FIGURE 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 TEFLOM 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

<table>
<thead>
<tr>
<th>INSIDE DIA</th>
<th>MAX FLUX FEED RATE</th>
<th>FLUX FEED NOZZLE</th>
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<tbody>
<tr>
<td>1/2&quot;</td>
<td>1 1/2 LBS. (.68 KG)</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)</td>
<td>USE T-NOZ-3/4&quot;</td>
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NOTE C:
1) 10" HOLE TO RECOVERY HOSE LENGTH.
2) 1 1/2" VACUUM HOSE OVER 25 FT. PER HEAD (CONSULT FACTORY FOR DETAILS).
3) 1 1/2" RECOVERY HOSE OVER 25 FT. PER HEAD (CONSULT FACTORY FOR MAXIMUM LENGTH).
4) DUAL ARC WELDING EACH HEAD (NOT TANDEM) (SEE NOTE D#1)
5) CUSTOMER MUST PROVIDE FH-100 MOUNTING BRACKETS.

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

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 E#8)
3) FF-3 (FLUX FEED PIPE) (see note a#4)
4) FCV-3000 (FLUX CONTROL VALVE)
5) VI-1000 (VACUUM SHUT OFF VALVE)
6) FCV-3000 (FLUX CONTROL VALVE)
7) MAGSEP-100 (MAGNETIC SEPARATOR)
8) FHM-1 (FLUX HOSE MOUNTING BRACKET) OR FHM-1ADJ (ADJUSTABLE FLUX HOSE MOUNTING BRACKET)
9) FLUX FEED HOSE (SEE NOTE B)
10) FLUX FEED NOZZLE (SEE NOTE A#4)
11) FLUX FEED TANK
12) PT-100 OR (HEATED) HPT-100 (FLUX FEED TANK AVAILABLE IN 100, 300, 600 LBS. OR LARGER)
13) NZ-1, NZ-1 BUTT, OR NZ-1 CBN (NOZZLE FOR FLUX PICK-UP)
14) FCV-3000 (FLUX CONTROL VALVE)
15) FLUX FEED NOZZLE (SEE NOTE E#8)
16) AIR INPUT (APPROX. 70-80 PSI WATER AND OIL FREE)

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FILE: 18-PT-2 FH-100 PTB-DRT 8-4-2008.CAD
WELD ENGINEERING CO., INC.
DRT 9-8-2008

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