

## MILLER ELECTRIC / PANDJIRIS TEAMWORK

### SINGLE SOURCE AUTOMATION SOLUTION EXTERNAL LONGITUDINAL SEAMER WITH SUBMERGED ARC WELDING PROCESS



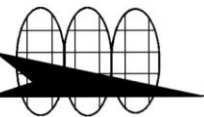
Pandjiris manufactures External, Internal and Flat Sheet Seamers from 24” to 710” weld lengths utilizing most weld processes designed for making 100% penetration, single pass welds on cylinders and flat sheets minimizing or eliminating heat distortion to the material.

The seamer shown here is capable of welding material 0.040” to 3/8” thick, up to 72” in length and up to 36” in diameter with a minimum 6” diameter. The seamer can be equipped with the weld process of the customer’s choice, including MIG, TIG, Plasma and SAW (both single wire and tandem).

### SYSTEM FEATURES

- Miller Sub Arc DC 1000 Power Source
- Miller SAW Digital Control
- Miller Low Speed RAD-400 Wire Drive
- Miller Hopper with Electric Gate
- Miller Spool and Hub Assembly
- Miller Wire Straightener
- Miller OBT 1200 SAW Torch
- Miller Insight Core Software Module
- Miller Insight Core Adapter
  
- Pandjiris Model 72E6-36 External Longitudinal Seamer
- Pandjiris Model VSC-15-3 Carriage – 3 to 133 IPM Travel Speed
- Pandjiris EZ Link Series® Controller
- Pandjiris Model 21-M Slide for Cross Seam Adjustment
- Pandjiris Model 61-AP Slide for Vertical Adjustment
- Copper Tipped Fingers
- Limit Switch/Return Home
- Weld Start/Stop Integration
- Power Cable Track for Carriage





### Features

- PLC based control technology
- Controls most Pandjiris DC motors
- For longitudinal welding and circumferential welding
- Solid-state circuitry
- Easy-to-read digital touch screen display
- User-friendly front panel layout
- Heavy-duty industrial pushbuttons
- Large mushroom head emergency stop switch increases safety
- Additional "Arc Start" outputs allow for multiple and tandem arc or starting ancillary equipment such as oscillators and flux recovery units.

### Operator Manual Functions

- Jog Fwd/Rev (at preset jog speeds)
- Jog Rapid Fwd/Rev (at preset rapid speed)
- Maintained Fwd/Rev Rapid Movement
- Dedicated Torch up/down Buttons
- Weld Start/Stop
- Travel Speed Adjustment

### Programmed Sequence Functions

- Travel Speed
- Weld Timer On/Off
- Weld Counter On/Off
- Weld Time
- Weld Distance
- Travel Start Delay
- Travel Stop Delay
- Pass Counter (Requires Limit Switch)
- Diameter (Circumferential only)
- Auto Torch Lift On/Off
- Torch Lower Time
- Torch Lift Time and Delay Time
- Return Home On/Off
- Home Delay Time
- Rapid Speed %
- Jog Speed %
- Auto finger unclamp on/off
- Finger unclamp time and delay time
- English or Metric units Display
- Weld direction selectable

## PLC-Based Controls

Pandjiris' EZ Link® Series Controllers are user-friendly, PLC-based controllers designed to provide flexibility for the operator. The EZ Link® Controllers put automated equipment control functions at your fingertips. Welding and motion functions are coordinated in an easy-to-use package.

EZ Link® Series controllers are perfect for new equipment and retrofitting your existing equipment, whether it's Pandjiris or another manufacturer.

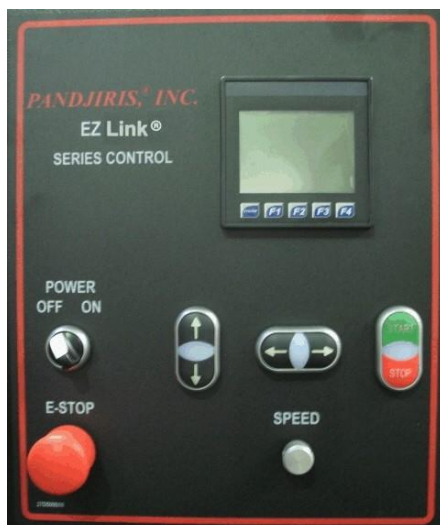
The front panel layout includes a large graphic touch screen display, 160 x 128 pixels. Custom-designed PLC program permits a wide range of programmed sequence configurations from English to Metric. Inputs into the PLC are isolated thru relays for optimum performance in welding environments.

## APPLICATIONS

**Longitudinal Welding:** The controller is standard on all Pandjiris travel carriages. Speed control, travel start and stop delays can be preset. The control will handle both the travel carriage motion and initiation of the weld sequence. Weld length can be controlled by a timer, limit switch, or optional distance encoder. An automatic home sequence can also be turned on/off if desired.

**Circumferential Welding:** The controller is also configurable for circumferential systems, including precision lathes, positioners, and head-and-tailstocks systems. Like the Longitudinal system, the controller includes speed control, travel start and stop delays, and the ability to initiate the weld sequence. When in the circumferential mode the controller automatically adjusts surface travel speed based on the part diameter input by the operator. A pass counter permits multi-pass welding with an optional pass counting limit switch arrangement. Weld degrees can also be preset and counted with our optional distance sensing encoder.

Contact your local Pandjiris representative or our St. Louis office to find out how the EZ Link® Series controller will make your life EZ'er!



## Specifications:

- PLC Based Control
- 115 VAC, 10 Amp Input
- Graphical Touch Screen Display
- 160 x 128 pixels Screen Display
- 12 Digital Inputs
- 4 DC In (High Speed)
- 10 Digital Outputs
- 4 Relay Outputs
- 2 Analog Output
- 2 Analog Inputs
- Dimensions: 15-1/2" T x 13" W x 8-5/8" D