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 FH-1-LD-3. (TYPICAL COMPONENT CONFIGURATION)

NOTE A: 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. (0.68 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)

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

NOTE C: CABLE TRACK

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

NOTE D: CABLE TRACK

CUSTOMER PROVIDES PALLET FOR EASY DUST DRUM REMOVAL

NOTE A: 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.

SYSTEM ORDER LIST:

1) @MM-3000X/P, OR MM-5000X/P (VACUUM) (220, 380-415, 460, 575 VOLTS/3PH/50 OR 60 HZ.)
2) @ FD-55 (DUST DRUM) WITH LD-55 (LID ASSEMBLY)
3) @ HPFR-HAMX-3000-H100-H100 (HEATED PRESSURE FEED AND RECOVER SYSTEM WITH HEATED AUTOMATIC MIXING HOPPER/SEPARATOR)
4) @ ELECTRONIC LEVEL SENSOR (SEE NOTE A)
5) @ MAGSEP-1 (MAGNETIC SEPARATOR)
6) @ FH-1-LD-3 OR (HEATED) FH-1-LD-3 (40 LBS. HOPPER WITH PRESSURE FEED LID)
7) @ AFV-2 (AUTOMATIC FLUX VALVE AND CONTROL)
8) @ FH-1-LD-3 (ADJUSTABLE HOSE MOUNTING BRACKET)
9) @ NZ-1/4" OR I.D. PIPE NOZZLE (SPECIFY DIAMETER) (NOZZLE FOR FLUX PICK-UP)
10) @ VFT-3000 (VACUUM CONTROL VALVE)
11) @ FLUX FEED HOSE (SEE NOTE B & D) (3/4" I.D. RECOMMENDED, 1/2", 3/4", 1" AVAILABLE)
12) @ 1 1/2" RECOVERY HOSE (SEE NOTE D)
13) @ 2" VACUUM HOSE (SEE NOTE C)

VINYL OR PVC (VACUUM)

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