**FIG. PFR-21**

PRESSURE FEED AND RECOVER SYSTEM FOR CONTINUOUS FLUX FEED. SPS-1500, SPS-3000, SPS-5000 VACUUM WITH PFR-3000 OR LFR-3000 AND PFR-LD3 LID. (TYPICAL COMPONENT CONFIGURATION)

- **FLUX FEED HOSE**
  - SEE NOTE B
- **MAGSEP-100** (MAGNETIC SEPARATOR)
- **SPS-1500, SPS-3000, OR SPS-5000** (SPS-3000 AND SPS-5000 SHOWN)
- **SIGHT WINDOWS**

**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

**NOTE A**: SPS VACUUM SELECTION:

- SPS-1500 FOR SINGLE AND TWIN WIRE, WITH 2" VACUUM HOSE UP TO 35 FT.
- SPS-3000 FOR SINGLE,TWIN AND TANDEM WIRE, WITH 2" VACUUM HOSE UP TO 50 FT.
- SPS-5000 FOR SINGLE,TWIN AND TANDEM WIRE, WITH 2" VACUUM HOSE UP TO 100 FT.

**NOTE B**: INSIDE DIAMETER OF THE FEED HOSE DETERMINES THE MAXIMUM FLUX FEED RATE AND FLUX FEED NOZZLE SIZE:

<table>
<thead>
<tr>
<th>INSIDE DIAMETER</th>
<th>MAX 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)

**SYSTEM ORDER LIST**:

1@ SPS-1500, SPS-3000 OR SPS-5000 (VACUUM)
200-450, 575 VOLTS/3PH/60 HZ.
1@ PFR-3000 OR LFR-3000 (PRESSURE FEED AND RECOVER SYSTEM)
1@ MAGSEP-100 (MAGNETIC SEPARATOR)
1@ FHM-1 OR FHM-1 ADJ (HOSE MOUNTING BRACKET)
1@ NZ-1, NZ-4 BUTT, OR NZ-4 CRN (NOZZLE FOR FLUX PICK-UP)
1@ PFR-LD3 LID (PRESSURE FEED LID)
1@ SHOP AIR INPUT (APPROX. 1 CFM @ 70-100 PSI. W/ MIN. 1/4" I.D.)
1@ PRESSURE FEED HOSE (SEE NOTE B)
1@ T-NOZ-1/2" OR T-NOZ-1/2" IF USING LINCOLN K-320 TANK
1@ ELECTRONIC LEVEL SENSORS (SEE NOTES)
1@ 1 1/2" RECOVERY HOSE
1@ 2" VACUUM HOSE (SEE NOTE A)

**HEAVY DUST REMOVAL**:

FOR HEAVY DUST REMOVAL, USE MM-1500XP, MM-3000XP, OR MM-5000XP

**FLUX RECOVERED BACK TO PFR-3000**

**NOTE B**: INSIDE DIAMETER OF THE FEED HOSE DETERMINES THE MAXIMUM FLUX FEED RATE AND FLUX FEED NOZZLE SIZE:

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

**FILE**: 21-PFR-PFR-3000S-SPS-1500-B-08.CAD
WELD ENGINEERING CO., INC.
DRT 9-6-2008