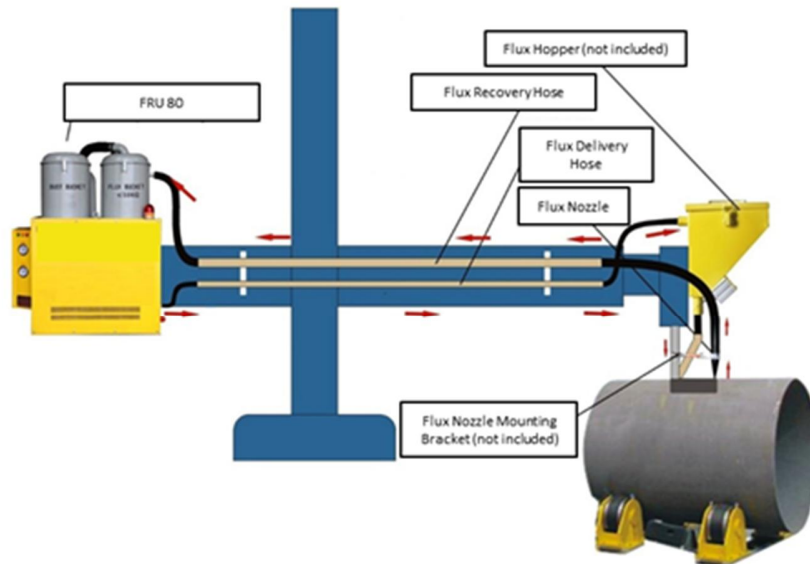
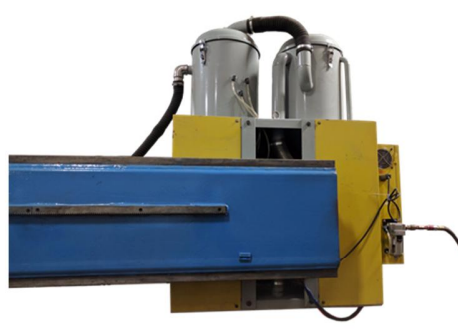




8. IRIZAR Flux Recovery System Model FRU 80

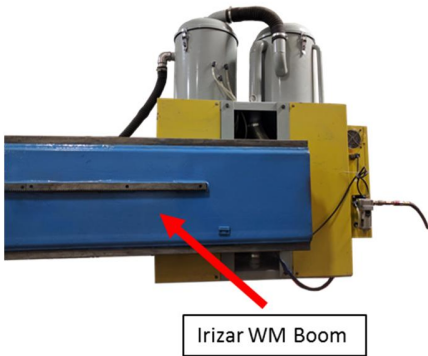


MODEL	FRU-80
DESCRIPTION	
Input Power	240 V, 60 HZ, 3 P or 380 V, 50 HZ, 3 P
Motor Power	2.2 kW
Working suction	≤ - 1.75 psi
Flux recovery distance	Up to 9 m
Flux recovery speed	6-12 Kg/min
Flux delivery distance	Up to 9 m
Max flux capacity	50 kg
Min flux required	15 kg
Air flow required	20 cfm @ 100 psi
Unit Weight	120 kg

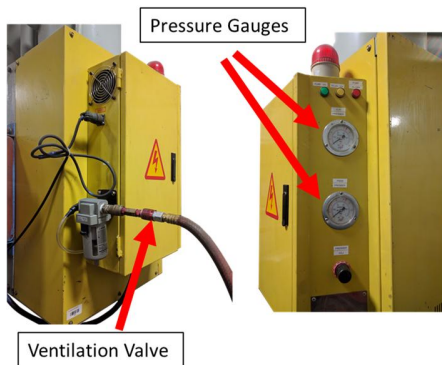


Installation Instructions

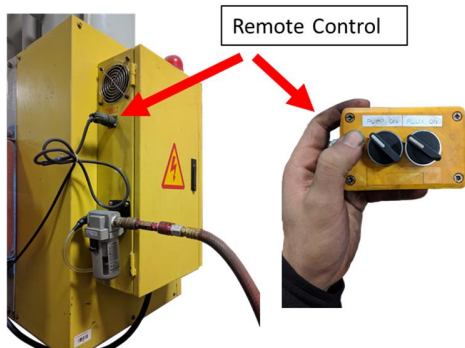
1. The FRU is mounted and secure on the end of the boom (opposite to welding head).



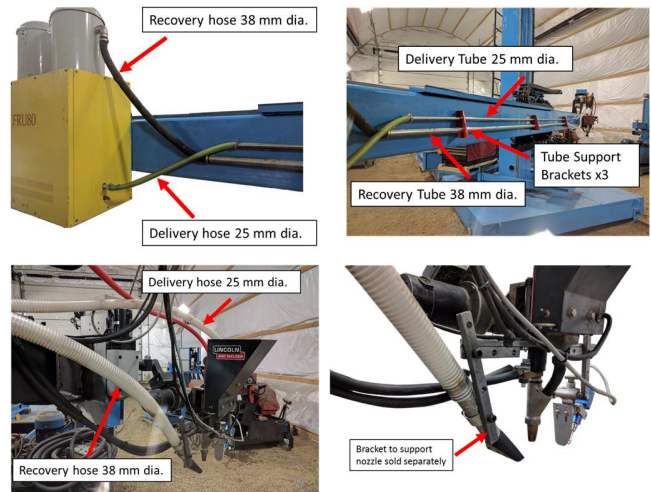
2. Connect external air source to the FRU regulator. Air pressure require of 100 psi @ 20 cfm. Note if less pressure is supplied flux delivery system will not work. Ensure FRU pressure gauges work once external air source is connected.



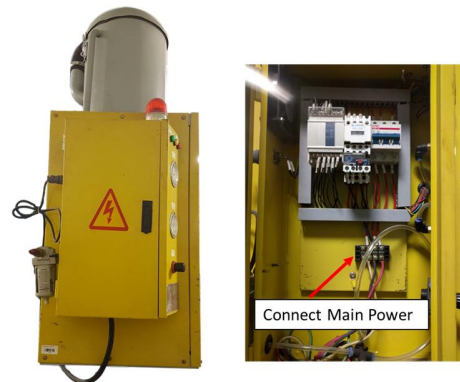
3. Connect the wire control remote on the FRU. The control remote is installed at the front of the manipulator near the welding head. The remote controls the flux delivery (Flux On) and flux recovery (Pump On). Before powering the system both functions need to be OFF.



4. Connect delivery/recovery hoses and pipes. Secure them to the boom of the manipulator using the supplied brackets. The flux delivery hose is kept inside the flux hopper. Note: Bracket to hold recovery hose nozzle on the welding head and flux hopper are sold separately.



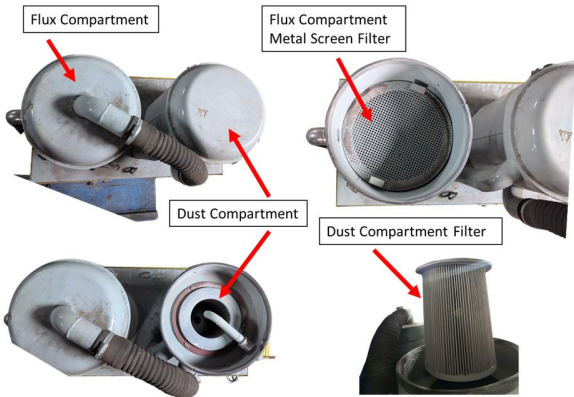
5. Connect power to the FRU main control box. Power require is can be 240V, 3P, 60hz or 380V, 3P, 50hz. Check data plate.



8. Place the wired remote-control toggle switch in the FLUX ON position. The yellow indicator light should light up and flux will be delivery to the flux hopper. Note flux is not constantly delivery. It will delivery for 5 min and stop for 1 min to re-pressurise. If the red siren alarm in on during operating, flux will not be deliver. The FUR needs to be shut down and flux added to Flux Compartment.



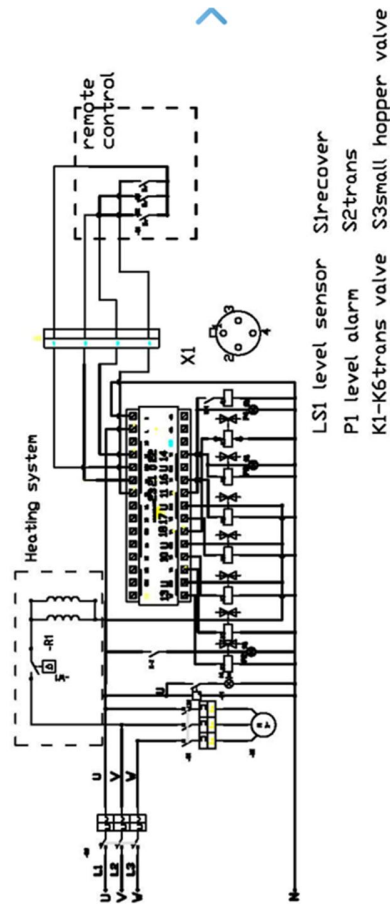
- Fill the flux compartment with flux. Min flux require is 15 kg. Max flux allowed is 50 kg. When filling FRU with flux it must go through the metal screen to prevent unwanted material to enter system. Dust compartment filter must be change when required. Flux needs to be heated (90 – 100 degrees Celsius) and dry prior to being added to flux compartment. If equipment is decommissioned or not use for long periods of time flux needs to be removed and placed in oven prior to be used on the FRU.



- Turn the FRU ON. Place the wired remote-control toggle switch in the PUMP ON position. The green indicator light should light up and vacuum will turn on. Place hand in the Recovery Hose and check for suction. If air is being blown the main power wiring terminal need to be swap. The ventilation valve is used to control and adjust the vacuum suction force. As the valve is close the more suction you will have.



Electrical Diagram



Air Diagram

