**FIG. HAMX-30: O.D. GIRTH WELD**

Heated and automatic mixing pressure feed and recover system for O.D. Girth Weld.

**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).

**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).

**NOTE C:** Vacuum Hose

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. Must provide enough slack for the manipulator to expand and contract.

**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) FHFR-1-LD-3 (40 lbs. hopper with pressure feed lid)
7. @AFV-2 (Automatic flux valve and control)
8. @FH-1-LD-3 or (adjustable) HPH-1-LD-3
9. @NZ-1/4" or I.D. pipe nozzle (specify diameter)
10. @VFT-3000 (Vacuum control valve)
11. @Flux Feed hose (see note B) (3/4" I.D. recommended, 1/2", 3/4", 1" available)
12. @1 1/2" Recovery hose
13. @2" Vacuum hose (see note C)

**BULLETIN:** (Page 30) TB-MM08

**FILE:** 30-HAMX~HPFR-HAMX-3000-100 OD TB-DRT 8-12-2008.CAD

**DRT 9-4-2008**