Brazing steel mold for golf ball dimple insert

**Objective**
Heating steel golf ball mold to brazing dimple insert

**Material**
Golf ball mold 2" in diameter, braze flux paste, dimple insert

**Temperature**
1400 °F (760 °C)

**Frequency**
206 kHz

**Equipment**
- Ambrell 8.3 kW induction heating system, equipped with a remote workhead containing two 0.5 µF capacitors for a total of 0.25 µF
- An induction heating coil designed and developed specifically for this application.

**Process**
A four turn helical coil is used to heat the golf ball mold to 1400 °F (760 °C) in 3 minutes and the dimple insert is brazed to the mold with braze flux paste.

**Results/Benefits**
Induction heating provides:
- No flame process.
- Reliable, repeatable, non contact and energy efficient heat in minimal time.
- Even distribution of heating.
Golf ball mold heated for brazing process