



Brazing & Soldering

APPLICATION DATA

No. 514 – Aluminum Manifold Assembly



Brazing Machine Specifications

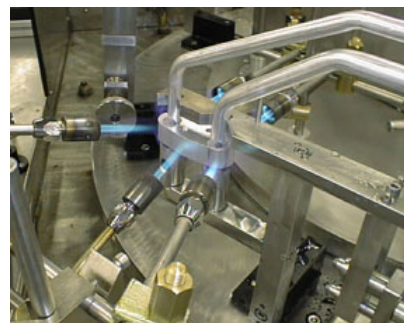
- ❑ **Assembly:** Two (3003 series) tubes to (6063 series) block.
- ❑ **Paste Filler Metal:** Fusion NDA-1070-400 (corrosive flux)
- ❑ **Production Rate:** 200 parts per hour, one operator.
- ❑ **Dimensions:** 70" X 70" welded steel base, 42" diameter aluminum tool plate, PDC 18" direct drive indexer.
- ❑ **Utilities:** Electrical 208V, 3PH, 60HZ (415V, 3PH, 50HZ), Control Voltage 24VDC, Gas (80 CFH) Water (1-2 gallons/minute) Compressed Air (30 CFM)
- ❑ **PLC:** General Electric 90/30.
- ❑ **Safety Features:** Sliding Lexan® guards on 3 slides of machine with safety interlock switches; light curtain mounted at operator station.
- ❑ **Options:** Inconel fixtures; machine built to CE European specifications.
- ❑ **Sequence:**
 - Station 1 - Load/Unload Assembly
 - Station 2 - Apply Paste Automatically
 - Station 3 - Heat
 - Station 4 - Heat
 - Station 5 - Heat
 - Station 6 - I.D. Water Flush
 - Station 7 - Water Cool Part & Fixture
 - Station 8 - Air Blast Fixture to Remove Water



Two applicator guns dispense four deposits of paste filler metal to both joint areas.



Inner and outer heat manifolds distribute filler metal throughout joint areas.



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