



## 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.

