/minute) and drain.
- PLC: Allen Bradley MicroLogix with AB PanelView operator interface.
- Safety Features: Perimeter guarding on 3 sides of machine with safety interlocks.

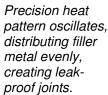
Sequence:

- 1. Operator loads heating element and flange into stainless steel fixture.
- 2. Operator dispenses paste filler metal to joint areas with hand-held applicator gun.
- 3. Touch switches pressed to actuate automatic brazing cycle.
- 4. Gas/air burners advance into position, adjust to high flame output, and bring filler metal to brazing temperature.
- 5. Heat cycle times out, burners retract into low flame condition.
- 6. Timed air and water cooling.
- Operator removes brazed assembly and repeats the cycle.





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







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