

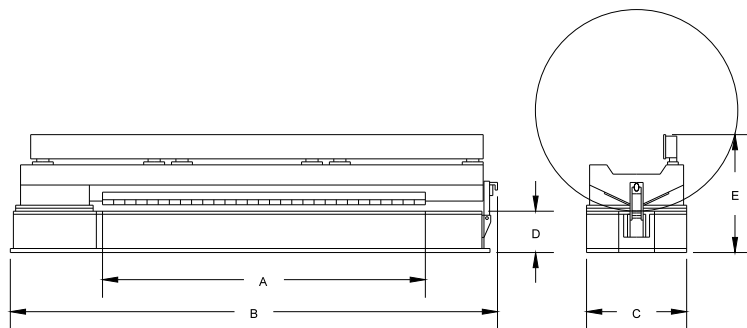
**PANDJIRIS, INC**

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

**168" INTERNAL/FLAT SHEET SEAMER  
(MODEL 168-I/50-FS)**

The **Model 168-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 ..... 168" 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, Clamping ..... .020 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.



A	Clamping Length	14' 6"
B	Overall Length	21' 7-1/4"
C	Base Width	43"
D	Mandrel Height	21-15/16"
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: 11,780 lbs.

<b>PRICE LIST</b>	
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## MODEL 168-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) 14'-8" long  
    To provide for gas back-up in copper bar  
For extra stainless steel back-up bar (plain) 14'-7" 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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