



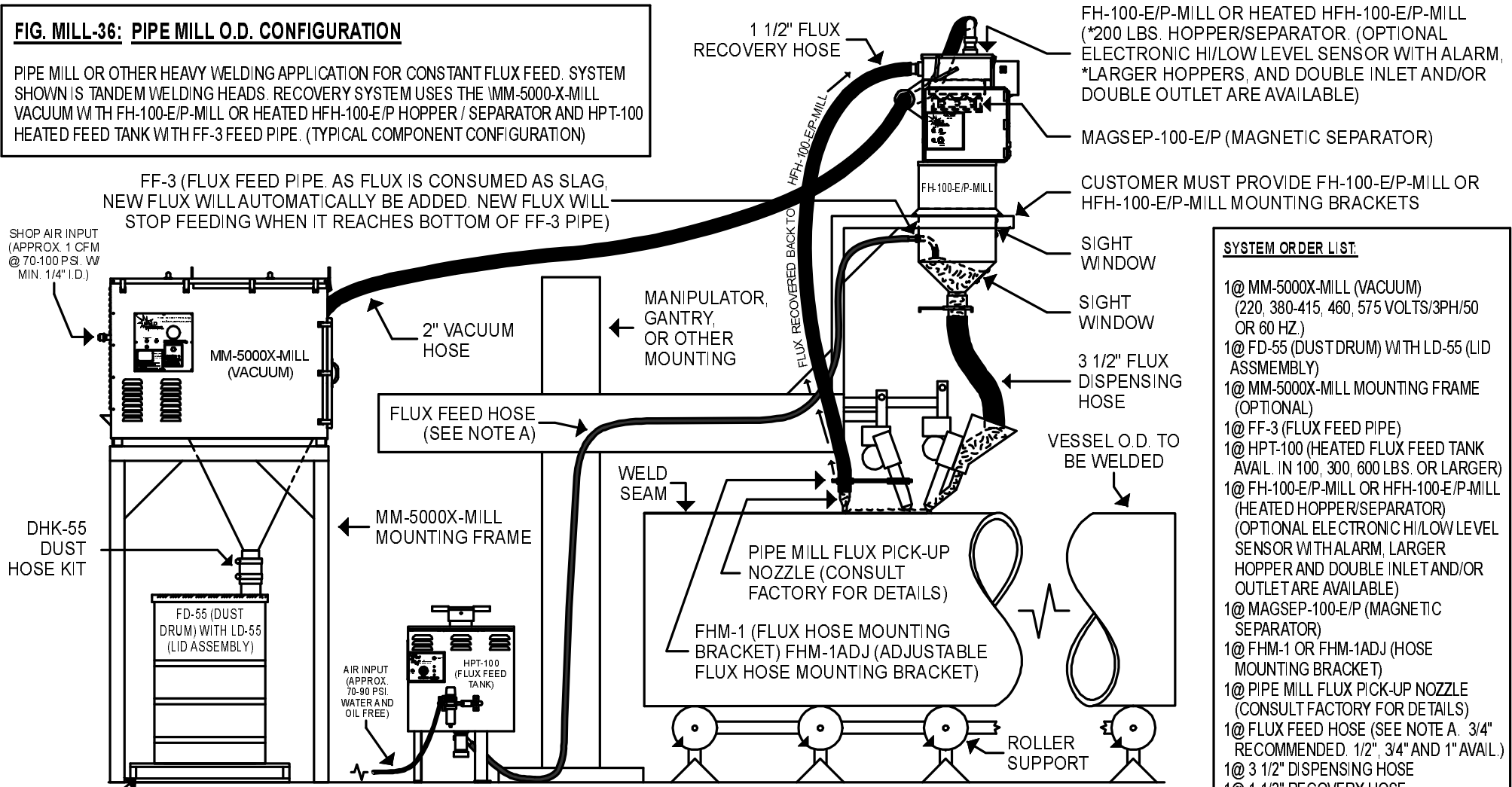
"MANUFACTURERS OF THE MOST COMPLETE LINE OF FLUX HANDLING EQUIPMENT IN THE WORLD"

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FIGURE MILL-36

FIG. MILL-36: PIPE MILL O.D. CONFIGURATION

PIPE MILL OR OTHER HEAVY WELDING APPLICATION FOR CONSTANT FLUX FEED. SYSTEM SHOWN IS TANDEM WELDING HEADS. RECOVERY SYSTEM USES THE MM-5000X-MILL VACUUM WITH FH-100-E/P-MILL OR HEATED HFH-100-E/P HOPPER / SEPARATOR AND HPT-100 HEATED FEED TANK WITH FF-3 FEED PIPE. (TYPICAL COMPONENT CONFIGURATION)



FF-3 (FLUX FEED PIPE. AS FLUX IS CONSUMED AS SLAG, NEW FLUX WILL AUTOMATICALLY BE ADDED. NEW FLUX WILL STOP FEEDING WHEN IT REACHES BOTTOM OF FF-3 PIPE)

- 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 ASSSEMBLY)
 - 1@ MM-5000X-MILL MOUNTING FRAME (OPTIONAL)
 - 1@ FF-3 (FLUX FEED PIPE)
 - 1@ HPT-100 (HEATED FLUX FEED TANK AVAIL. IN 100, 300, 600 LBS. OR LARGER)
 - 1@ FH-100-E/P-MILL OR HFH-100-E/P-MILL (HEATED HOPPER/SEPARATOR) (OPTIONAL ELECTRONIC HI/LOW LEVEL SENSOR WITH ALARM, LARGER HOPPER AND DOUBLE INLET AND/OR OUTLET ARE AVAILABLE)
 - 1@ MAGSEP-100-E/P (MAGNETIC SEPARATOR)
 - 1@ FHM-1 OR FHM-1ADJ (HOSE MOUNTING BRACKET)
 - 1@ PIPE MILL FLUX PICK-UP NOZZLE (CONSULT FACTORY FOR DETAILS)
 - 1@ FLUX FEED HOSE (SEE NOTE A. 3/4" RECOMMENDED. 1/2", 3/4" AND 1" AVAIL.)
 - 1@ 3 1/2" DISPENSING HOSE
 - 1@ 1 1/2" RECOVERY HOSE
 - 1@ 2" VACUUM HOSE (UP TO 100FT.)

NOTE A: FEED HOSE INSIDE DIAMETER CHANGES MAXIMUM FLUX FEED RATE AND FLUX FEED NOZZLE SIZE

INSIDE DIAMETER	MAX FLUX 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)

CUSTOMER PROVIDES PALLET FOR EASY DUST DRUM REMOVAL

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WELD ENGINEERING CO., INC.
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