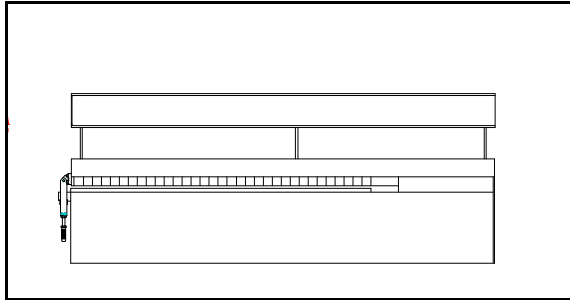


LSWI Technical Specification Data Sheet

AMET is pleased to provide the following technical specification for the LSWI “standard” internal style seam welder. The internal 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 4” (100 mm), allowing for run on/off tabs
Minimum Diameter	Either 48”, 54”, or 60” (1220, 1375, or 1525 mm), depending on weld length
Maximum Diameter	As can be conveniently handled by the end customer
Wall Thickness	.020 to 3/8” (0.5 to 10 mm)

TRACK & CARRIAGE ASSEMBLY:

Track Accuracy	+/- 0.015” per 10ft of weld length (+/- 0.4 mm per 3 meter)
Track Design	Machined Structural Tube, fitted with linear square rails (THK style) on top and bottom
Track Adjustment	Included to provide required alignment with table top assembly
Carriage Speed	A = 4 to 150 IPM (100 to 3800 mm/min) B = 2 to 75 IPM (50 to 1900 mm/min)
Carriage Drive	Precision Gear rack with pinion gear
Carriage Motor	DC motor
Closed Loop Feedback	Included, via encoder
Speed Accuracy	+/- 1.0% of set speed
Carriage Weight Cap.	330 lbs (150 kg) out 12” (300 mm) from carriage face
Carriage Face Dimension	14’ x 27” (360 x 680 mm)
Limit Switches	Included – home, end of weld and end of travel
Carriage Control	QII, XMS and XM controls with DSP technology (See controller tech Specs for more details)

Cable Carrier/Hanger	Included - on weld lengths from 1200 to
Torch Mount Bracket	Optional

TABLE TOP & MANDREL ASSEMBLY:

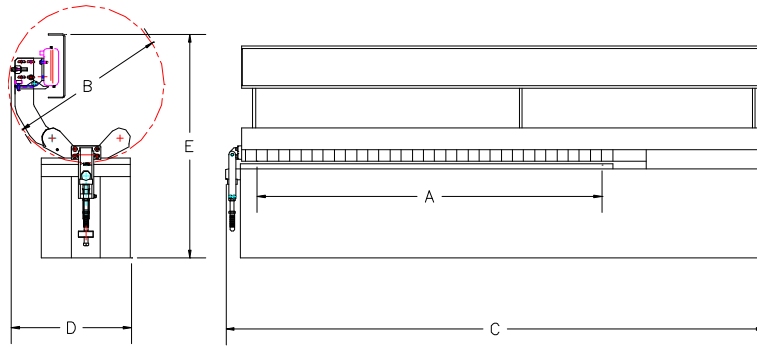
Water-cooled Mandrel	Included (cooler is optional)
Mandrel Adjustment	Included to handle various material thickness
Mandrel Latch	Included, with safety switch and adjustment ability to insure mandrel is level
Insert	Includes one standard copper insert, with machined groove as specified
Clamping Activation	Hand pendent, or foot switches if requested
Clamping Force	Adjustable, up to 5000 lbs/ft (75 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
Clamping Fingers	Aluminum with reversible & replaceable copper finger tips
Finger Adjustment	1/8” to 1.2” (3 to 30 mm) Optional: 0.55” to 1.73” (14 to 44 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	Integral part of base section

SERVICE REQUIREMENTS:

Air Requirements	80 PSI (8 kg/sq.cm or 0.6 MPa)
Power Requirements	120 or 220 volts, 50/60 hz (350 watts maximum)

LSWI Technical Specification Data Sheet

LSWI Standard Internal Style Seam Welders



Model Number	"A" Welding Length *	"B" Min. Part Diameter **	"C" Overall Length	"D" Overall Width	"E" Overall Height	Approx. Shipping Weight - Kg(lb)
LSWI-1200	1200 (47.2)	1220 (48.0)	3100 (122)	1050 (42)	1170 (46)	2220 (4900)
LSWI-1500	1500 (59.0)	1220 (48.0)	3400 (134)	1050 (42)	1170 (46)	2350 (5200)
LSWI-1800	1800 (70.8)	1220 (48.0)	3700 (146)	1050 (42)	1170 (46)	2490 (5500)
LSWI-2100	2100 (82.6)	1220 (48.0)	4015 (158)	1050 (42)	1170 (46)	2715 (6000)
LSWI-2400	2400 (94.4)	1220 (48.0)	4320 (170)	1050 (42)	1170 (46)	3000 (6500)
LSWI-2700	2700 (106.3)	1220 (48.0)	4625 (182)	1120 (44)	1375 (54)	5225 (11,500)
LSWI-3000	3000 (118.2)	1375 (54.0)	4925 (194)	1120 (44)	1375 (54)	5455 (12,000)
LSWI-3300	3300 (129.9)	1375 (54.0)	5235 (206)	1120 (44)	1375 (54)	5680 (12,500)
LSWI-3600	3600 (141.7)	1375 (54.0)	5535 (218)	1120 (44)	1375 (54)	5900 (13,000)
LSWI-3900	3900 (153.5)	1375 (54.0)	5845 (230)	1120 (44)	1375 (54)	6140 (13,500)
LSWI-4200	4200 (165.3)	1375 (54.0)	6150 (242)	1120 (44)	1375 (54)	6350 (14,000)
LSWI-4800	4800 (188.9)	1375 (54.0)	6755 (266)	1170 (46)	1425 (56)	6820 (15,000)
LSWI-5400	5400 (212.6)	1525 (60.0)	7370 (290)	1170 (46)	1425 (56)	7250 (16,000)
LSWI-6000	6000 (236.2)	1525 (60.0)	7975 (314)	1170 (46)	1425 (56)	7700 (17,000)
LSWI-6600	6600 (259.8)	1525 (60.0)	8575 (338)	1220 (48)	1425 (56)	8200 (18,000)
LSWI-7200	7200 (283.5)	1525 (60.0)	9175 (360)	1220 (48)	1425 (56)	8600 (19,000)

* All models include an extra 50mm (2") weld length on each end for Run On/Off tabs

** Maximum Part Diameter is based on capability of customer's ability to handle part. Typically an overhead crane is required to support larger diameter parts with long lengths.

Note: On most internal applications, the cylinder will have to include some tack welds to help hold the part together to assist the operators in loading and clamping the part correctly.

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