

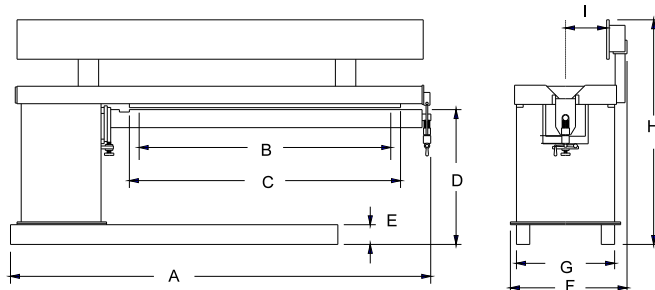
# PANDJIRIS, INC

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

## 72" EXTERNAL LONGITUDINAL SEAMER (MODEL 72E6-36)

The **Model 72E6-36 External Longitudinal 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 ..... 72" plus 3" overtravel at each end for starting and stopping on tabs.
- Part Configuration ..... Cylinders 6" I.D. to 36" O.D., flat sheets, and other configurations which can be placed on the mandrel without structural interference.
- Mandrel ..... 5-1/2" diameter steel pipe equipped with dove tail groove to accept a removable back up bar. 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 gauges are mounted on the seamer's upper clamping beam opposite the operator. The gauges are designed to pivot down along the centerline of the back up bar. They are used for referencing the alignment of the back up bar, weld joint and torch travel path.
- Material Thickness, Clamping ..... .020 through 3/8".
- Clamping Finger ..... 3" 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	Overall Length	122"
B	Weld Length	72"
C	Clamping Length	78"
D	Mandrel Height	43"
E	Base Leg Height	6"
F	Overall Width	34-7/16"
G	Base Width	28-1/4"
H	Overall Height	71-7/16"
I	Weld Centerline	11-3/16"

**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: 4,000 lbs.

### PRICE LIST

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## MODEL 72E6-36 EXTERNAL 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) 6'-7" long  
To provide for gas back-up in copper bar  
For extra stainless steel back-up bar (plain) 6'-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 adjustable mandrel height, provides 2" of lower mandrel adjustment  
For extra side beam track extension (per foot)  
For power cable support track

For removable column elevation riser block

For powered end latch  
For pneumatic seam alignment gauges

### 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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