



## Brazing & Soldering

# APPLICATION DATA

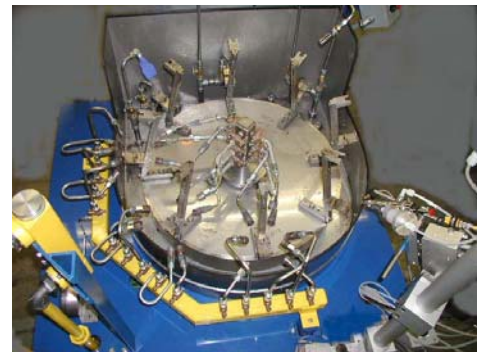
No. 522 – Medical Gas Valve Assembly



### Brazing Machine Specifications

- ❑ **Assembly:** Two-piece, ½" O.D. copper tube to brass body.
- ❑ **Paste Filler Metal:** Fusion STK-1205-750 (BAg 7)
- ❑ **Production Rate:** 250 parts per hour, one operator.
- ❑ **Dimensions:** 48" X 48" welded steel base, 26" dia. aluminum tool plate, stainless water trough, PDC 15" direct drive indexer.
- ❑ **Utilities:** Electrical (460 VAC, 3PH), Control voltage 24VDC, Gas (144 CFH) Water (1 gallon/minute) Compressed air (28 CFM).
- ❑ **PLC:** Allen Bradley MicroLogix 1200 with MicroView operator interface.
- ❑ **Options:** Two-axis adjustment on paste applicator slide; device permits incremental movement up to 2 ½" in both (XY) axes.
- ❑ **Sequence:**
  - Station 1 - Load/Unload Assembly
  - Station 2 - Apply Paste Automatically
  - Station 3 - Heat
  - Station 4 - Heat
  - Station 5 - Heat
  - Station 6 - Air Cool
  - Station 7 - Water Cool
  - Station 8 - Water Cool

*8-station  
brazing  
machine  
operates at  
250 parts per  
hour with one  
operator.*



*Applicator gun  
dispenses two  
premeasured  
deposits of  
paste filler  
metal to joint  
area.*

*Inner and outer  
manifolds provide  
balanced heat  
pattern to bring  
filler metal to  
1205°F liquidus  
and seal joint.*



### FUSION INCORPORATED

4658 E. 355<sup>th</sup> St., Willoughby, OH 44094  
Phone 1-800-626-9501 • (440) 946-3300  
Fax (440) 942-9083 • e-mail: info@fusion-inc.com  
Web: www.fusion-inc.com