

SYNCO Presents

S12E FLAME SPRAY SYSTEM

SPRAYS ALL METALS AVAILABLE IN WIRE FORM USING OXY-FUEL GAS. A VERSATILE, FIELD PROVEN METALLIZING GUN

Specifications

Wire Drive-Air Turbine

Wire Size-1/8"(standard), 3/6" (optional)

Compressed Air Consumption

35 cfm at 70psi

Flame Spray, S12E Standard

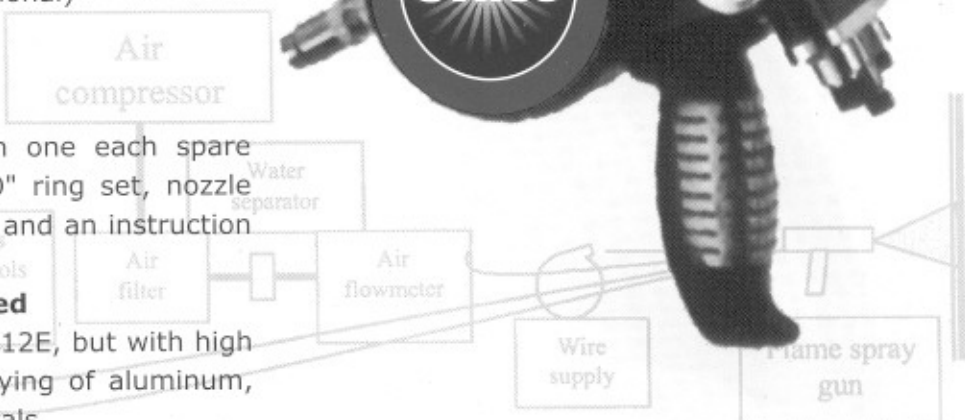
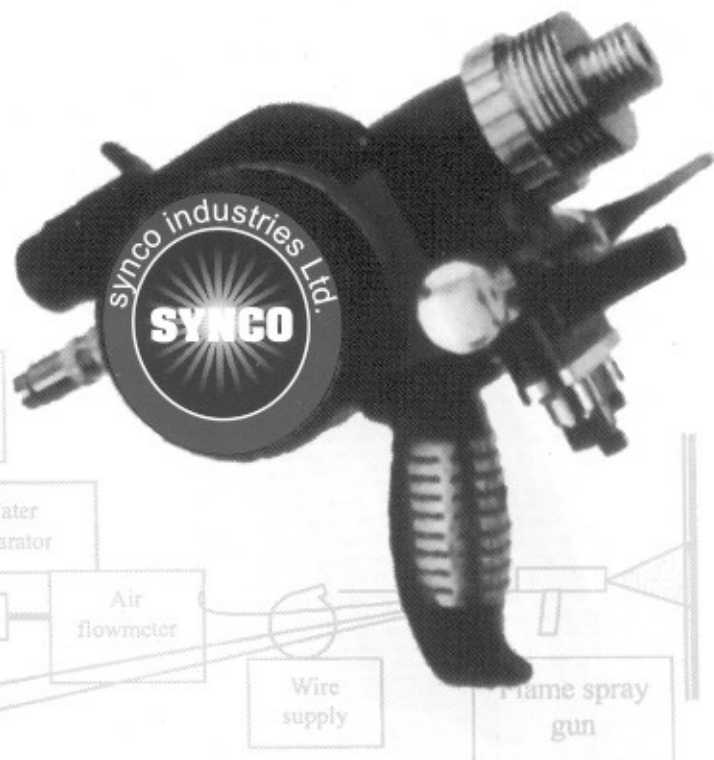
Supplied Bare and Complete with one each spare nozzle 1/8", air cap, gas head "O" ring set, nozzle cleaning kit, tool post attachment, and an instruction manual packed in a case.

Flame Spray, S12E HS, High Speed

Similar to standard Flame Spray, S12E, but with high speed gears to facilitate fast spraying of aluminum, zinc and other low melting point metals.

LPG Conversion Kit

A set of parts is available to use LPG (Propane) in place of acetylene, to cut fuel cost particularly with the HS model.



SPRAY RATE WITH ELECTRIC AVC

Material	Spray rate at 400 A (75% duty/cycle) Kg./hr.	Coverage with 100 microns thickness Kg/m	M/Hr
Zinc & Alloys*	30.0	1.22	24.6
Tin Zinc*	50.0	1.20	41.5
Aluminium*	08.1	0.31	26.1
Al Bronze	12.3	1.10	11.2
Copper	15.0	1.10	13.6
Carbon Steel	12.5	0.90	13.8
Stainless Steel	13.5	0.98	13.8

Wire size is 1.6 mm unless mentioned otherwise.
*These figures are for 2 mm wire size.
*ABOVE FIGURES ARE FOR GUIDANCE ONLY

SPECIFICATIONS

Wire Drive	Air Turbine	Air Consumption	0.8 Cu. Mtr./Min. at 4.5 Kg/Cm2
Wire Size	3.17 mm Std. 1.6 mm		
Approx Spray Rates	Steel (Kg/hr)	Zinc (Kg/hr)	Net Weight (Gun only) 2.65 kgs.
Using 3.17 mm wire	05	14	Shipping Weight 9.50 Kgs.
Using 4.75 mm wire	08	28	

Deposit Efficiency of Thermal Spray Processes

Material	Wire Flame Spray %	Arc Spray %
Zinc	60-70	60-65
Aluminum	80-85	70-75
85-15 Zn-Al	85-90	70-75

Spray Rates

Material	Wire Flame 2.4mm	Wire Flame 3.2mm	Wire Flame 4.8mm	Arc Spray
Zinc	9.1 (20.0)	20 (44.0)	30 (66.1)	18 (39.6)
Aluminum	2.5 (5.5)	5.4 (11.9)	7.3 (16.1)	2.7 (5.9)
85-15 Zn-Al	8.2 (18.0)	18 (39.6)	26 (57.3)	16 (35.2)

Weight of Material for Coating a Given Area

Material	Wire Flame Spray	Arc Spray
Zinc	0.0098 (0.050)	0.0110 (0.056)
Aluminum	0.0027 (0.014)	0.0029 (0.015)
85-15 Zn-Al	0.0070 (0.036)	0.0093 (0.048)

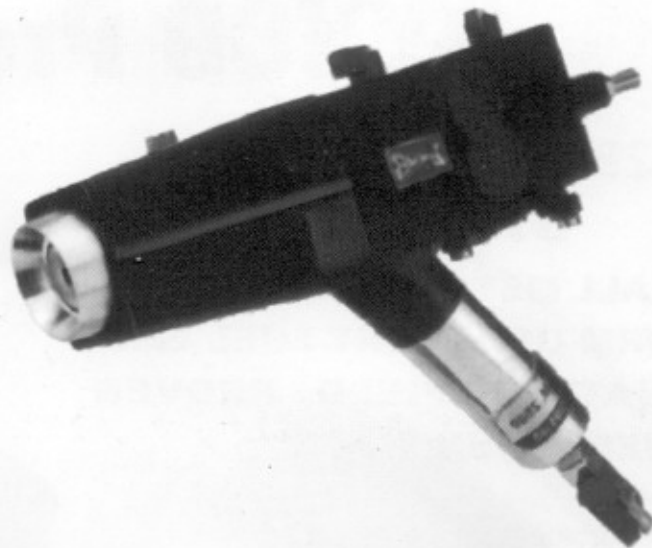
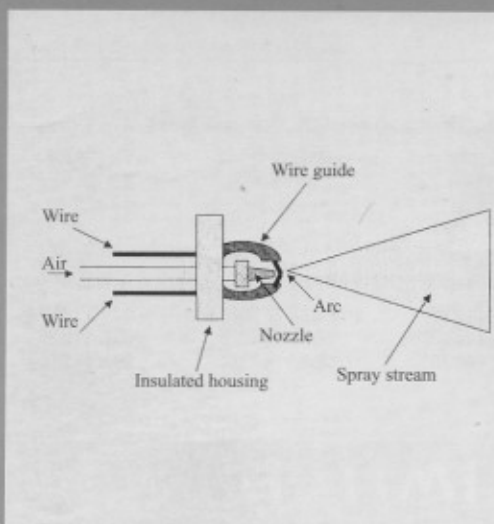
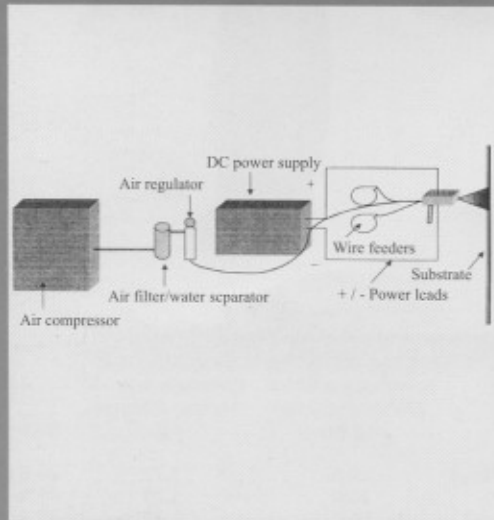
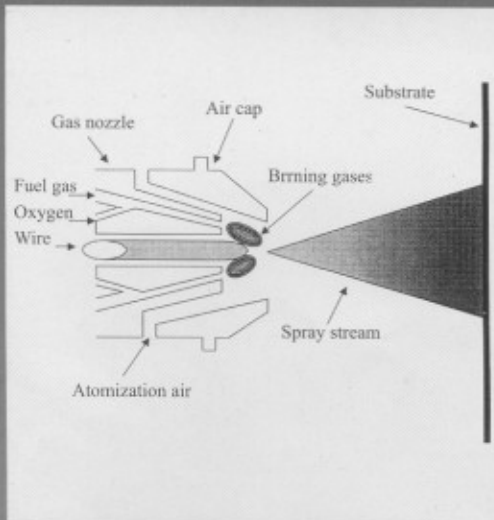
Coverage Rates

Material	Wire Flame 2.4mm	Wire Flame 3.2mm	Wire Flame 4.8mm	Arc Spray
Zinc	944 (2190)	2120 (4930)	3070 (7130)	1100 (2560)
Aluminum	873 (2030)	1890 (4390)	2530 (5880)	826 (1920)
85-15 Zn-Al	1180 (2740)	2620 (6090)	3800 (8830)	968 (2250)

* All Specifications are subject to change without notice.

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SPECIFICATIONS

DESCRIPTION	ARCJET-SN/200	ARCJET-SN/400
POWER SOURCE	415	415
SUPPLY VOLTAGE	3 PHASE, 50 Hz	3 PHASE, 50 Hz
MAIN SUPPLY	12 Amps.	25 Amps.
PRIMARY CURRENT	8 KW	20 KW
MAX. CAPACITY	17-32 V	18-52 V
OPEN CIRCUIT VOLTAGE	200 Amps at 75% Duty Cycle	400 Amps at 75% Duty Cycle
CURRENT	150 Amps for continuous operation	310 Amps for continuous operation
FUSES		
1. MAIN	10 Amps.	32 Amps.
2. FAN	6 Amps.	6 Amps.
3. CONTROL	10 Amps.	10 Amps.
MAX AMBIENT TEMPERATURE TO WHICH THE RATING APPLY	40 DEG. C	40 DEG. C
WIRE FEED	BY AIR MOTOR FITTED IN THE GUN	BY AIR MOTOR FITTED IN THE GUN
TOTAL WEIGHT	~ 240 KGS.	~ 365 KGS.
AIR REQUIREMENTS		

(a) With long slot nozzle/positioner 0.708 mtr. Cub./min. [25 Cfm] at 2.1 cm.sq. [30 psi].

(b) With cross slot nozzle/positioner (i) 0.538 mtr.cub./min [19 cfm] 1.4 kg/cm sq. [20 psi].

(ii) 0.920 mtr.cub./min. [32.5 cfm] 2.8 kg/cm.sq. [40 psi]

(iii) 1.274 mtr.cub./min. [45 cfm] 4.2 kg/cm.sq. [60 psi]

(iv) 1.685 mtr.cub./min [59.5 cfm] 5.6 kg/cm.sq. [80 psi]