



"MANUFACTURERS OF THE MOST COMPLETE LINE  
OF FLUX HANDLING EQUIPMENT IN THE WORLD"

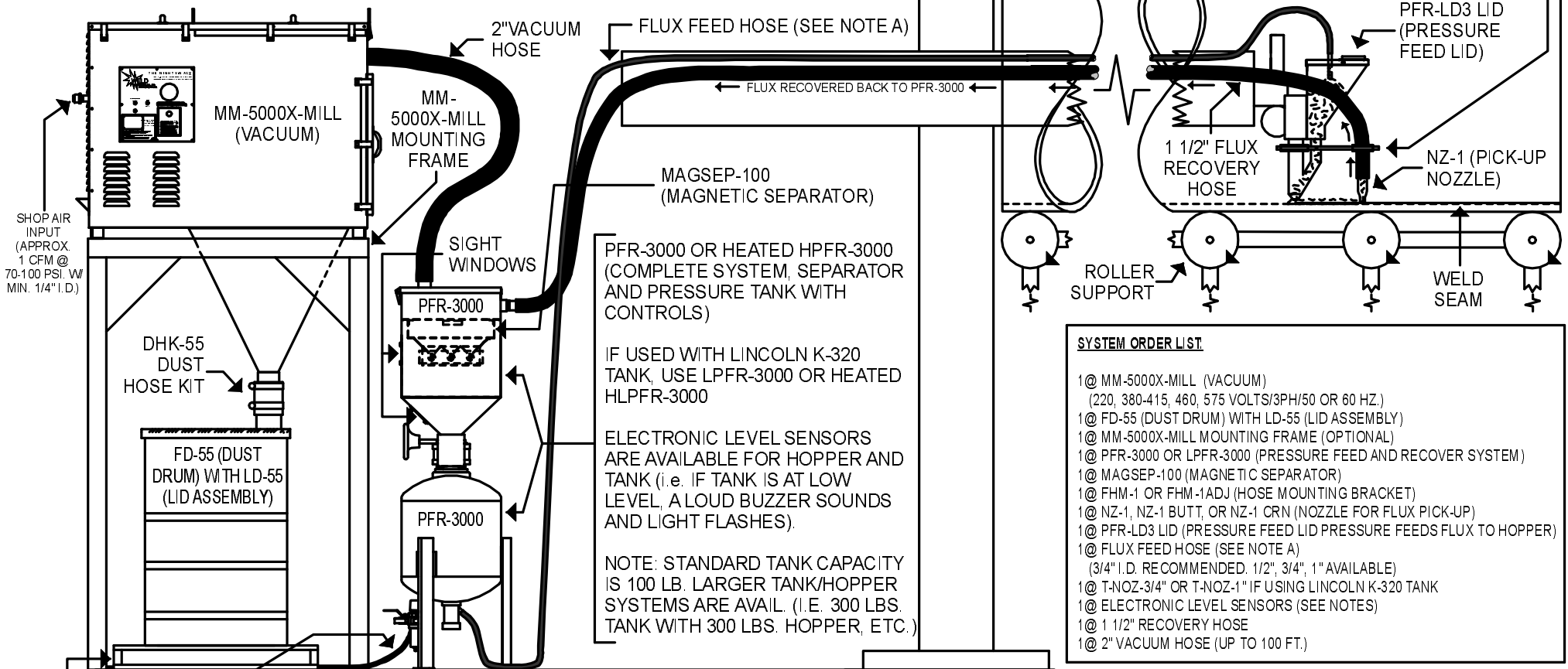
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## FIGURE MILL-34

### 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.



#### SYSTEM ORDER LIST

- 1@ MM-5000X-MILL (VACUUM)  
(220, 380-415, 460, 575 VOLTS/3PH/50 OR 60 HZ.)
- 1@ FD-55 (DUST DRUM) WITH LD-55 (LID ASSEMBLY)
- 1@ MM-5000X-MILL MOUNTING FRAME (OPTIONAL)
- 1@ PFR-3000 OR LPFR-3000 (PRESSURE FEED AND RECOVER SYSTEM)
- 1@ MAGSEP-100 (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@ PFR-LD3 LID (PRESSURE FEED LID PRESSURE FEEDS FLUX TO HOPPER)
- 1@ FLUX FEED HOSE (SEE NOTE A)  
(3/4" I.D. RECOMMENDED. 1/2", 3/4", 1" AVAILABLE)
- 1@ T-NOZ-3/4" OR T-NOZ-1" IF USING LINCOLN K-320 TANK
- 1@ ELECTRONIC LEVEL SENSORS (SEE NOTES)
- 1@ 1 1/2" RECOVERY HOSE
- 1@ 2" VACUUM HOSE (UP TO 100 FT.)

#### NOTE A: FEED HOSE INSIDE DIAMETER DETERMINES 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 MAX. HOSE LENGTH OF 50 FT. (CONSULT FACTORY FOR DETAILS)

BULLETIN: (PAGE 34) TB-MM708  
FILE: 34-MILL~PFR3000 MILL TB-DRT 7-17-2008.CAD  
REVISED: PFRMILL1.CAD (12-3-1996 TB-MM294)  
WELD ENGINEERING CO., INC.  
DRT 9-9-2008

CUSTOMER PROVIDES PALLET FOR EASY DUST DRUM REMOVAL

AIR INPUT (APPROX. 70-90 PSI. WATER AND OIL FREE)

SHOP AIR INPUT (APPROX. 1 CFM @ 70-100 PSI. W/ MIN. 1/4" I.D.)