FIG. PT-17

PRESSURE FEED SYSTEM FOR CONTINUOUS FLUX FEED AND EASY LOADING OF HOPPER MM-1500X, MM-3000X, OR MM-5000X VACUUM WITH FH-100 OR HEATED FH-100 HOPPER/SEPARATOR, PT-100 FEED TANK AND FF-3 FEED PIPE. (TYPICAL COMPONENT CONFIGURATION)

FF-3 (FLUX FEED PIPE. AS FLUX IS CONSUMED AS SLAG, NEW FLUX WILL AUTOMATICALLY BE ADDED. NEW FLUX WILL STOP FEEDING WHEN IT REACHES BOTTOM OF FF-3 PIPE)

MANIPULATOR, GANTRY, OR OTHER EQUIPMENT MOUNTING.

2" VACUUM HOSE

VFT-3000 (SEE NOTE C)

NOTE: TO ELIMINATE NEED FOR "HEAD HEIGHT" USE FH-100-E/P OR FH-100-E/P (SEE FIG. 19)

NOTE A: MIGHTY-MACX VACUUM SELECTION

MM-1500X FOR SINGLE AND TWIN WIRE, WITH 2" VACUUM HOSE UP TO 35 FT.

MM-3000X FOR SINGLE, TWIN AND TANDEM WIRE, WITH 2" VACUUM HOSE UP TO 50 FT.

MM-5000X FOR SINGLE, TWIN AND TANDEM WIRE, WITH 2" VACUUM HOSE UP TO 100 FT.

NOTE C -- VFT-3000:

VFT-3000 ALLOWS VACUUM ADJUSTMENT. IF VACUUM IS REDUCED, THESE REQUIREMENTS FOR FH-100 MAY ALSO BE REDUCED.

SYSTEM ORDER LIST:
1) MM-1500X, MM-3000X OR MM-5000X (VACUUM) (220,380-415/40,575 VOLS/3 PH/50 OR 60 HZ.)
2) FH-100 OR HEATED FH-100 (HOPPER/SEPARATOR) (OPTIONAL ELECTRONIC HI/LOW LEVEL SENSOR WITH ALARM, *LARGER HOPPERS, AND DUAL INLETS AND/OR DUAL OUTLETS ARE AVAILABLE)
3) FF-3 (FLUX FEED PIPE)
4) PT-100 OR (HEATED) HPT-100 (FLUX FEED TANK AVAILABLE IN 100, 300, 600 LBS. OR LARGER)
5) MAGSEP-100 (MAGNETIC SEPARATOR)
6) FHM-1 (FLUX HOSE MOUNTING BRACKET) OR FHM-1ADJ (ADJUSTABLE FLUX HOSE MOUNTING BRACKET)
7) NZ-1, NZ-1 BUTT, OR NZ-1 CRN (NOZZLE FOR FLUX PICK-UP)
8) FCV-3000 (FLUX CONTROL VALVE)
9) VFT-3000 (VACUUM CONTROL VALVE) (SEE NOTE C FOR ADJUSTING "HEAD HEIGHT")
10) @ FLUX FEED HOSE (SEE NOTE B) (3/4" ID. RECOMMENDED 1/2", 3/4", 1" AVAILABLE)
11) 1 1/2" RECOVERY HOSE (TYPICAL IS 15 FT. LONG)
12) 1 1/2" DISPENSING HOSE (TYPICAL IS 10 FT. LONG)
13) 2" VACUUM HOSE (LENGTH DETERMINED BY SYSTEM. SEE NOTE A)

NOTE B: FEED HOSE INSIDE DIAMETER CHANGES MAXIMUM FLUX FEED RATE AND FLUX FEED NOZZLE SIZE

<table>
<thead>
<tr>
<th>INSIDE DIA</th>
<th>MAX FLUX FEED RATE</th>
<th>FLUX FEED NOZZLE</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/2&quot;</td>
<td>1 1/2 LBS. (.68 KG)/MIN.</td>
<td>USE T-NOZ-1/2&quot;</td>
</tr>
<tr>
<td>3/4&quot;</td>
<td>4 TO 6 LBS. (1.81-2.72 KG)/MIN.</td>
<td>USE T-NOZ-3/4&quot;</td>
</tr>
<tr>
<td>1&quot;</td>
<td>6 TO 8 LBS. (2.72-3.63 KG)/MIN.</td>
<td>USE T-NOZ-1&quot;</td>
</tr>
</tbody>
</table>

BASED ON AGGLOMERATED FLUX AND MAXIMUM HOSE LENGTH OF 50 FT. (CONSULT FACTORY FOR DETAILS)

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WELD ENGINEERING CO., INC.
DRT 9-8-2008

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WELD ENGINEERING CO., INC.
EXCELLENCE SINCE 1979