



Brazing & Soldering APPLICATION DATA

No. 538 – Torque Converter Shells

Ask for

Video

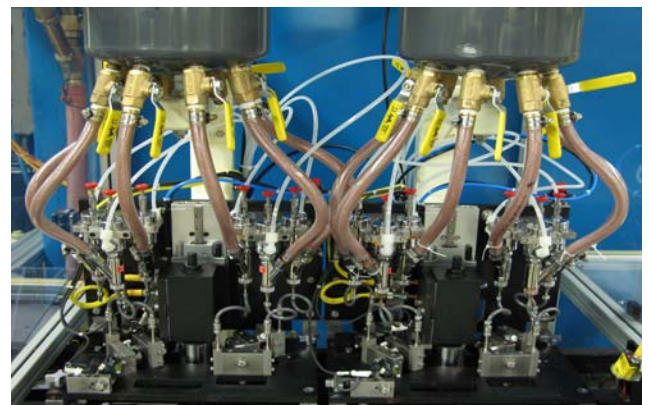


Two Station Paste Application System Specifications

- **Assembly:** 9 1/2", 10", 248 mm steel impeller shell assemblies.
- **Paste Filler Metal:** Fusion 2BY-1900WF-780, fluxless copper (AWS BCu-1a) 1980°F/1082°C liquidus.
- **Production Rate:** 360 assemblies per hour; joints per assembly: 31 blades x 3 rows.
- **Dimensions:** 68"W x 60"D x 40" load height.
- **Utilities:** Electrical 480 VAC, 3 Phase; Compressed air (80 PSI)
- **PLC:** Allen Bradley 5/04 with Panel View 1000 color operator interface.
- **Safety Features:** Lexan® perimeter guarding with interlocked door.

Sequence:

1. Torque converter shells enter pasting system on driven feed conveyor.
2. Two shells are metered into the paste area where spindle servo motors engage the shell center hole.
3. Shells rotate as (12) dispenser guns apply 93 "dot" deposits to the joint areas. (Two complete shells every twenty seconds)
4. After pasting, shells exit the pasting area onto the roller conveyor for processing in an atmosphere brazing furnace.



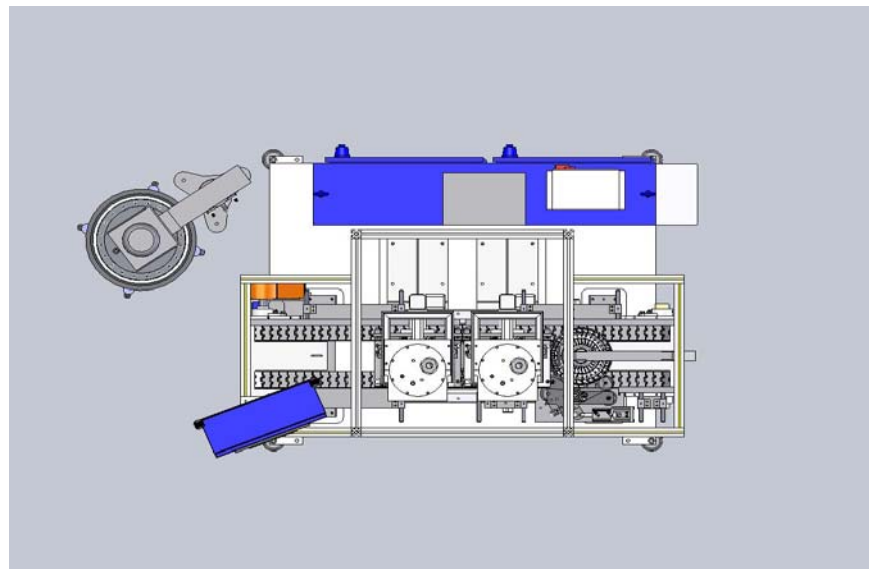
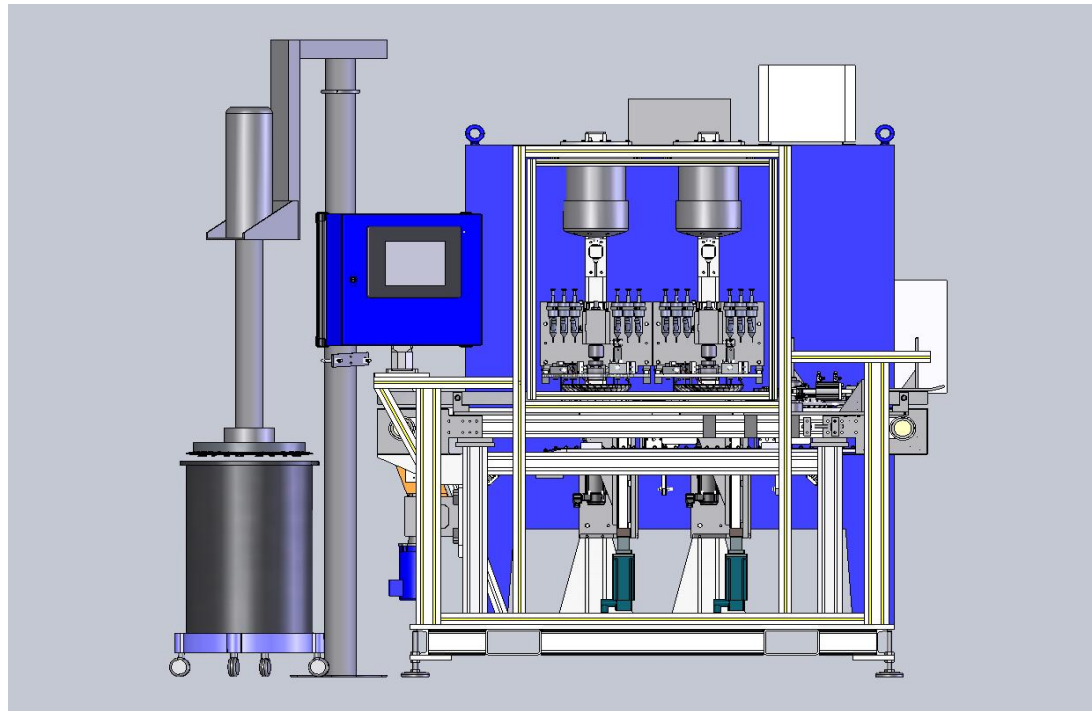
Twelve dispenser guns apply 93 accurate paste deposits in 20 seconds.



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See Reverse Side for 3-D System Drawings



Two Station Paste Application System Special Features

- Paste is automatically pumped from 30 gallon containers into (2), two gallon capacity reservoirs. Level of reservoirs is maintained automatically.
- Dispenser guns mounted on quick-adjust mounting plates.
- Vision system with cylinders and rotary actuators to reposition paste nozzles for different part configurations and sizes.
- Quick changeover procedure so system can run all part sizes efficiently.

