

APPLICATION DATA

No. 802 - Soldering Cell



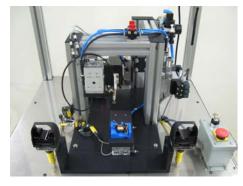
Single Station Soldering Cell Specifications

- Millivolt Assembly: Tinned copper magnet wire to tinned, interconnect terminal.
- Wire Filler Metal: 99.3Sn/0.7Cu, rosin base flux core, 439°F (227°C) liquidus.
- Production Rate: 360 parts per hour, one operator.
- **Dimensions:** 30" W x 27" L x 35" H, bench top aluminum extruded frame, compact 3 kW induction unit.
- Utilities: Electrical Induction unit 240/1/60, Machine 120/1/60, Control voltage 24VDC, Compressed Air ¼ NPT, 80-100 psi.
- Control: TECO SG2 smart relay.
- Safety Features: Two hand, anti-tie-down buttons, Lexan guarding between operator and wire feed mechanism.

Sequence:

- 1. Operator loads the assembly.
- 2. Part slide moves part behind shield (removed in photos) into soldering position.
- 3. Induction coil extends into heating position and begins timed cycle.
- 4. Wire feed slide extends down and feeds a precise amount of solder wire, as measured by Fusion's wire verification unit.
- 5. Wire feed and induction units retract.
- 6. Operator unloads the soldered part and repeats the cycle.









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