Technical note 101: Number of workplaces for equipment of the **MIG-O-MAT microflame** series

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Depending on use and working method, a soldering unit of the microflame series (from microflame 140) can be operated with several workplaces.

The following table offers an overview on how many nozzles of which size can be connected to an equipment as maximum. This does only apply if work is carried out simultaneously at all places. Decisive is the **minimum pressure of 60mbar** in the system. When removing too much gas and the equipment is already working at 100% power (e.g. because of too many or too large nozzles), the pressure drops and might come below the minimum pressure. The consequence is that at approx. 60mbar the combustion speed of the flame is higher than the outflow of the gas, and thus the flame (usually burning in front of the nozzle) enters in contact with the nozzle, which starts glowing and is destroyed. If the pressure continues to drop a flashback might be produced. In principle, of course it is possible to use different nozzle sizes at the workplaces.

Advice: in case of several workplaces it is recommended to install a pressure indicator (manometer), which can be seen from all workplaces.

Number of possible workstations in connection with used max. nozzle size										
Type Inside-Ø nozzle	**0,5 (G 25)** 0,25 mm	**0,6 (G 23)** 0,30 mm	**0,7 (G 22)** 0,40 mm	**0,8 (G 21)** 0,50 mm	**0,9 (G 20)** 0,60 mm	**1,0 (G 19)** 0,65 mm	**1,2 (G 18)** 0,80 mm	**1,5 (G 17)** 1,00 mm	**1,8 (G 15)** 1,30 mm	**2,0 (G 14)** 1,50 mm
microflame 80	1	1	1	1	1	-	-	-	-	-
microflame 140	6	3	2	1	1	1	-	-	-	-
microflame 170	10	5	4	2	1	1	1	-	-	-
microflame 240	16	8	6	4	2	2	1	1	-	-
microflame 300	18	10	6	4	3	2	1	1	1	