

GAS AUTO BRAZING MACHINE



Features / Benefits

- Brazing GAS-OXYGEN or GAS-AIR
- High level of performance with minimal operating costs
- Panel Control System
- Wire feeder
- Gas valve, regulator control
- Ignition device
- High - Low flame switching
- Digital Flow Meter Control
- Index turn table, Servo Motor Control
- Rocking Jig System



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MACHINE SPECIFICATION

Machine Model	Rotary + Motion Type Gas Auto Brazing Machine		
Utility	Supply pressure	Burner movement air	0.5 MPa
		Flammable gas(Acetylene)	0.05 MPa
		Combustion enhancing gas(Oxygen)	0.5 MPa
Power Supply	220VAC, 2P, 50HZ, 5KVA		
	Control	:Drive apparatus by AC 220V :Indication apparatus by DC 24V	
Machine Dimension	Machine outline dimension - W1000 X D1700 X 1900 mm (Change by condition)		
General View	Burner model	: Four tips burner for LPG, Acetylene, LPG+Air	
	Supply filler	: 2 Line type wire supply device. with forwardinf speed adjustment.	
	Burner positioning movement by air cylinder.		
	Wire supply movement by motor.		
	Burner oscillating movement by motor.		
General View	Gas brazing is automatically operated positioning the work by fixer(Jig).		
	Work brazing by timer control (touch panel type).		
	Brazing location is 4 Point (Change by condition).		
Target Work	Change by condition.		
Burner	Burner model	: Four tips burner for Gas use	
	Burner Positioning control	: Air cylinder movement	
	Heating Position adjustment	: Flexible branch pipe shape	
	(Change by Condition)		
Gas control	Mixed gases	: Main Burner GAS+OX x 1 Unit	
		: Ignition Burner GAS x 1 Unit	
	Flow quantity control	: Digital flower meter (Gas + OX)	
	Flow quantity	: Needle valve control	
	Ignition method	: Automatic ignition by spark plug.	
	Fire extinguishing method	: Air blow extinguishing	
	Backfire detection	: Prevention back fire device for acetylene, oxygen.(Dry type)	
	Antioxidant circuit	: N ₂ GAS	
	Gas control at stand-by time	: Fire off operation (The ignition starts automatically at re-operation.)	
Brazing point	Pipe joint point		
Brazing filler material	Reel winding filler Material (Provided By Customer)		
Brazing point	Pipe joint point		
Flux	Vapor flux tank (Provided By Customer)		
Work jig	Not include		
Turn table	Index turn table, Servo motor control and Rocking jig system.		



Production capacity 25,000/month (Working day : 20 Hours/day (6 days/week) Setting&gas brazing time : 50~65 second (There is time lag by terms of use)

Operation

<Auto Mode> Gas Brazing at One Points automatically

Set work by manual operation → Start switch ON → Gas Ignition Start → Moving burner unit (By air cylinder) → Stop at brazing position → Brazing Start(Burner oscillating movement Start) → Brazing Completed(Burner oscillating movement Start) → Fire extinguishing → Moveing burner unit (Stand-by position) → Remove Work Out → Cycle End

Continue same process operation

<Manual Mode> Each movement can be done independently on touch panel.

- The progress of the burner , retreat.
- The progress of the wire supply nozzle , retreat.
- Forwarding of wire supply.
- The ignition of the burnner , fire extinguishing.
- Reshuffling high flame or low flame.
- The ignition only for pilot burners, fire extinguishing.

Switches

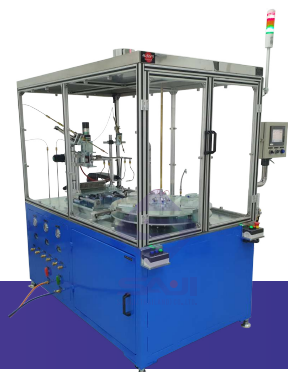
Start switch and emergency stop button

Touch panel summary

Timer control is possible on touch panel

1. Heating time.
2. Time before wire supply nozzle appering since a burner appeared at the heating position.
3. Forwarding time of wire supply.
4. Ignition time of the ignition burner.
5. Supply time of the fire extinguishing air.
6. Time before a burner being replaced by low flame form high flame at the time of brazing.

In addition, touch panel can perform error indication, reset, a buzzer stop.



Requisition Form

1.	Production capacity	
2.	Target Works Name	
3.	Target Works material	
4.	Dimension, Figure of Work	
	Work Drawings	
	Sample Work before brazing	
	Sample Work after brazing	
5.	Production Quantity(pcs./Month)	
6.	Running time & Operating Rate	
7.	Gas Kind	
	Flammable gas	
	auxiliary gas	
8.	Gas Pressure Value	
	Flammable gas	
	auxiliary gas	
9.	Brazing method	
	Automatic feeding filler type	
	Face - fed filler type	
10.	Brazing filler kind	
11.	Flux use	
	Vapor Flux	
	Paste Flux	
12.	Gas Control	
	Electric solenoid Valve Control	
	Mass flow controller	

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