

# PANDJIRIS, INC

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

## 1,500 LB. WELDING POSITIONER

**The Model 15-4 MVRHTFB Positioner** has a motorized variable speed rotation with Forward-Stop-Reverse switch and dynamic braking. The rotation speed is variable from 0.08 to 1.60 RPM with hand crank tilt infinitely variable through 135 degrees. A 24" square table with fixed height at 23-1/4" to allow full tilting capability is standard. All wiring conforms to National Electrical Code Standards. The positioner operates on 115-volt, single phase, 60 cycle input power, 10 amps. A field changeable plug-in hand pendant includes "Forward-Stop-Reverse-Weld/Rapid-E-Stop" buttons and a speed adjustment potentiometer on 25' of cable as standard. Control voltage is 24 VAC. Equipment is high frequency protected.

Load capacity ..... 1,500 lb. 4 inch overhung from face of table, 4-inch eccentricity.  
Swing radius.....20" @ 90° tilt.  
Rotational motor size ..... 1/2 H.P. DC motor.  
Rotation speed ..... Variable from .08 to 1.60 RPM.  
Rotation torque (R<sub>t</sub>) ..... 6,000-inch pounds.  
Tilt range ..... 0 through 135 degrees, hand crank.

**The Model 15-4 MVRMTAB Positioner** is the same as above except with motorized tilt and an adjustable base and a swing radius from 20" to 33" @ 90° tilt in three pinned hole locations. Draws 20 amps. Tilt Up/Down control located on the main electrical enclosure.

Tilt motor size..... 1/2 H.P. AC Brakemotor.  
Tilt Speed..... 135 degrees in 22 seconds.  
Tilt Torque (T<sub>i</sub>)..... 12,000-inch pounds inherent.

**The Model 15-4 MVRMT-VPL Positioner** is the same as Fixed Base unit except with vertical power lift via acme jack screw, linear rail guide bearings, 1hp Brakemotor, 30 IPM, overtravel limit switch protection. Up/Down push buttons momentary contact located in the side of the electrical enclosure next to the Tilt Up/Down push buttons. Table height infinitely adjustable between 26" and 38" above floor line. Rotation Centerline at 90 degrees forward tilt is 25" to 37" above the floor line with swing radius at 19" to 32".

## Optional Accessories

Foot switch with compatible plug for Forward/Stop/Reverse (speed potentiometer on hand pendant)  
Foot switch, Variable Speed with compatible plug  
Preset digital tachometer with compatible plug reads speed in RPM  
Dialweld®, (shows linear speed in IPM for diameter set on diameter selector. Dial diameter to be welded, dial weld speed, table RPM is automatically set to weld diameter at selected welding speed) digital meter with compatible plug reads IPM or CmPM  
Tach feedback for precision speed control  
25' Extension Cable with compatible plugs for standard pendants and accessories  
Model 600 PT Copper Welding Ground  
Model 1200 PT Copper Welding Ground  
OS-15 Outboard Support Stand, 1,500# capacity (For use with 15-4 Adjustable Base only)  
24" Diameter Round Table  
Hand Pendant with Tilt Up/Down in Addition to Standard Features, In Lieu of Standard Pendant  
Wireless Foot Switch or Wireless Hand Pendant

**Note:** The 15-4 Fixed Base positioner will not accommodate the OS-15 stand due to the positioner's limited height. In order to utilize the OS-15 stand with the 15-4 FB positioner, the positioner must be mounted onto a riser block. The design and fitness of purpose of such a riser block is the sole responsibility of the purchaser.

**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: 750 lbs.  
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### PRICE LIST

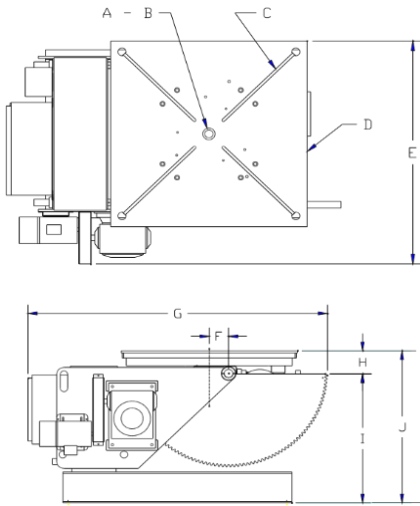
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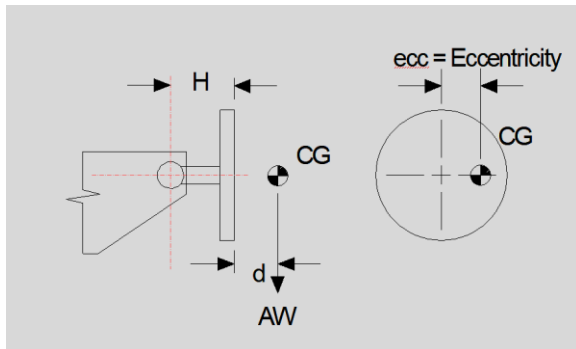
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|   |                       |                     |
|---|-----------------------|---------------------|
| A | Pilot Hole            | 2" $\phi$ x 1" Deep |
| B | Thru Hole             | 3/4" $\phi$         |
| C | "T" Slot Quantity     | 4                   |
|   | ANSI Std "T" Nut size | 1/2"                |
| D | Table Size            | 24" sq.             |
| E | Overall Width         | 30-1/4"             |
| F | Rotation Offset       | 3"                  |
| G | Overall Length        | 45-3/4"             |
| H | Inherent Overhang     | 4"                  |
| I | Tilt Axis Height      | 19-1/2"             |
| J | Table Height min      | 23-1/2"             |
|   | (3) Positions max     | 37-1/2"             |



| RATED OVERHUNG LOAD |             |
|---------------------|-------------|
| d (inches)          | AW (pounds) |
| 0 to 4              | 1,500       |
| 6                   | 1,200       |
| 12                  | 750         |
| 24                  | 429         |
| 30                  | 353         |
| 36                  | 300         |
| 42                  | 261         |

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