



Inserting brass bushing into plastic wire connector

Objective Inserting threaded brass bushing into a plastic wire connector

Material Threaded brass bushing .437" (11mm) diameter, .687" (17.4mm) long. Plastic wire connector 4.375" (11.1cm) long, 1" (2.5cm) wide

Temperature Brass bushing is heated to 500 °F (260 °C), 550 °F (288 °C), 600 °F (315 °C) and 650 °F (343 °C) to test torque, must hold 175 in/lbs

Frequency 322 kHz

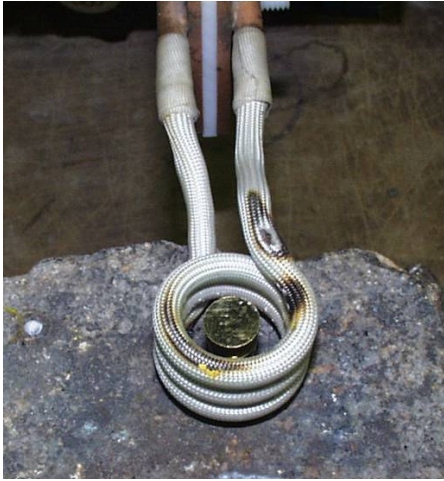
Equipment

- Ambrell 4.2 kW induction heating system, equipped with a remote workhead containing one 1.0µF capacitor.
- An induction heating coil designed and developed specifically for this application.

Process A three turn helical coil is used to heat the brass bushing. The brass bushing is heated for 2 seconds and then placed on the wire connector & pressed into position.

Results/Benefits Induction heating provides:

- Strong threaded connection
- Fast, accurate and repeatable
- Ability to heat very small areas within precise production tolerances
- Even distribution of heating



Brass bushing heating in coil



Brass bushing

Pressing brass bushing into wire connector



Finish product