



Brazing & Soldering **APPLICATION DATA** No. 513 – Rifle Bolt Assembly

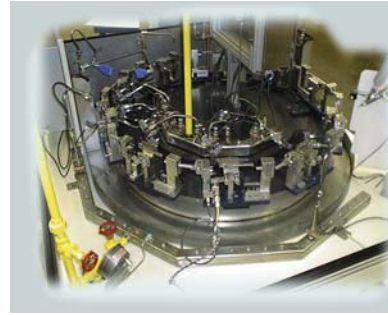


Brazing Machine Specifications

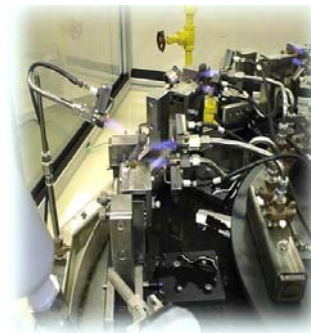
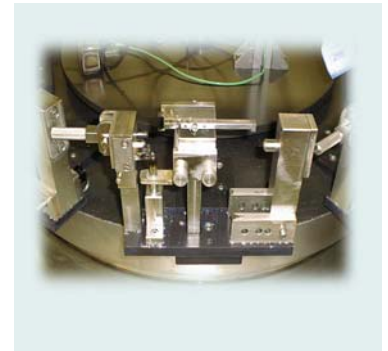
- ❑ **Assembly:** Two-piece bolt body to handle (carbon steel and stainless styles).
- ❑ **Paste Filler Metal:** Fusion LHK-1205-650
- ❑ **Production Rate:** 200 parts per hour.
- ❑ **Dimensions:** 65" X 65" welded steel base, 42" aluminum tool plate, PDC 18" direct drive indexer.
- ❑ **Utilities:** Electrical (460V) Gas (133 CFH) Water (1-2 gallons/minute) Compressed Air (57 CFM)
- ❑ **PLC:** Allen Bradley SLC 500 with operator interface.
- ❑ **Safety Features:** Lexan guards on 3 sides of machine with safety interlocks; light curtain-front of machine.
- ❑ **Options:** Vent hood, electronic flame ignition.
- ❑ **Sequence:**

| | |
|------------|-------------------------------------|
| Station 1 | - Load/Unload assembly |
| Station 2 | - Apply paste automatically |
| Station 3 | - Heat |
| Station 4 | - Heat |
| Station 5 | - Heat |
| Station 6 | - Heat |
| Station 7 | - Air Cool |
| Station 8 | - Air cool part/water cool fixture |
| Station 9 | - Water cool part and fixture |
| Station 10 | - Air blast fixture to remove water |

*10-station
brazing machine
operates at 200
parts per hour
with one
operator.*



*Stainless steel
fixtures
accommodates
three bolt body
lengths.*



*Inner and outer
heat manifolds
distribute filler
metal throughout
joint area.*



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