

PS Series

LONGITUDINAL SEAM WELDER



The fixed height mandrel is incorporated into the machine base with provision to attach gas purge and water cooling capability if necessary, water cooling requires an in-house water supply or water chiller with pump. A replaceable copper backing bar is attached to the top of the mandrel. Retractable alignment mechanisms are provided for aligning the plate. Machine equipped with aluminum clamping fingers for maximum conduction of heat away from weld and to prevent arc blow caused by magnetization of the ram (Optional replaceable copper tipped fingers tips are available). A stainless steel pressure support plate is provided at the loading end of the machine to guard against machine magnetization.

Full-length precision custom side beam runs the full length of the machine. Side beam assembly is adjustable for aligning and leveling with mandrel and weld joint. The travel carriage is a rack and pinion design to provide positive travel. A cable carrier with supporting shelf is provided on rear of side beam to support and capture incoming cables and hoses to welding head.

Carriage over-travel limit switches and adjustable weld length limit switches are standard.

The side beam with rack and pinion driven carriage and optional welding equipment can be arranged to allow for specified travel lengths.

Machine is freestanding and all controls are built into rear frame. Nema 4/12 Enclosure, with Circuit Breakers. A remote pendant control is provided for operator convenience with 1-Turn Potentiometer, Start/Stop, Forward/Reverse, and Auto/Manual Selector Switch. Operation of pressure finger banks is individual and controlled by foot treadle. A Microprocessor is used to control many welding wire functions, including speed control, start/stop delays, and wire retract distance. Standard controls include air pressure regulator. Primary Voltage: 115/1/60

Internal, External and Flat Plate Models



KOIKE ARONSON, INC. / RANSOME

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Features

- ◆ Rack and Pinion powered carriage
- ◆ Optional Copper tipped hold down fingers
- ◆ Water cooled back-up bar
- ◆ Gas Purge back-up bar
- ◆ Standard plate thickness up to 3/8"
- ◆ Powered torch lifter available
- ◆ Welding equipment can be provided or Customer supplied
- ◆ Special Engineered Solutions



SPECIFICATIONS SUBJECT TO CHANGE

Specifications



Longitudinal Weld Seamers

SPECIFICATIONS, External Weld Seamer	LS-48	LS-60	LS-72	LS-96	LS-120	LS-144
Effective Seam Length	48"	60"	72"	96"	120"	144"
Maximum Plate Thickness	3/8"	3/8"	3/8"	3/8"	3/8"	3/8"
Mandrel Diameter	4"	5"	6"	6"	8"	10"
Min. Part Diameter	4-1/2"	5-1/2"	6-1/2"	6-1/2"	8-1/2"	10-1/2"
Max. Part Diameter	36"	36"	36"	36"	36"	36"
Standard working Height	45"	45"	45"	45"	45"	45"
Shop Air required	100 P.S.I.	100 P.S.I.	100 P.S.I.	100 P.S.I.	100 P.S.I.	100 P.S.I.
Std. Voltage	115/1/60	115/1/60	115/1/60	115/1/60	115/1/60	115/1/60

SPECIFICATIONS SUBJECT TO CHANGE

**Specification shown for standard External Longitudinal Weld Seamers.
Please consult factory for Internal, flat plate and special requirements.**



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