

PANDJIRIS, INC

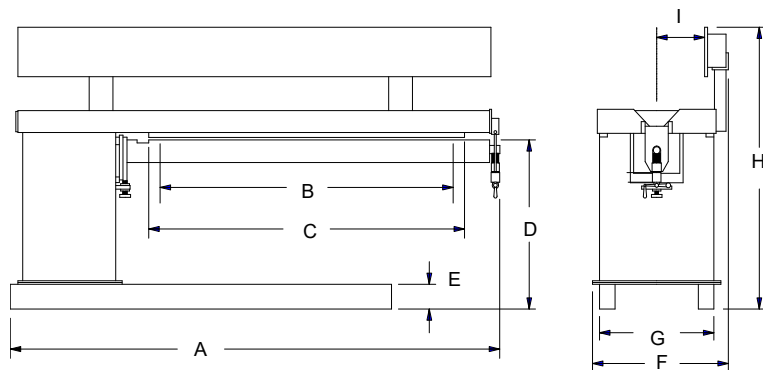
5151 Northrup • St. Louis, MO 63110 • (314) 776-6893

24" EXTERNAL LONGITUDINAL SEAMER (MODEL 24E3.5-30)

The **Model 24E3.5-30 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.....	24" plus 3" overtravel at each end for starting and stopping on tabs.
Part Configuration.....	Cylinders 3.5" I.D. to 30" O.D., flat sheets, and other configurations which can be placed on the mandrel without structural interference.
Mandrel	3-1/4" 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 backup bar. They are used for referencing the alignment of the backup bar, weld joint and torch travel path.
Material Thickness, Clamping020 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.

PRICE



A	Overall Length	73"
B	Weld Length	24"
C	Clamping Length	30"
D	Mandrel Height	37"
E	Base Leg Height	6"
F	Overall Width	33-5/16"
G	Base Width	28-1/4"
H	Overall Height	65-1/16"
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: 2,400 lbs.

PRICE LIST

For Bulletin No. : Seamer
Effective Date : January, 2014
Page Number : F-1

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MODEL 24E3.5-30 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) 2'-7" long
 To provide for gas back-up in copper bar
For extra stainless-steel back-up bar (plain) 2'-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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For Bulletin No. : Seamer
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Page Number : F-2