

LSW-BP Technical Specification Data Sheet

AMET is pleased to provide the following technical specification for the LSW “precision bench” external style seam welder. The seam welder supplied to the customer will adhere to these specifications, unless modified in the proposal offered to the customer.



GENERAL SPECIFICATIONS & FEATURES

Nominal Weld Length	As specified in the Model Number of the system
Maximum Weld Length	Nominal weld length plus 75 mm (2.95”), allowing for run on/off tabs
Minimum Diameter	Dependent on weld length, please see chart on second page
Maximum Diameter	Depends on base support structure, either built by customer or optionally included with the order
Wall Thickness	.020 to 0.16” (0.5 to 4 mm)

TRACK & CARRIAGE ASSEMBLY:

Track Accuracy	+/- 0.005” over weld length (+/- 0.15 mm)
Track Design	Machined Structural Tube, fitted with linear square rails (THK style) on top and bottom
Track Adjustment	Included to provide required alignment with tabletop assembly
Carriage Speed	2 to 200 IPM (50 to 5000 mm/min) (other speed ranges are available as special order)
Carriage Drive	Precision ball screw & nut
Carriage Motor	DC Servo motor
Closed Loop Feedback	Included, using encoder
Speed Accuracy	+/- 0.5 % of set speed or better
Carriage Weight Cap.	100 lbs (45 kg) out 6” (150 mm) from carriage face

Carriage Face Dimension	6” x 8” (150 x 200 mm) minimum
Limit Switches	Included – home and end of travel
Carriage Control	Designed to operate using XMS-Linear, QII or XM Control using DSP technology (see XMS-Linear, QII or XM Control literature for more details)
Cable Carrier	Included, except on 75 and 150 models
Torch Mount Bracket	Included – with manual X-Y Slides for vertical and cross seam adjusting (Slide stroke = 3”/75 mm)

TABLE TOP & MANDREL ASSEMBLY:

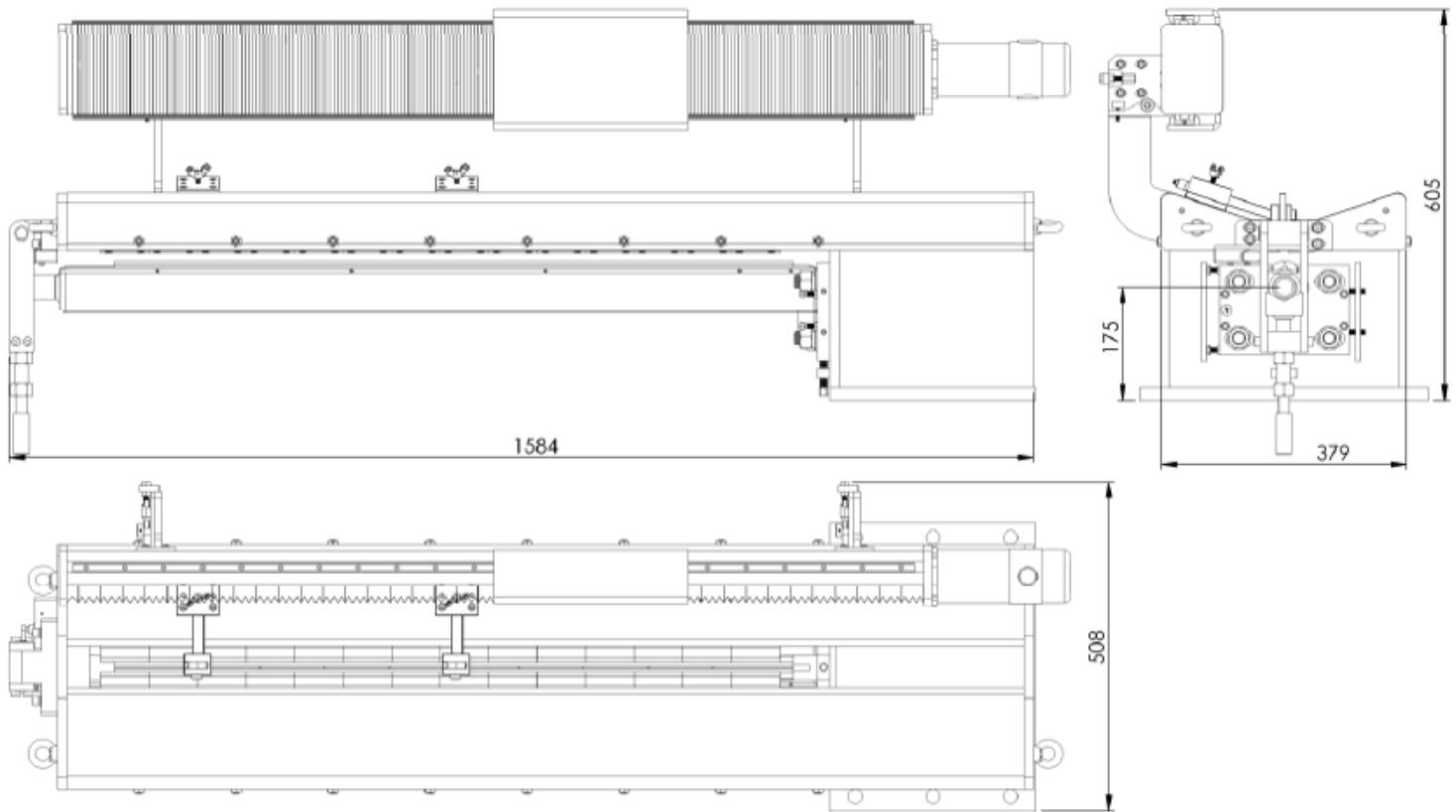
Water-cooled Mandrel	Optional on this model ONLY
Mandrel Adjustment	Included to handle various material thickness and for proper alignment
Mandrel Latch	Included, with safety switch and adjustment ability to insure mandrel is level
Insert	Includes one standard copper insert, with machined groove as specified
Clamping Activation	Tape switch, unless hand pendent or foot switches are requested
Clamping Force	Adjustable, up to 3500 lbs/ft (52 kg/cm)
Clamping Control	PLC
Safety Interlocks	Included – one to prevent clamping if mandrel latch is not engaged and the other is to prevent unclamping during welding (requires arc-on signal)
Clamping Fingers	Aluminum with reversible & replaceable copper finger tips
Cont. Clamping Strips	Optional
Finger Adjustment	1/8” to 1.2” (3 to 30 mm)
Clamping Design	Air, using one clamping hose per side
Centering devices	Includes two manually operated devices which can be located along the weld length incrementally
Vertical Mainstay	Only a section of the mainstay is provided, required to properly hold the mandrel in position. A base needs to be supplied by the customer, or optionally included by AMET

SERVICE REQUIREMENTS:

Air Requirements	60 PSI (5 kg/sq.cm or 0.4 MPa)
Power Requirements	120 or 220 volts, 50/60 hz, 1 ph (350 watts maximum)

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LSW-BP Precision Bench Style Seam Welders



Model Number	"A"	"B"	"C"	"D"	"E"	
	Welding Length *	Min. Part Diameter **	Overall Length	Overall Width***	Overall Height	Approx. Shipping Weight - Kg(lb)
LSW-BP-75	75 (2.95)	50 (1.97)	1780 (70)	1050 (42)	1850 (73)	1090 (2400)
LSW-BP-150	150 (5.9)	55 (2.17)	1930 (76)	1050 (42)	1850 (73)	1160 (2550)
LSW-BP-300	300 (11.8)	60 (2.36)	2080 (82)	1050 (42)	1850 (73)	1230 (2700)
LSW-BP-450	450 (17.7)	65 (2.56)	2235 (88)	1050 (42)	1850 (73)	1550 (3400)
LSW-BP-600	600 (23.6)	70 (2.76)	2385 (94)	1050 (42)	1850 (73)	1820 (4000)
LSW-BP-750	750 (29.5)	80 (3.15)	2690 (106)	1050 (42)	1850 (73)	2130 (4685)
LSW-BP-900	900 (35.4)	90 (3.55)	3000 (118)	1050 (42)	1850 (73)	2400 (5280)

* All models include an extra 75 mm (2.95") weld length on each end for Run On/Off tabs

** Maximum Part Diameter depends on support structure supplied by customer or optionally included by AMET

*** Overall width does not include cable carrier, add an extra 4" (100 mm) for the cable carrier.

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