



"MANUFACTURERS OF THE MOST COMPLETE LINE  
OF FLUX HANDLING EQUIPMENT IN THE WORLD"

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**NOTE:** For diagrams of flux recovery system configurations, see the "Heavy Duty" section of the catalog and look in the Technical Bulletin "TB-MM708," or call us for engineering assistance. (Ask us to send you the "TB-MM708" if it is not available to you.)

### ACCESSORIES FOR MIGHTY-MAC VACUUMS

1. **FD-55 DUST DRUM.**



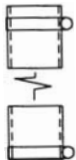
The FD-55 is a dust drum with sealed lid and 3-1/2" hose fitting for dust collection (i.e. includes LID-55 and DHK-55 dust hose kit. See item no. 2 and 3 below). It has a 55 gallon capacity and is used with the MM-1500X/P, MM-3000X/P, MM-5000X/P, and MM-5000X-MILL vacuum.

2. **LID-55 DUST DRUM LID.**



The LID-55 dust drum lid fits standard **heavy duty** 55 gallon drum. Includes lid to drum ring clamp. (Also recommend ordering DHK-55 hose Kit below.)

3. **DHK-55 DUST HOSE KIT.**



The DHK-55 Dust hose kit includes 5 feet of 3 1/2" dust hose and two hose clamps for attachment to LID-55. (Included with FD-55; not included with LID-55.)

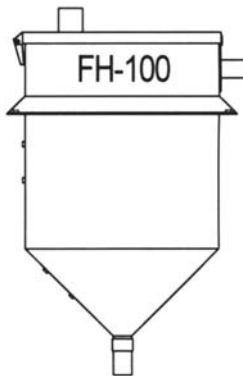


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#### 4. FH-100 FLUX HOPPER/SEPARATION CHAMBER.



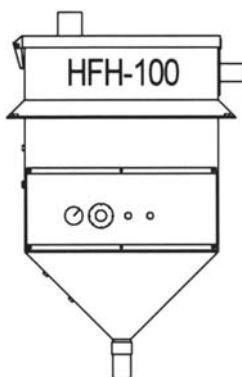
The FH-100 Flux Hopper/Separation Chamber has approximately a 200 lb. capacity with a slag tray, two large sight window level indicators, a filter which prevents slag from being drawn into the vacuum unit, and vacuum control valve. (See MAGSEP-100 for optional magnetic separator.) (See Technical Bulletin TB-MM708 figure nos. 2, 9, 10, 11, 12, 13, 14, 15, 17, and 18.)

**FH-300** Flux Hopper/Separation Chamber is same as above except the FH-300 has a 300 lb. capacity.

**FH-600** Flux Hopper/Separation Chamber is same as above except the FH-600 has a 600 lb. capacity.

**FH-1000** Flux Hopper/Separation Chamber is same as above except the FH-1000 has a 1000 lb. capacity.

#### 5. HFH-100 HEATED FLUX HOPPER/SEPARATION CHAMBER.



The HFH-100 Heated Flux Hopper/Separation Chamber is same as item no.4, except heated. Continuous control to 250°F (121°C.) Please specify voltage, 115v/1ph/50-60hz or 220v/1ph/50-60hz. (See MAGSEP-100 for optional magnetic separator.) (See Technical Bulletin TB-MM708 figure nos. 2, 9, 10, 11, 12, 13, 14, 15, 17, and 18.)

**HFH-300** Heated Flux Hopper/Separation Chamber is the same as above except the HFH-300 has a 300 lb. capacity.

**HFH-600** Flux Hopper/Separation Chamber is same as above except the HFH-600 has a 600 lb. capacity.

**HFH-1000** Flux Hopper/Separation Chamber is same as above except the HFH-1000 has a 1000 lb. capacity.

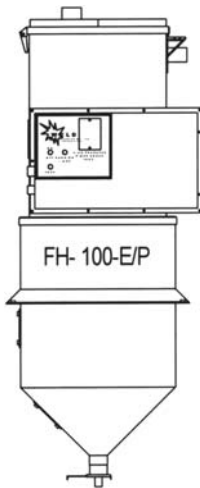


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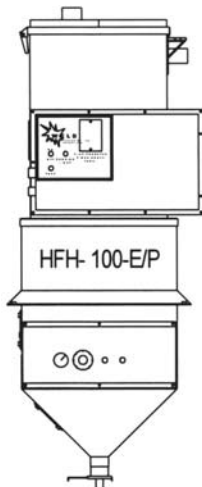
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**6. FH-100-E/P AND HFH-100-E/P AUTOMATIC FLUX HOPPER/SEPARATION CHAMBER.**



The FH-100-E/P is a fully automatic submerged arc flux hopper/separator. It has approximately a 200 lb. flux capacity with auto flux transfer to a lower chamber within the FH-100-E/P. This enables the FH-100-E/P not to be sensitive to "Head Height" as the standard FH-100 is, and allows placing the unit in any convenient position over the welding torch. (See Technical Bulletin TB-MM708, figure nos. 2, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19 and 20) (See MAGSEP-100-E/P for optional magnetic separation.)

**FH-300-E/P** Automatic Flux Hopper/Separation Chamber is the same as above except the FH-300-E/P has a 300 lb. capacity.



**HFH-100-E/P** Heated Automatic Flux Hopper/Separation Chamber Same as above, except heated. Continuous control to 250°F (121°C). Please specify voltage, 115v/1ph/50-60hz or 220v/1ph/50-60hz. (See MAGSEP-100-E/P for optional magnetic separation.)

**HFH-300-E/P** Heated Automatic Flux Hopper/Separation Chamber. Same as above HFH-100-E/P, except it has a 300 Lb. capacity. Continuous control to 250°F(121°C). Please specify voltage, 115v/ 1ph/ 50-60hz or 220v/1ph/50-60hz. (See MAGSEP-100-E/P for optional magnetic separation.)

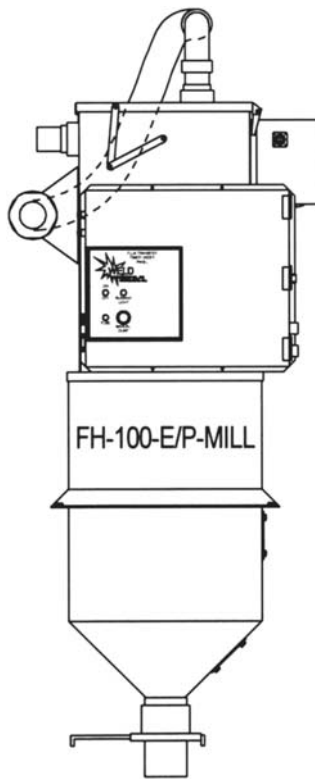


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## 7. FH-100-E/P-MILL AUTOMATIC FLUX HOPPER/SEPARATION CHAMBER



The **FH-100-E/P-MILL** is a fully automatic submerged arc flux hopper/separator. It is made extremely rugged with rubber lined walls for abrasion resistance and specially designed flux transfer valve and automatic vacuum line shutoff valve for rapid flux transfer. It has approximately a 200 lb. flux capacity with auto flux transfer to a lower chamber within the FH-100-E/P-MILL. This enables the FH-100-E/P-MILL not to be sensitive to "Head Height" as the standard FH-100 is, and allows placing the unit in any convenient position over the welding torch. (Call factory for diagrams showing applications in "Pipe Mill" or other very heavy duty application.) (Please see Technical Bulletin TB-MM708 Figure 35 and 36.)

**HFH-100-E/P-MILL** Heated Automatic Flux Hopper/Separation Chamber. Same as above except heated. Continuous control to 250°F (121°C). Please specify voltage, 115v/1ph/50-60hz or 220v/1ph/50-60hz. (See MAGSEP-100-E/P for optional magnetic separation.)



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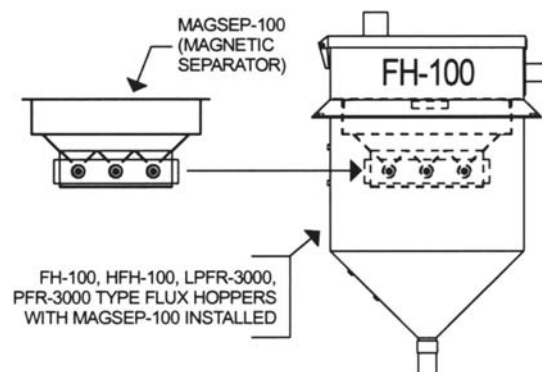
#### **NOTE FOR ITEMS 4, 5, 6 & 7**

**A.)** For two (2) flux recovery hose inlets (standard is one {1}), an additional cost is added to FH-100, FH-300, FH-600, FH-1000, HFH-100, HFH-300, HFH-600, HFH-1000, FH-100-E/P, FH-300-E/P, HFH-100-E/P or HFH-300-E/P prices. (Not recommended for FH-100-E/P-MILL and HFH-100-E/P-MILL.)

**B.)** For two (2) flux dispensing outlets (standard is one {1}), add an additional cost is added to FH-100, FH-300, FH-600, FH-1000, HFH-100, HFH-300, HFH-600, HFH-1000, FH-100-E/P, FH-300-E/P, HFH-100-E/P or HFH-300-E/P prices. (Not recommended for FH-100-E/P-MILL and HFH-100-E/P-MILL.)

#### **C.) MAGSEP-100 MAGNETIC SEPARATOR.**

MAGSEP-100 Magnetic Separator for FH-100, FH-300, FH-600, FH-1000, HFH-100, HFH-300, HFH-600, HFH-1000, LPFR-3000, PFR-3000, HLPFR-3000 and HPFR-3000 flux recovery units. The MAGSEP-100 installs in place of the standard slag tray. Its advanced design provides a slag separation tray and powerful magnets to remove magnetic particles from recovered flux. Magnetic particles are easily disposed of by removing MAGSEP-100 from the flux recovery separator, operator then slides magnet assembly out of magnetic collection tubes and magnetic particles fall away to be discarded.



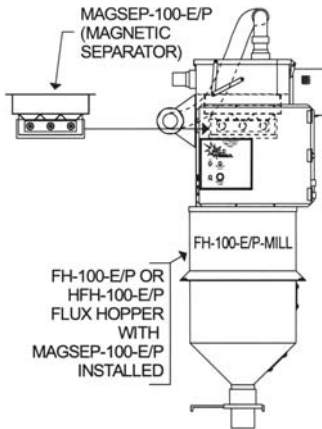


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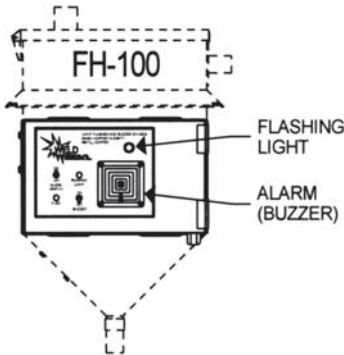
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**D.) MAGSEP-100-E/P MAGNETIC SEPARATOR.**



MAGSEP-100-E/P Magnetic Separator for FH-100-E/P, FH-300-E/P, HFH-100-E/P, HFH-300-E/P, SUPER-FH-100-A/P-E/P and SUPER-HFH-100-A/P-E/P, installs in place of the standard slag tray. Its advanced design provides a slag separation tray and powerful magnets to remove magnetic particles from recovered flux. Magnetic particles are easily disposed of by removing MAGSEP-100-E/P from the flux recovery separator, operator then slides magnet assembly out of magnetic collection tubes and magnetic particles fall away to be discarded.

**E.) ELECTRONIC HIGH OR LOW FLUX LEVEL SENSOR FOR FH-100, FH-300, FH-600, FH-1000, HFH-100, HFH-300, HFH-600, HFH-1000, FH-100-E/P, FH-300-E/P, HFH-100-E/P AND HFH-300-E/P.**

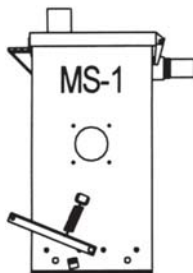


High or low flux level warning lights or audible alarm for flux level. (Consult factory if high and low flux level sensing is required.)

FH-100, FH-300, FH-600, FH-1000, FH-100-E/P and FH-300-E/P  
(115V)  
(220V)

HFH-100, HFH-300, HFH-600, HFH-1000, HFH-100-E/P and HFH-300-E/P  
(115V)  
(220V)

**8. MS-1 SEPARATOR.**



The MS-1 Separator is for flux recovery directly back to the welding head hopper. Mounts directly on to Lincoln, L-Tec and most other hoppers, or use optional FH-1, 35 to 40 pound capacity hopper. **Two MS-1 separators can be used with one MM-3000X or MM-5000X. If only one MS-1 is used, the VFT-3000 vacuum control valve must also be used. Use one MS-1 with the MM-1500.** (See Technical Bulletin TB-MM708 figure nos. 1, 3, 4, 5, 6, and 7 in TB-MM708. Also see MAGSEP-1 for optional magnetic separator.)

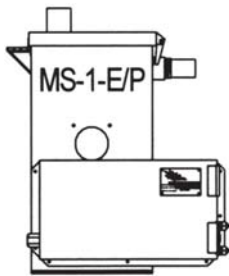


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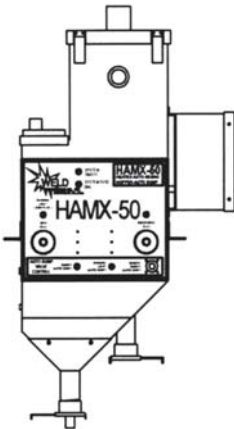
#### 9. MS-1-E/P SEPARATOR.



The MS-1-E/P Separator is the same as Item 8, except flux is automatically transferred to the lower welding head hopper. 115v or 220V input and shop air (70-100 psi with minimum 3/16" I.D. air hose required. The air operates flux valve only, does not provide vacuum). (See MAGSEP-1 for optional magnetic separator.) See Technical Bulletin TB-MM708 figure nos. 1, 3, 4, 5, 6, 7 and 8.)

Input power: (115v/1ph/50-60hz)  
Input power: (220v/1ph/50-60hz)

#### 10. HAMX-50.



HAMX-50 recovers unfused flux and automatically mixes a pre-set ratio of new flux to recovered and dispenses this mixture to the welding torch while welding. The HAMX-50 holds 50 pounds of new flux and 50 pounds of recovered flux in separate heated chambers (70°F/21°C to 250°F/121°C). It replaces existing OEM flux hopper. (User must provide own mounting brackets for attachment of HAMX-50 to welding system.) Larger capacity systems are available, please consult factory with your requirements. Hoses, pick up nozzle and magnetic separator are not included. (See MAGSEP-1 for optional magnetic separator and figure nos. 24 and 25 of TB-MM708.) (Note: Compressed air @ 70-100 psi with minimum 3/16" I.D. hose must be attached to the HAMX-50. (This provides power for operation of flux transfer valve.)

Input power: 115v/1ph/50-60hz

Input power: 220v/1ph/50-60hz

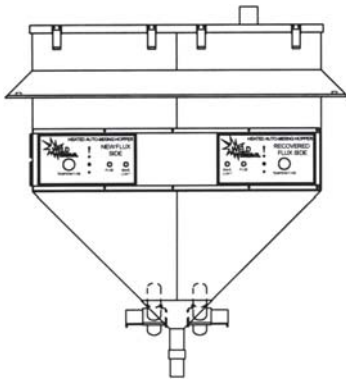


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#### 11. GHAMX-150 HEATED GRAVITY FEED MIXING HOPPER

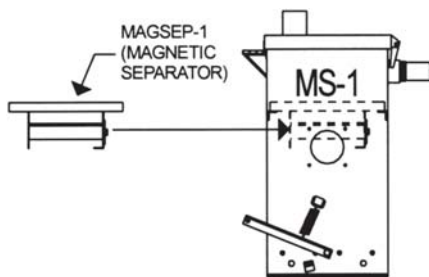


GHAMX-150 Separator automatically mixes a pre-set ratio of new flux to recovered flux and dispenses this mixture to the welding torch while welding. The GHAMX-150 holds 150 pounds of **new flux** and 150 pounds of **recovered flux** in separate heated chambers {70°F (21°C) to 250°F (121°C)}. User must provide own mounting brackets for attachment of GHAMX-150 to welding system. Hoses, pick up nozzle and magnetic separator are ordered separately. (See MAGSEP-100 for optional magnetic separator and figure no.26 of TB-MM708 for complete system requirements.)

Input power: 115v/1ph/50-60hz

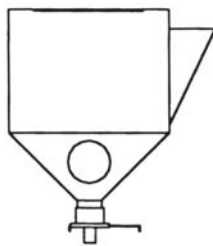
Input power: 220v/1ph/50-60hz

#### 12. MAGSEP-1 MAGNETIC SEPARATOR.



MAGSEP-1 Magnetic Separator for MS-1, MS-1-E/P, and HAMX-50 flux recovery vacuums. The MAGSEP-1 installs in place of the standard slag tray. Its advanced design provides a slag separation tray and powerful magnets to remove magnetic particles from recovered flux. Magnetic particles are easily disposed of by removing MAGSEP-1 from the flux recovery vacuum, operator then slides magnet assembly out of magnetic collection tubes and magnetic particles fall away to be discarded.

#### 13. FH-1 FLUX HOPPER.



The FH-1 flux hopper is for use with AS-4, AS-4-E/P, AP-1, AP-1-E/P, SUPER-AP-1, SUPER-AP-1-E/P, MS-1 and MS-1-E/P where greater flux capacity is required. Side Loading Port of hopper enables operator to add flux to hopper during welding, without interrupting the weld; thus providing an unlimited supply of flux. Hopper holds approximately 35 to 40 pounds of flux.

**Note: Customer must provide own mounting bracket. Does not mount directly to welding head because of increased size and flux weight capacity.**

**FH-1-60** flux hopper is the same as above except it holds 60 lbs of flux.

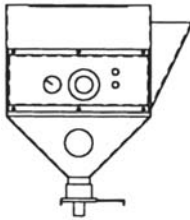


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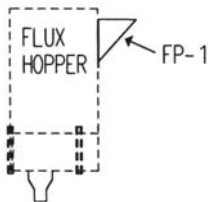
#### 14. HFH-1 HEATED FLUX HOPPER.



The HFH-1 heated flux hopper is the same as the FH-1 Hopper, except it is heated. It has a continuous thermostat control (ambient to 250°F {121°C}) and temperature gauge for those applications where flux must be heated. (Interfaces with same recovery equipment as FH-1 Hopper). Please specify voltage, 115v/1ph/50-60hz or 220v/1ph/50-60hz.

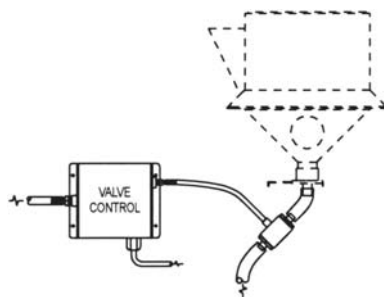
**HFH-1-60** flux hopper is the same as above except it holds 60 lbs of flux.

#### 15. FP-1 FLUX PORT.



The FP-1 flux port is for the Lincoln hopper or any flat walled hopper. Allows additional flux to be added to hopper without interrupting the weld. Includes aluminum port and pop-rivets.

#### 16. AFV-2 AUTOMATIC FLUX VALVE.



The AFV-2 is an in-line flux pinch valve for 3/4" I.D. flux feed hose. Automatically opens or closes flux flow in 3/4" I.D. hose, when 115v electrical signal is supplied. Use with FH-1, HFH-1, or any gravity feed hopper. (Typical use would be to automatically start flux flow when arc-start button is pushed and stop flux flow when weld is finished.) System includes flux pinch valve, air on/off solenoid, pressure regulator and five (5) feet of 1/4" I.D. air hose.

Input power: 115v/1ph/50-60hz and standard shop air (available in other voltages).

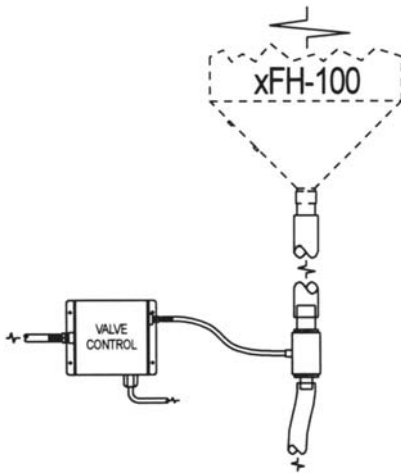


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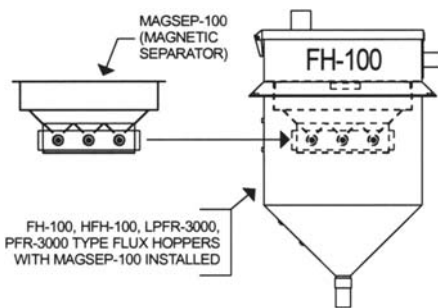
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**25. AFV-2-FH-100 AUTOMATIC FLUX VALVE.**



Same as Item 16, except used with FH-100 or HFH-100. One end accepts 1 1/2" I.D. flux dispensing hose from FH-100; other end accepts 3/4" I.D. hose to feed welding torch. Input power: 115v/1ph/50-60hz and standard shop air (available in other voltages).

**27. MAGSEP-100 MAGNETIC SEPARATOR.**



MAGSEP-100 Magnetic Separator for FH-100, HFH-100, LPFR-3000, PFR-3000, HLPFR-3000 and HPFR-3000 flux recovery separators. The MAGSEP-100 installs in place of the standard slag tray. Its advanced design provides a slag separation tray and powerful magnets to remove magnetic particles from recovered flux. Magnetic particles are easily disposed of by removing MAGSEP-100 from the flux recovery machine, operator then slides magnet assembly out of magnetic collection tubes and magnetic particles fall away to be discarded.

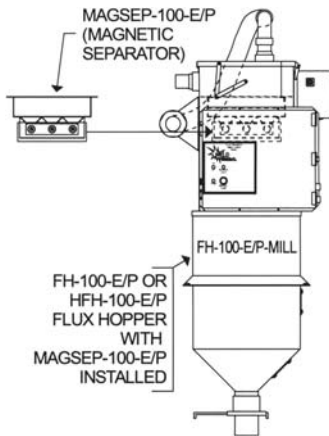


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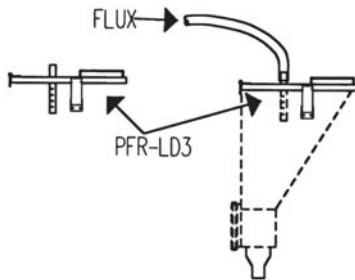
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**28. MAGSEP-100-E/P MAGNETIC SEPARATOR.**



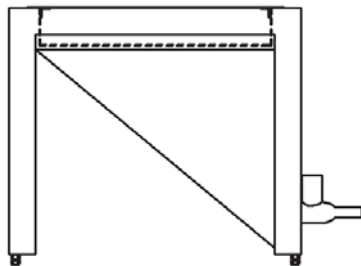
MAGSEP-100-E/P Magnetic Separator for FH-100-E/P, HFH-100-E/P, SUPER-FH-100-A/P-E/P and SUPER-HFH-100-A/P-E/P, installs in place of the standard slag tray. Its advanced design provides a slag separation tray and powerful magnets to remove magnetic particles from recovered flux. Magnetic particles are easily disposed of by removing MAGSEP-100-E/P from the flux recovery separator, operator then slides magnet assembly out of magnetic collection tubes and magnetic particles fall away to be discarded.

**29. PFR-LD3 LID.**



The PFR-LD3 Lid is for attachment to most manufacturer's standard flux hoppers (please specify model of hopper used when ordering), to pressure feed flux to the hopper from a flux feed pressure tank ("x"PT-"x"00, LPFR-3000 and PFR-3000 systems). Customer has choice of 1/2", 3/4" or 1" I.D. hose fitting.

**30. FT-100 - 100 POUND CAPACITY FLUX TROUGH**



The FT-100 - 100 pound capacity flux trough is used under small parts where flux spills off and needs to be recovered. It is also used for loading flux into hopper/separators which are not easily accessible. (See Technical Bulletin TB-MM708 figure nos. 7, 8, 13, 14, and 15.)

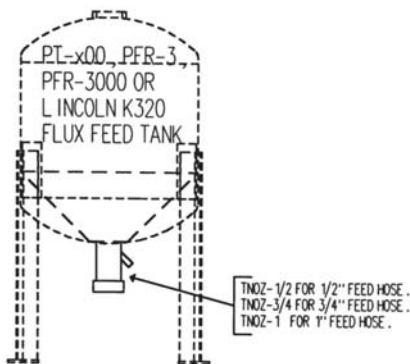


"MANUFACTURERS OF THE MOST COMPLETE LINE OF FLUX HANDLING EQUIPMENT IN THE WORLD"

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Fax: (508) 842-3893  
Website: www.weldengineering.com  
Email: Sales@weldengineering.com

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**31. TNOZ-"XX" PRESSURE TANK FLUX FEED NOZZLES.**



**1. TNOZ-1/2"** - Pressure tank flux feed nozzle for 1/2" I.D. hose. Nozzle fits 2" NPT female pipe fitting which is standard on PFR-3, "x"PFR-3000, "x"PT-"x"00 and Lincoln K320 tanks. (Please consult factory for non-standard sizes.)

**2. TNOZ-3/4"** - Same as above, except for 3/4" I.D. flux feed hose.

**3. TNOZ-1"** - Same as above, except for 1" I.D. flux feed hose.

**32. FV-1 IN-LINE FLUX VALVE.**



The FV-1 in-line flux valve is for hand-held sub-arc guns and PFR-LD3 lid. Trouble free valve fits inside diameter flux hose. Installs in minutes and is ready to use.

**FV-1-1/2"** (For 1/2" I.D. Hose)

**FV-1-3/4"** (For 3/4" I.D. Hose)

**FV-1- 1"** (For 1" I.D. Hose)

**33. TWO INCH (2") VACUUM HOSE.**

(Hose between Mighty-Mac vacuum unit and hopper/separator.)

- A. 10 feet .....
- B. 15 feet .....
- C. 20 feet .....
- D. 25 feet .....

Longer hose available in increments of five (5) feet.

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**34. 1-1/2" FLUX RECOVERY HOSE.**

From hopper/separator to point of flux pick-up. This is our special "YELLOW" ultra-high abrasion hose designed for very rugged recovery applications.

- A. 5 feet .....
- B. 10 feet .....
- C. 15 feet .....
- D. 20 feet .....
- E. 25 feet .....

Longer hose available in increments of five (5) feet.

**35. 1-1/2" FLUX DISPENSING HOSE.**

From hopper/separator to welding equipment hopper or welding torch.

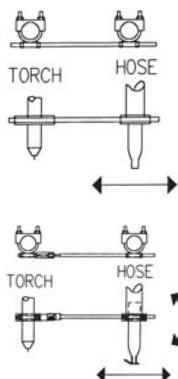
- A. 5 feet .....
- B. 10 feet .....

Longer hose available in increments of five (5) feet.

**36. PRESSURE FEED HOSE.**

- A. 1/2" .....
- B. 3/4" .....
- C. 1" .....
- D. 3/4" High Temperature Hose (Max. 450°F {232°C}) .....
- E. 1" High Temperature Hose (Max. 450°F {232°C}) .....

**37. MOUNTING BRACKETS.**



**A.** The **FHM-1** provides easy positioning of hose over flux. (Linear adjustment only.) For use with all Mighty-Might and Mighty-Mac Recovery Systems.

**B.** The **FHM-1ADJ** provides easy positioning of hose over flux. (Linear and angular adjustment.) For use with all Mighty-Might and Mighty-Mac Recovery Systems.



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**38. FCV-3000.**



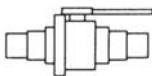
The **FCV-3000** flux control valve with 8" nozzle is used on end of flux dispensing hose (1-1/2") to control flux flow rate to welding equipment hopper or torch.

**39. F/A-3000.**



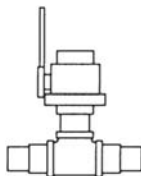
The F/A-3000 flux recovery line shut-off valve for 1-1/2" hose (i.e., Shut off one recovery line; open another.)

**40. V/L-3000.**



V/L-3000 vacuum line shut-off valve (2")

**41. VFT-3000.**



The VFT-3000 vacuum line control valve (2") allows operator to adjust vacuum draw on separator. The VFT-3000 enables the use of one MS-1 separator with the MM-3000X or MM-5000X, or reduces "head height" between the FH-100 or HFH-100 separator and the lower welding equipment hopper.

**42. BAC-3000.**



The BAC-3000 air control for flux trough (bin) pick-up, mixes air with flux when recovery hose is connected directly to a flux collecting trough, or bin, beneath the part which is welded. This is for the 1 1/2" hose.



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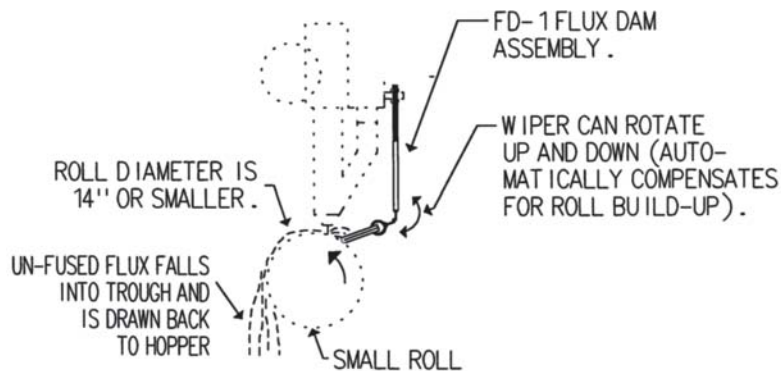
**43. Y-3000.**



The Y-3000 "Y" fitting for 1-1/2" or 2" I.D. hose is used to branch flux recovery or vacuum hose to two positions. Specify hose I.D. when ordering. (Note: MM-3000X, MM-5000X and MM-5000X-MILL have two (2) vacuum inlets.)

**44. FD-1 FLUX DAM FOR BUILDING UP SMALL DIAMETER ROLLS.**

The FD-1 Flux Dam "dams" flux on cylindrical welding applications, to enable proper flux coverage and keeps flux from cascading off the cylinder.



**45. FLUX PICK-UP NOZZLES.**



**A. NZ-1;** Standard Flux Pick-up Nozzle.



**B. NZ-1-4;** 4" Wide Flux Pick-up Nozzle. **(NEW PRODUCT!)**



**C. NZ-1CRN;** Corner Weld Flux Pick-up Nozzle. (Sold as a pair, one left nozzle, one right nozzle.)



**D. NZ-1BUTT;** Butt Weld Flux Pick-up Nozzle.



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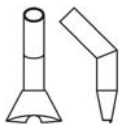
**NOTE:** For diagrams of flux recovery system configurations, see the "Heavy Duty" section of the catalog and look in the Technical Bulletin "TB-MM708," or call us for engineering assistance. (Ask us to send you the "TB-MM708" if it is not available to you.)

**46. PIPE ID OR OD PICK UP NOZZLES - AVAILABLE IN SIZES FROM 24" TO 42". (Two inch recovery hose required).**



**ID**

Straight ID pick up nozzles (24" to 42")



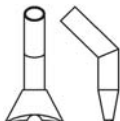
**ID**

45 degree ID pick up nozzles (24" to 42")



**OD**

Straight OD pick up nozzles (24" to 42")



**OD**

45 degree OD pick up nozzles (24" to 42")

(Larger sizes are available, please contact factory for information and pricing.)

**47. SPECIAL DESIGN NOZZLES AVAILABLE FOR SPECIFIC NEEDS. CONSULT FACTORY FOR DETAILS.**



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**ATTENTION: SPARE PARTS MANAGER**

**RECOMMENDED CONSUMABLE PARTS FOR:**

**MM-1500X, 3000X AND 5000X VACUUM SYSTEMS WITH SEPARATOR**

**SPS-1500, SPS-3000 AND SPS-5000 RECOVERY SYSTEMS WITH SEPARATOR**

**PS-1500, PS-3000 AND PS-5000 RECOVERY SYSTEMS WITH SEPARATOR**

**1. MM-1500X, SPS-1500 AND PS-1500.**

**A.)** 1 each Cartridge Dust Filter  
(One required per machine)

**2. MM-3000X , MM-5000X, SPS-5000 AND PS-5000**

**A.)** 2 each Cartridge Dust Filter (**MM-3000X & MM-5000X**)  
(Two required per machine)

**B.)** 1 each Cartridge Dust Filter (SPS-3000, SPS-5000, PS-3000 & PS-5000)

**Or: TEFLON COATED POLYESTER FILTERS.** Specify these filters for extra heavy duty or dusty flux applications. Filters last much longer and resist dust clogging. (Available only for MM-3000X, MM-3000X/P, MM-5000X, MM-5000X/P and MM-5000X-MILL.)

**B.)** 2 each Cartridge Dust Filter  
(Two required per machine)

**3. FH-100/HFH-100 SEPARATOR/HOPPER.**

**A.)** Flux Impingement Plate  
**B.)** Inlet nozzle

**4. MS-1 and MS-1-E/P SEPARATOR.**

**A.)** Flux Impingement Plate  
**B.)** Inlet nozzle

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**5. FLUX PICK-UP NOZZLES.**

- A.) NZ-1 Standard Flux Pick-up Nozzle.
  
- B.) NZ-1-4 4" Wide Flux Pick-up Nozzle
  
- C.) NZ-1CRN Corner Weld Flux Pick-up Nozzle.  
(Sold as a pair, one left nozzle, one right nozzle.)
  
- D.) NZ-1BUTT Butt Weld Flux Pick-up Nozzle.

**6. HOSE.**

- A.) Flux Pick-up Hose (Yellow Ultra-High Abrasion)
  
- B.) Vacuum Hose
  
- C.) Pressure Feed Hose -     1/2" dia.  
  3/4" dia.  
  1" dia.

**ALL EQUIPMENT - F.O.B. - OUR FACTORY**

**Prices subject to change without notice,  
and are those in effect at time of order.**