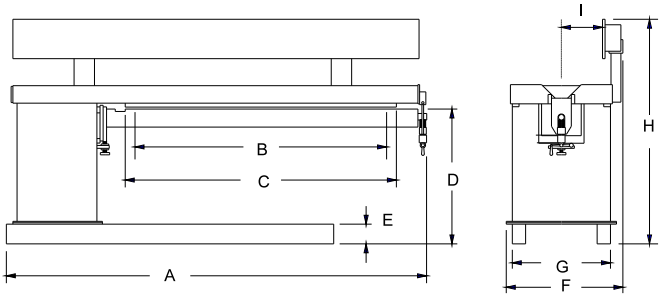
PANDJIRIS, INC
5151 Northrup • St. Louis, MO 63110 • (314) 776-6893

120" EXTERNAL LONGITUDINAL SEAMER (MODEL 120E9-36)

The Model 120E9-36 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	120" plus 3" overtravel at each end for starting and stopping on tabs.
Part Configuration	Cylinders 9" I.D. to 36" O.D., flat sheets, and other configurations which can be placed on the mandrel without structural interference.
Mandrel	8-1/2" 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	168-1/4"
B	Weld Length	120"
C	Clamping Length	126"
D	Mandrel Height	45"
E	Base Leg Height	8"
F	Overall Width	34-7/16"
G	Base Width	28-1/4"
H	Overall Height	73-7/16"
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: 6,500 lbs.

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MODEL 120E9-36 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) 10'-7" long
To provide for gas back-up in copper bar
For extra stainless steel back-up bar (plain) 10'-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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