

Induction Soldering Brass Bellows Assembly

United Induction Heating Machine Limited

We are experienced in Induction Heating, induction heating machine, Induction Heating equipment. They are widely used in induction heating service, induction heat treatment, induction brazing, induction hardening, induction welding, induction forging, induction quenching, induction soldering induction melting and induction surface treatment applications
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Soldering Brass Bellows Assembly Objective: To heat a brass bellows and end cap assembly to 450°F for soldering within 20 seconds. Presently, a soldering iron is used to produce the joint between the bellows and cap. The customer requests a quality solder joint with minimal heating of the bellows to prevent annealing and performance losses. Solder preforms, in the form of flat washers, are to be used to complete this application.

Material: Brass Bellows measuring 2 in diameter

Solder Preforms

Cadmium Free Flux

Temperature: 450°F

Application: The Power of 10KW, 10kW output solid state induction power supply along with a unique three (3) turn double wound helical coil was utilized to achieve the following results:

- * 450°F was reached and solder flow completed in 6.3 seconds.
- * A quality repeatable solder joint was observed.

Equipment: Power of 10KW, 10kW output solid state induction power supply including one (1) remote heat station containing one (1) 1.2 µF capacitor, and a unique three (3) turn double wound helical coil with an inside diameter of 0.4.

Frequency: 307 kHz Soldering Brass Bellows Assembly

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