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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 HAMX-29

### FIG. HAMX-29: I.D. GIRTH WELD

HEATED AND AUTOMATIC MIXING PRESSURE FEED AND RECOVER SYSTEM FOR I.D. GIRTH WELD. MM-3000X/P OR MM-5000X/P VACUUM WITH HPFR-HAMX-3000-H100-H100, AND FH-1-LD-3 OR HEATED HFH-1-LD-3. (TYPICAL COMPONENT CONFIGURATION)

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

INSIDE DIAMETER	MAX. 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)

### NOTE D: CABLE TRACK

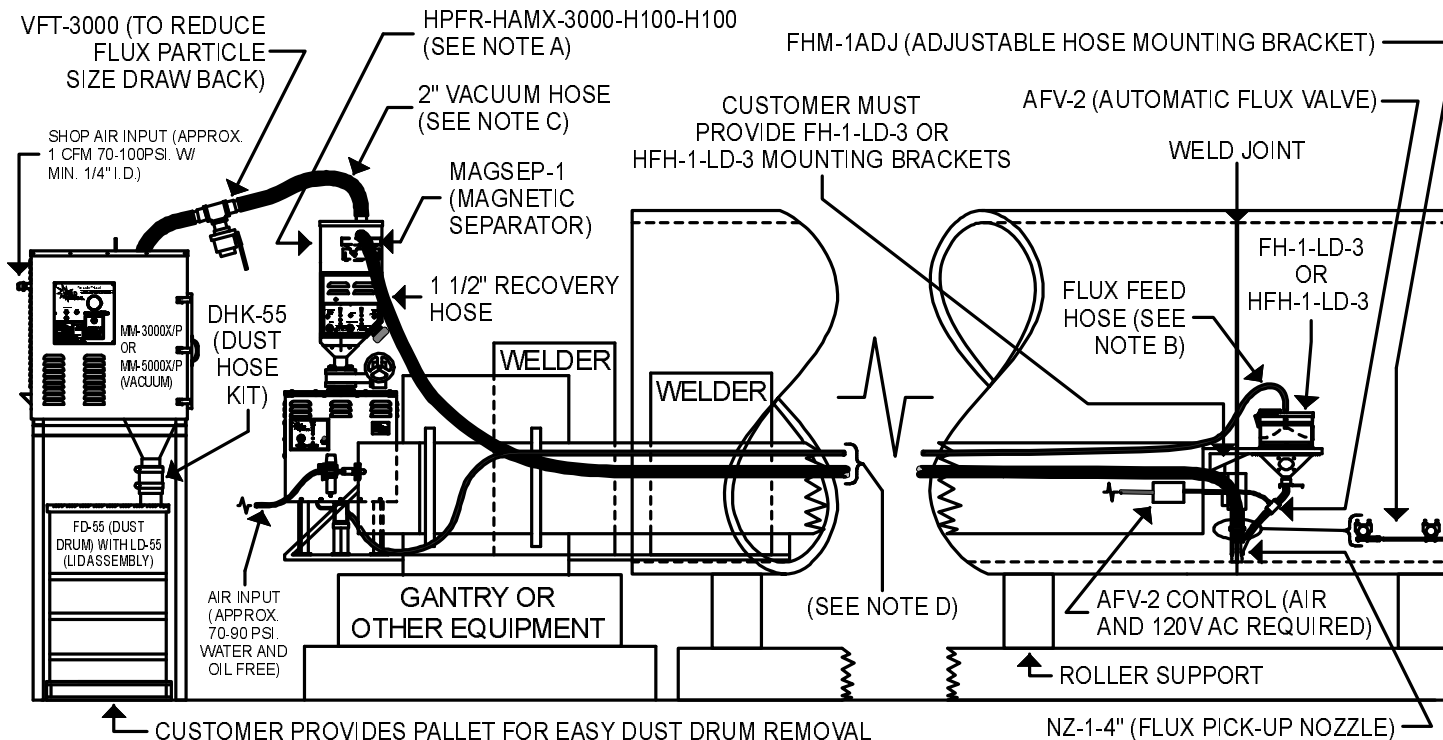
ALL HOSES MUST BE IN A SUITABLE CABLE TRACK WHICH DOES NOT REDUCE THE MINIMUM BEND RADIUS.

### NOTE A: HPFR-HAMX-3000-H100-H100

HPFR-HAMX-3000-H100-H100 IS A COMPLETE SYSTEM: HEATED AUTOMATIC MIXING SEPARATOR AND HEATED PRESSURE TANK WITH CONTROLS. ELECTRONIC LEVEL SENSORS ARE AVAILABLE FOR TANK AND HOPPER (i.e. IF TANK IS AT LOW LEVEL, A LOUD BUZZER SOUNDS AND LIGHT FLASHES). HPFR-HAMX-3000-H100-H100 MOVES WITH THE WELDERS, NOT THE BOOM IN THIS CONFIGURATION.

### NOTE C: MIGHTY-MAC VACUUM SELECTION

MM-3000X/P FOR SINGLE, TWIN AND TANDEM WIRE, WITH 2" VACUUM HOSE UP TO 50 FT. MM-5000X/P FOR SINGLE, TWIN AND TANDEM WIRE, WITH 2" VACUUM HOSE UP TO 100 FT.



### SYSTEM ORDER LIST:

- 1@ MM-3000X/P, OR MM-5000X/P (VACUUM) (220, 380-415, 460, 575 VOLTS/3PH/50 OR 60 HZ.)
- 1@ FD-55 (DUST DRUM) WITH LD-55 (LID ASSEMBLY)
- 1@ HPFR-HAMX-3000-H100-H100 (HEATED PRESSURE FEED AND RECOVER SYSTEM WITH HEATED AUTOMATIC MIXING HOPPER/SEPARATOR)
- 1@ ELECTRONIC LEVEL SENSOR (SEE NOTE A)
- 1@ MAGSEP-1 (MAGNETIC SEPARATOR)
- 1@ FH-1-LD-3 OR (HEATED) HFH-1-LD-3 (40 LBS. HOPPER WITH PRESSURE FEED LID)
- 1@ AFV-2 (AUTOMATIC FLUX VALVE AND CONTROL)
- 1@ FHM-1ADJ (ADJUSTABLE HOSE MOUNTING BRACKET)
- 1@ NZ-1-4" OR I.D. PIPE NOZZLE (SPECIFY DIAMETER) (NOZZLE FOR FLUX PICK-UP)
- 1@ VFT-3000 (VACUUM CONTROL VALVE)
- 1@ FLUX FEED HOSE (SEE NOTE B & D) (3/4" I.D. RECOMMENDED: 1/2", 3/4", 1" AVAILABLE)
- 2@ 1 1/2" RECOVERY HOSE (SEE NOTE D)
- 2@ 2" VACUUM HOSE (SEE NOTE C)

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