**FIG. MILL-34: PIPE MILL I.D. CONFIGURATION**

Pressure feed and recover system for continuous flux feed. MM-5000X-Mill Vacuum with PFR-3000 or LPFR-3000 and PFR-LD3 Lid (Typical component configuration) for pipe mill internal weld or heavy duty flux recovery application where weld system size is important.

**NOTE A:** Feed hose inside diameter determines 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. (1.82 KG.)/MIN.</td>
<td>USE T-NOZ-1/2&quot;</td>
</tr>
<tr>
<td>3/4&quot;</td>
<td>4 TO 6 LBS. (1.82-2.72 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 max. hose length of 50 ft. (Consult factory for details.)

**BULLETIN:** (Page 34) TB-MM-708

**FILE:** 34-MILL~ PFR-3000 MILL TB-DRT 7-17-2008.CAD

**REVISED:** PFR-MILL 211 (1-2-1996 TB-MM-394)

**WELD ENGINEERING CO., INC.**

**NOTE:**
- Do not restrict air flow at pick-up nozzle. Allow at least 50% air flow.
- Do not overfill auxiliary separator (i.e., FH-100, MS-1, PFR-3000, etc). This will cause reusable flux to be drawn into dust drawer.
- Repeat as necessary.
- The ETREME vacuum system for tough, heavy-duty flux recovery.

**SYSTEM ORDER LIST:**
- MM-6000X-MILL (VACUUM)
  - MM-6000X-MILL MOUNTING FRAME (OPTIONAL)
  - PFR-3000 OR HEATED HPFR-3000 (COMPLETE SYSTEM, SEPARATOR AND PRESSURE TANK WITH CONTROLS)
  - Electronic level sensors are available for hopper and tank (i.e., if tank is at low level, a loud blower sounds and light flashes).
  - Standard tank capacity is 100 L. Larger tank/hopper systems are available. (i.e. 300 LBS. tank with 300 LBS. hopper, etc.)

**CUSTOMER**
- Provides pallet for easy dust drum removal.