



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

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FIGURE PT-17

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 HFH-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)

SHOP AIR INPUT (APPROX. 1 CFM @ 70-100 PSI. W/ MIN. 1/4" I.D.)

MM-1500X
MM-3000X
OR
MM-5000X
(VACUUM)

AIR INPUT (APPROX. 70-90 PSI. WATER AND OIL FREE)

PT-100 OR HPT-100 (FLUX FEED TANK)

(MM-3000X AND MM-5000X SHOWN)

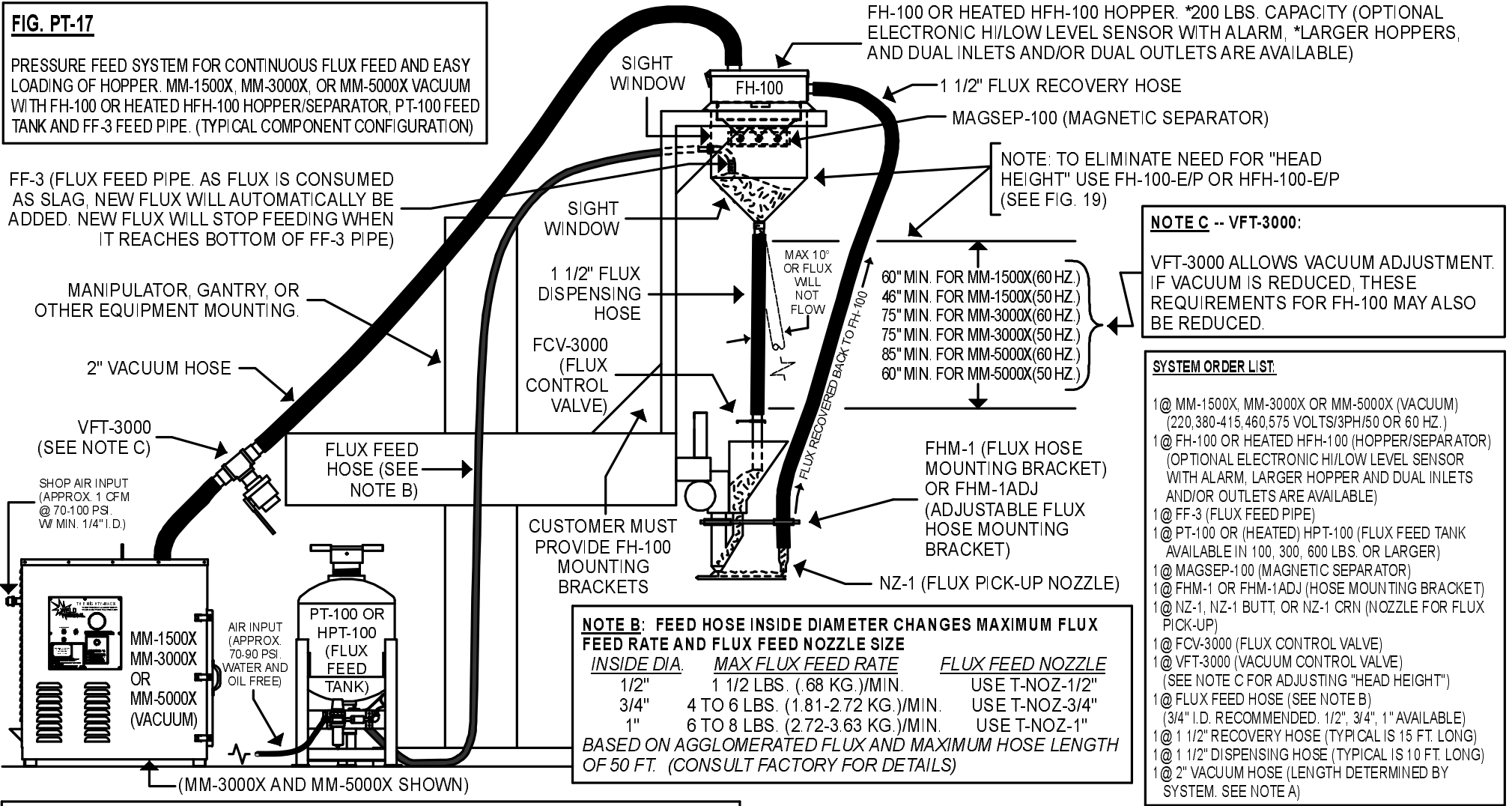
NOTE A: MIGHTY-MACX VACUUM SELECTION

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

| INSIDE DIA. | MAX FLUX FEED RATE | FLUX FEED NOZZLE |
|-------------|----------------------------------|------------------|
| 1/2" | 1 1/2 LBS. (.68 KG.)/MIN. | USE T-NOZ-1/2" |
| 3/4" | 4 TO 6 LBS. (1.81-2.72 KG.)/MIN. | USE T-NOZ-3/4" |
| 1" | 6 TO 8 LBS. (2.72-3.63 KG.)/MIN. | USE T-NOZ-1" |

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



FH-100 OR HEATED HFH-100 HOPPER. *200 LBS. CAPACITY (OPTIONAL ELECTRONIC HI/LOW LEVEL SENSOR WITH ALARM, *LARGER HOPPERS, AND DUAL INLETS AND/OR DUAL OUTLETS ARE AVAILABLE)

1 1/2" FLUX RECOVERY HOSE

MAGSEP-100 (MAGNETIC SEPARATOR)

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

SIGHT WINDOW

SIGHT WINDOW

1 1/2" FLUX DISPENSING HOSE

FCV-3000 (FLUX CONTROL VALVE)

CUSTOMER MUST PROVIDE FH-100 MOUNTING BRACKETS

MAX 10" OR FLUX WILL NOT FLOW

FLUX RECOVERED BACK TO FH-100

FHM-1 (FLUX HOSE MOUNTING BRACKET) OR FHM-1ADJ (ADJUSTABLE FLUX HOSE MOUNTING BRACKET)

NZ-1 (FLUX PICK-UP NOZZLE)

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) (220,380-415,460,575 VOLTS/3PH/50 OR 60 HZ.)
 - 1@ FH-100 OR HEATED HFH-100 (HOPPER/SEPARATOR) (OPTIONAL ELECTRONIC HI/LOW LEVEL SENSOR WITH ALARM, LARGER HOPPER AND DUAL INLETS AND/OR OUTLETS ARE AVAILABLE)
 - 1@ FF-3 (FLUX FEED PIPE)
 - 1@ PT-100 OR (HEATED) HPT-100 (FLUX FEED TANK AVAILABLE IN 100, 300, 600 LBS. OR LARGER)
 - 1@ MAGSEP-100 (MAGNETIC SEPARATOR)
 - 1@ FHM-1 OR FHM-1ADJ (HOSE MOUNTING BRACKET)
 - 1@ NZ-1, NZ-1 BUTT, OR NZ-1 CRN (NOZZLE FOR FLUX PICK-UP)
 - 1@ FCV-3000 (FLUX CONTROL VALVE)
 - 1@ VFT-3000 (VACUUM CONTROL VALVE) (SEE NOTE C FOR ADJUSTING "HEAD HEIGHT")
 - 1@ FLUX FEED HOSE (SEE NOTE B) (3/4" I.D. RECOMMENDED. 1/2", 3/4", 1" AVAILABLE)
 - 1@ 1 1/2" RECOVERY HOSE (TYPICAL IS 15 FT. LONG)
 - 1@ 1 1/2" DISPENSING HOSE (TYPICAL IS 10 FT. LONG)
 - 1@ 2" VACUUM HOSE (LENGTH DETERMINED BY SYSTEM. SEE NOTE A)

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