

PANDJIRIS, INC

5151 Northrup • St. Louis, MO 63110 • (314) 776-6893

**120" INTERNAL/FLAT SHEET SEAMER
(MODEL 120-I/50-FS)**

The **Model 120-I/50-FS Internal/Flat Sheet Seamer** as described includes one copper back-up bar with back-up groove machined to customer's specifications, a water-cooled mandrel, two seam alignment gauges, a variable pressure aluminum fingers clamping system with foot controls, a safety air interlock on mandrel latch, and a machined side beam track for rack and pinion carriage travel.

- Welding Length 120" plus 3" overtravel at each end for starting and stopping on tabs.
- Part Configuration Cylinders minimum 50" I.D., flat sheets, and other configurations which can be placed in the throat of the seamer without structural interference.
- Base and Platen Heavy structural base equipped with wide steel platen. The platen has a machined dove tail groove to accept a removable back up bar. A parallel groove is machined the length of the platen for use with the removable seam alignment gauges. The base is plumbed for connection to an outside water source to enhance the heat sink capabilities of the seamer.
- Back Up Bar Copper with machined groove to support and shape weld puddle.
- Alignment Gauges Two removable alignment gauge blocks are provided with the seamer. The gauge blocks are designed to be inserted in the platen and reference the alignment of the plate being welded with the back up bar, weld joint and torch travel path.
- Material Thickness, Clamping020 through 3/8".
- Clamping Finger 6" wide aluminum, optional copper or stainless steel tips available.
- Clamping Actuation Industrial air bladder clamping, spring return.
- Clamping Pressure 0 to 200 pounds per linear inch.
- Air System Requires a clean 90 psi input. Includes filter/regulator/lubricator.
- Safety System Air interlock prevents clamping if the end latch is open.
- Track Blade Steel blade 3/4"x12" mounted on a 6"x8" box beam. The blade is equipped with pitch and yaw adjustment along the full length of travel. A precision gear rack is mounted on the back side of the blade for carriage travel.
- Carriage See Specification/Price Page G-1 & G-2.
- Electrical 115 Volt, Single Phase, 60 Hz.
- Controls Front and rear footswitch for finger clamping.

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| A | Clamping Length | 10' 6" |
| B | Overall Length | 17' 7-1/4" |
| C | Base Width | 43" |
| D | Mandrel Height | 21-5/16" |
| E | Overall Height | 59-9/16" |

Terms: Pandjiris, Inc. standard terms and conditions apply, f.o.b. Factory, St. Louis, Missouri, or designated ship point.

Delivery: Consult factory.
Approximate shipping weight: 9,450 lbs.

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| PRICE LIST | |
| For Bulletin No. : | Seamer |
| Effective Date : | July 1, 2000 |
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MODEL 120-I/50-FS INTERNAL/FLAT SHEET SEAMER Optional Accessories

For replaceable copper tipped fingers
For continuous copper strip mounted on finger clamping system
For replaceable stainless steel tipped fingers

For extra copper back-up bar (plain) 10'-8" long
To provide for gas back-up in copper bar
For extra stainless steel back-up bar (plain) 10'-8" long
To provide for gas back-up in stainless steel bar
For stainless steel back-up bar in place of standard copper bar

For water cooler for mandrel cooling system
For extra side beam track extension (per foot)
For power cable support track

For air operated ball transfer sheet elevators to clear back-up bar
and facilitate loading and unloading

WELD EQUIPMENT MOUNTING CHARGES

Pandjiris will mount and integrate welding head and control packages on the above seamer. The configuration of the mounting will typically include installation of the wire drive, torch, wire reel, flux hopper, wire drive control, and connection of all cables and hoses between the power source and wire feed control required for proper operation. Other accessories such as AVCs, slides, swivels etc. can also be mounted for an extra charge.

To Mount a Single Wire SUB-ARC package
To Mount a MIG package
To Mount a Cold Wire TIG package
To Mount a Fusion TIG package
To Mount an AVC with the above TIG packages

Mounting of one of the above weld packages requires a carriage, various slides and a 90° mounting bracket. These options can be found on Specification/Price Pages E-1, E-2, G-1, G-2.

NOTE: For customer supplied welding equipment, mounted by Pandjiris, there is a 15% handling charge based on the current list price of the equipment supplied.

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