FIGURE HAMX-25

HEATED AUTOMATIC MIXING FLUX HOPPER SEPARATOR SYSTEM. MM-1500X, MM-3000X, OR MM-5000X VACUUM WITH HAMX-50 AND HPT-100 HEATED FEED TANK. (TYPICAL COMPONENT CONFIGURATION)

NOTE A: MIGHTY-MAC 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.

HAMX-50 AUTOMATICALLY MIXES A PRESET RATIO OF NEW FLUX TO RECOVERED FLUX, KEEPS NEW AND RECOVERED FLUX HEATED TO 250°F AND DELIVERS THIS MIXTURE TO THE WELDING TORCH.

NOTE: AIR MUST BE PROVIDED. 70-100 PSI. MINIMUM 3/16" I.D. LINE REQUIRED. THIS OPERATES FLUX TRANSFER VALVE ONLY. VACUUM IS PROVIDED BY MIGHTY-MAC ELECTRIC VACUUM.

SYSTEM ORDER LIST:

1@ MM-1500X, MM-3000X, OR MM-5000X (VACUUM)
1@ HAMX-50 (SEPARATOR)
1@ HPT-100 (HEATED FLUX FEED TANK AVAILABLE IN 100, 300, 600 LBS. OR LARGER)
1@ AFV2 (AUTOMATIC FLUX VALVE AND CONTROL)
1@ MAGSEP-1 (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@ PRESSURE FEED HOSE (SEE NOTE B)
1@ 1 1/2" FLUX RECOVERY HOSE (NOTE C)
1@ FLM-1 (FLUX HOSE MOUNTING BRACKET) OR FHM-1ADJ (ADJUSTABLE FLUX HOSE MOUNTING BRACKET)
1@ 11/2" FLUX RECOVERY HOSE (NOTE D)
1@ 2" VACUUM HOSE (LENGTH DETERMINED BY SYSTEM. SEE NOTE A)

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

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

NOTE: VFT-3000

VFT-3000 ALLOWS VACUUM ADJUSTMENT. IF VACUUM IS REDUCED, FLUX PARTICLE SIZE DRAW BACK IS ALSO REDUCED.

BULLETIN: (PAGE 25) TB-MM708
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REvised: HAMX ~ PRESSURE FEED.CAD (12-3-1996 TB-MM294)
WELD ENGINEERING CO., INC.
DRT 6-8-2008