



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

34 FRUIT STREET  
SHREWSBURY, MA 01545 (U.S.A.)  
TELEPHONE: (508) 842-2224  
FAX: (508) 842-3893  
WEBSITE:  
WWW.WELDENGINEERING.COM  
EMAIL:  
SALES@WELDENGINEERING.COM

## FIGURE PT-20

### FIG. PT-20

PRESSURE FEED DUAL WELDING STATION FLUX RECOVERY SYSTEM FOR CONTINUOUS FLUX FEED NOT DEPENDENT UPON "HEAD HEIGHT" LIKE STANDARD FH-100. MM-3000X OR MM-5000X VACUUM WITH 2@ FH-100-E/P OR HFH-100-E/P 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)

#### UGHTY-MAC VACUUM SELECTION:

USE MM-3000X FOR...

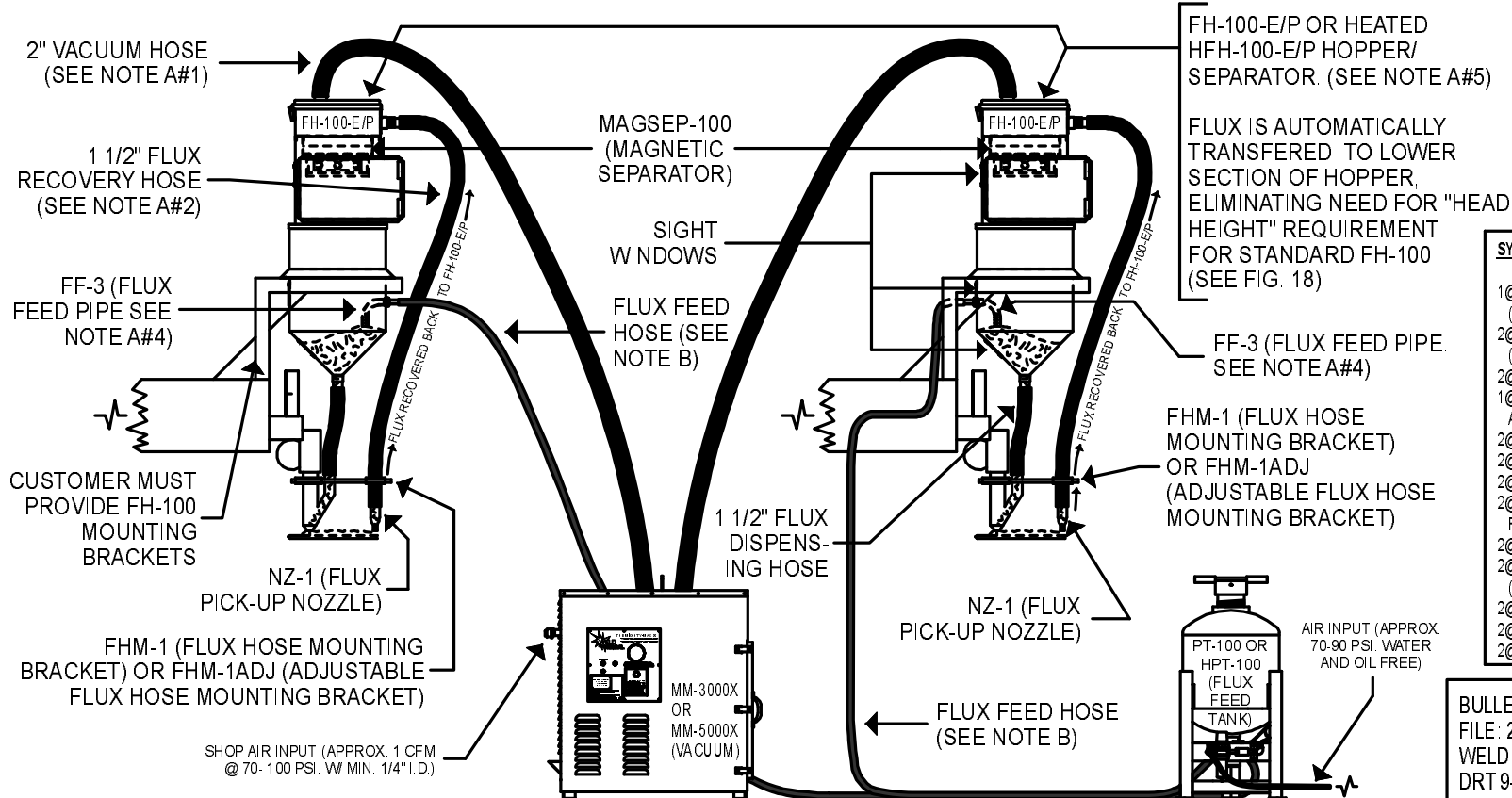
- A) 50/60 HZ. POWER INSTALLATIONS
- B) SINGLE WIRE WELDING ON EACH HEAD
- C) MAXIMUM 2" VACUUM HOSE PER HEAD IS 30 FT.
- D) MAXIMUM 1 1/2" RECOVERY HOSE PER HEAD IS 25 FT.

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.



#### SYSTEM ORDER LIST:

- 1@ MM-3000X OR MM-5000X (VACUUM) (220, 380-415, 460, 575 V OLTS/3PH/50 OR 60 HZ.)
- 2@ FH-100-E/P OR (HEATED) HFH-100-E/P (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@ STANDARD 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 5 FT. LONG)
- 2@ 1 1/2" RECOVERY HOSE (SEE IMPORTANT NOTE #2)
- 2@ 2" VACUUM HOSE (SEE IMPORTANT NOTE #1)

BULLETIN: (PAGE 20) TB-MM708  
FILE: 20-PT-2 FH-100-EP PT TB-DRT 8-5-2008.CAD  
WELD ENGINEERING CO., INC  
DRT 9-8-2008