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## FIGURE PT-18

**FIG. PT-18**

PRESSURE FEED DUAL WELDING STATION FLUX RECOVERY SYSTEM. MM-3000X OR MM-5000X VACUUM WITH 2@ FH-100 OR HFH-100 SEPARATORS, PT-100 FEED TANK, AND FF-3 FEED PIPE. (TYPICAL CONFIGURATION)

**NOTES A:**

- #1) VACUUM HOSES MUST BE APPROXIMATELY EQUAL LENGTHS. (I.E. 2 @ 25 FT.)
- #2) RECOVERY HOSES MUST BE APPROXIMATELY EQUAL LENGTHS. (I.E. 2 @ 15 FT.)
- #3) FOR OPTIMAL HEAVY DUST REMOVAL, ORDER TEFLON COATED FILTERS.
- #4) AS FLUX BECOMES SLAG, NEW FLUX IS AUTOMATICALLY ADDED. NEW FLUX WILL STOP FEEDING WHEN IT REACHES BOTTOM OF FF-3 PIPE.
- #5) \*200 LBS. CAPACITY. OPTIONAL ELECTRONIC HI/LOW LEVEL SENSOR WITH ALARM, LARGER HOPPERS, AND DUAL INLETS AND/OR OUTLETS AVAILABLE

**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"

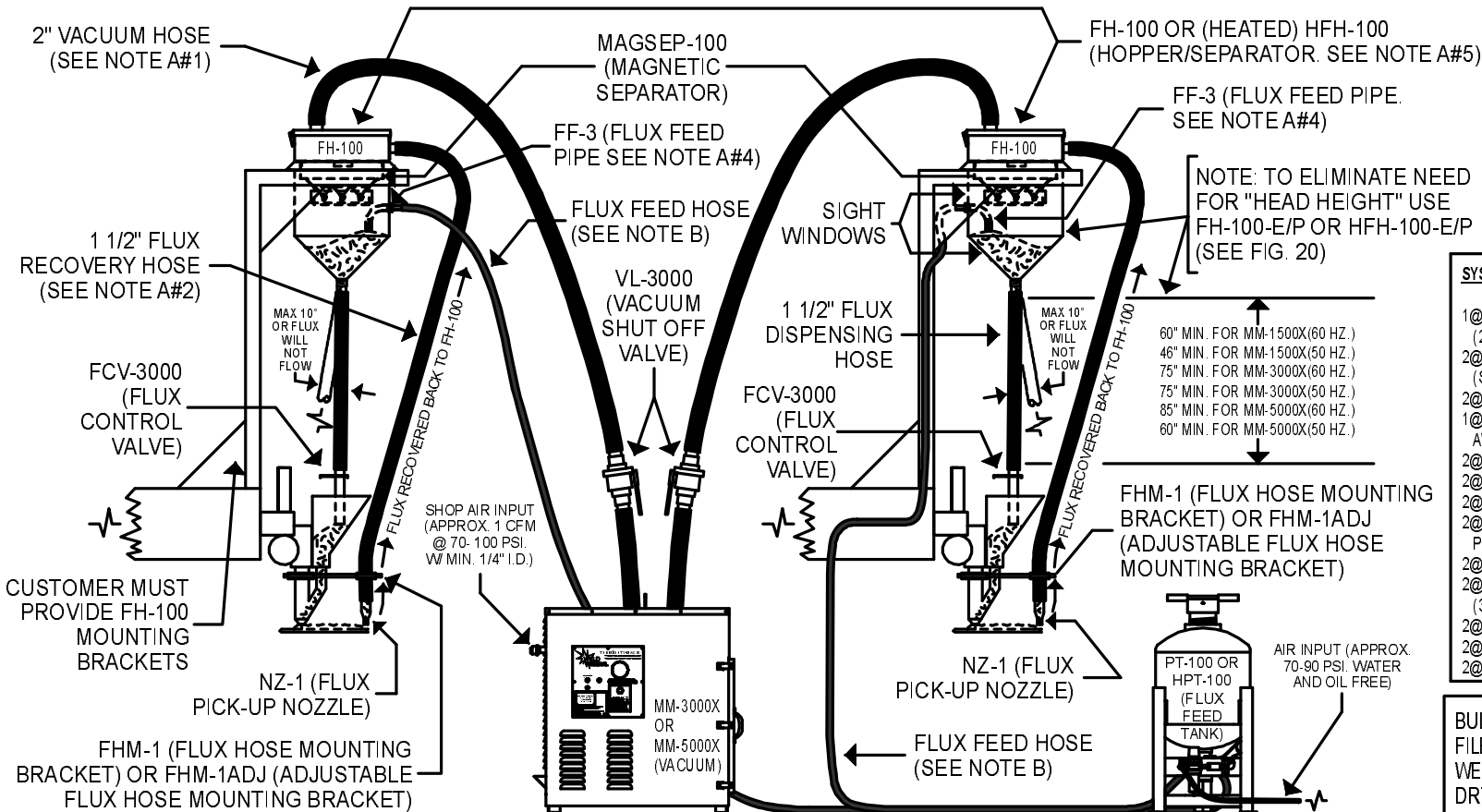
BASED ON AGGLOMERATED FLUX AND MAXIMUM HOSE LENGTH OF 50 FT. (CONSULT FACTORY FOR DETAILS)

**MIGHTY-MAC VACUUM SELECTION:**

**USE MM-3000X FOR...**  
 A) 50/60 HZ. POWER INSTALLATIONS  
 B) SINGLE WIRE WELDING ON EACH HEAD  
 C) MAXIMUM 2" VACUUM HOSE PER HEAD IS 30 FT.  
 D) MAXIMUM 1 1/2" RECOVERY HOSE PER HEAD IS 25 FT.

**USE MM-5000X FOR...**  
 A) 50 HZ. POWER INSTALLATIONS WITH 2" VACUUM HOSE MAXIMUM OF 30 FT. PER HEAD  
 B) 60 HZ. WITH 2" VACUUM HOSE OVER 50 FT. PER HEAD (CONSULT FACTORY FOR MAXIMUM LENGTH)  
 C) 1 1/2" RECOVERY HOSE OVER 25 FT. PER HEAD (CONSULT FACTORY FOR MAXIMUM LENGTH)  
 D) TWIN ARC WELDING EACH HEAD (NOT TANDEM)

**NOTE:**  
 1) DUAL SYSTEM NOT RECOMMENDED FOR TANDEM OR TRIPLE HEADS. USE ONE MM-3000X OR MM-5000X PER TANDEM APPLICATION.  
 2) MM-1500X NOT RECOMMENDED FOR DUAL STATION.



**NOTE: TO ELIMINATE NEED FOR "HEAD HEIGHT" USE FH-100-E/P OR HFH-100-E/P (SEE FIG. 20)**

- 60" MIN. FOR MM-1500X(60 HZ.)
- 46" MIN. FOR MM-1500X(50 HZ.)
- 75" MIN. FOR MM-3000X(60 HZ.)
- 75" MIN. FOR MM-3000X(50 HZ.)
- 85" MIN. FOR MM-5000X(60 HZ.)
- 60" MIN. FOR MM-5000X(50 HZ.)

- SYSTEM ORDER LIST:**
- 1@ MM-3000X OR MM-5000X (VACUUM)  
(220, 380-415, 460, 575 VOLTS/3PH/50 OR 60 HZ.)
  - 2@ FH-100 OR HEATED HFH-100 (HOPPER/SEPARATOR)  
(SEE NOTE A#5)
  - 2@ FF-3 (FLUX FEED PIPE)
  - 1@ PT-100 OR (HEATED) HPT-100 (FLUX FEED TANK  
AVAILABLE IN 100, 300, 600 LBS. OR LARGER)
  - 2@ MAGSEP-100 (MAGNETIC SEPARATOR)
  - 2@ FHM-1 OR FHM-1ADJ (HOSE MOUNTING BRACKET)
  - 2@ VL-3000 (VACUUM SHUT-OFF VALVE)
  - 2@ NZ-1, NZ-1 BUTT, OR NZ-1 CRN (NOZZLE FOR FLUX PICK-UP)
  - 2@ FCV-3000 (FLUX CONTROL VALVE)
  - 2@ FLUX FEED HOSE (SEE NOTE B)  
(3/4" I.D. RECOMMENDED. 1/2", 3/4", 1" AVAILABLE)
  - 2@ 1 1/2" DISPENSING HOSE (TYPICAL IS 10 FT. LONG)
  - 2@ 1 1/2" RECOVERY HOSE (SEE IMPORTANT NOTE #2)
  - 2@ 2" VACUUM HOSE (SEE IMPORTANT NOTE #1)

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