



Brazing & Soldering

APPLICATION DATA

No. 530 – Antilock Brake Assembly

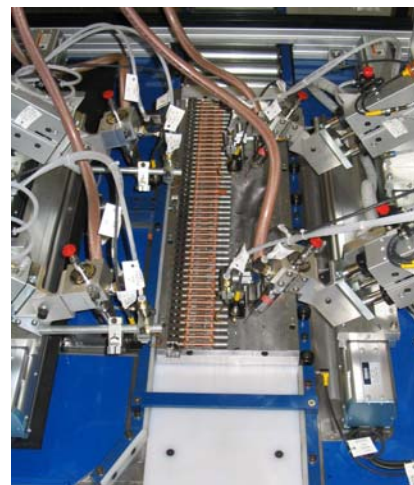


Automatic Paste Application System Specifications

- ❑ **Assembly:** 5/16" (8 mm) steel tube to two connectors.
- ❑ **Paste Filler Metal:** Fusion EXO-1900W-710, fluxless copper (AWS BCu-1a) 1980°F liquidus.
- ❑ **Production Rate:** 6,200 assemblies per hour
- ❑ **Dimensions:** 50" x 52" welded steel frame with casters; 37" load height.
- ❑ **Utilities:** Electrical 220 VAC, 1 Phase; Compressed air (10 CFM)
- ❑ **PLC:** Allen Bradley Panel View 300 with operator interface.
- ❑ **Safety Features:** Sliding Lexan® guards on 3 sides of machine with Interlock switches; light curtain for E-Stop function.
- ❑ **Options:** Low-level paste sensing device mounted to 6 gallon reservoir alerts operator with visual signal. Entry and exit roller conveyors.

Sequence:

1. Operator loads 46 brake assemblies into locating fixture.
2. Fixture is positioned under four, single-axis robots. FE-71 applicator gun mounted to each robot; robots/guns parallel to each other.
3. Touch button actuates pasting sequence; 92 deposits of paste applied to assemblies in 23 seconds.
4. Operator pushes fixture out of pasting machine onto gravity conveyor to second operator who transfers parts to atmosphere furnace.



Single axis robots guide applicator guns to dispense paste filler metal to tube joints.



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