



WELDING &
POSITIONING

SEAM WELDER

INTERNAL, EXTERNAL, AND FLAT PLATE MODELS



SIMPLY BETTER BUILT.

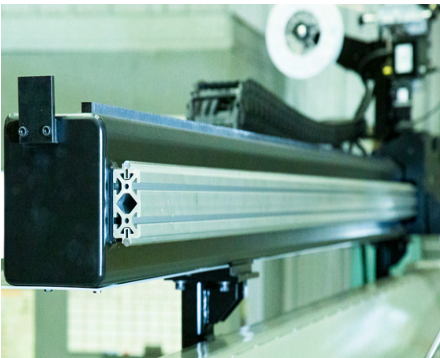




Freestanding with fork truck pockets located in seamer base for mobility.

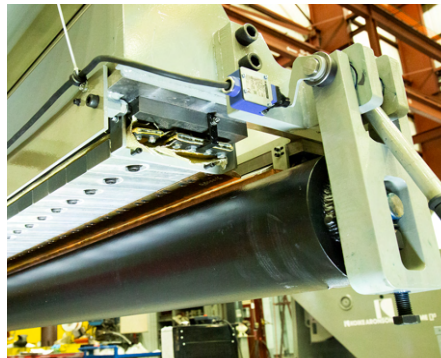
Longitudinal seam welder provides accurate cylinder manufacturing that is simply and cost effective to operate

Designed to accept multiple welding processes including MIG, TIG and SAW, utilizing a +/- 0.009" travel accuracy over 10 feet. A unique hand held Human Machine Interface (HMI) makes operation simple and reliable.



Drive system

A powered rack and pinion drive carriage traverses a replaceable full-length linear round way with an additional 6" of travel allowing for 3" start and run-off tabs. A cable carrier is included for all incoming cables and hoses.



Construction

Heavy walled mandrel includes integrated water cooling tube, isolation between mandrel and beam reduces magnetization. Standard copper tipped hold-down fingers and back-up bar insure heat dissipates quickly from weld seam.



Clamping

Two-stage clamping included, directly from HMI or included foot pedals. Individually adjustable clamping pressures for alignment and final clamping, retractable alignment mechanisms for seam positioning along mandrel.

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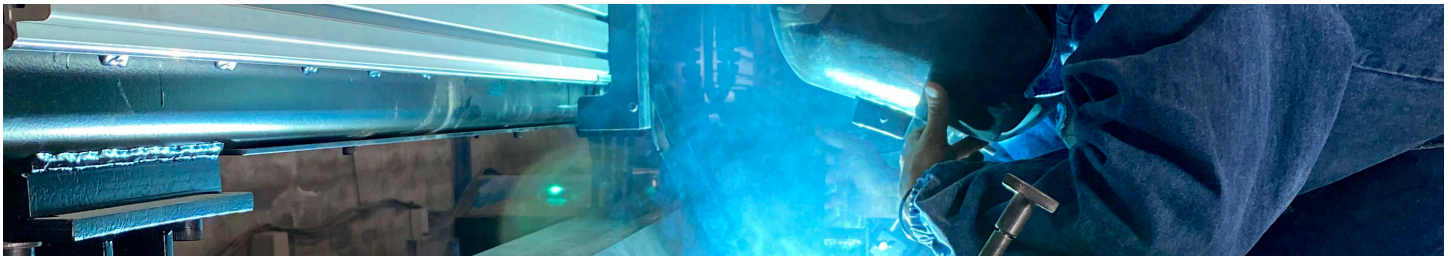
Model	LS-48	LS-60	LS-72	LS-96	LS-120	LS-144
Effective weld seam length	48 Inches	60 Inches	72 Inches	96 Inches	120 Inches	144 Inches
Maximum plate thickness	3/8 Inch	3/8 Inch	3/8 Inch	3/8 Inch	3/8 Inch	3/8 Inch
Mandrel diameter	4 in	5 in	5 in	5 in	8 in	8 in
Minimum part inside diameter	5 in	6 in	6 in	6 in	9 in	9 in
Maximum part diameter	36 in	36 in	36 in	36 in	36 in	36 in
Standard working height	45 in	45 in	45 in	45 in	45 in	45 in
Machine weight capacity	600 lbs	750 lbs	900 lbs	1200 lbs	1500 lbs	1750 lbs
Seam gap range	1/4 - 1-1/4 in	1/4 - 1-1/4 in	1/4 - 1-1/4 in	1/4 - 1-1/4 in	1/4 - 1-1/4 in	1/4 - 1-1/4 in
Carriage travel	54 in	66 in	78 in	102 in	126 in	150 in
Carriage weight capacity	500 lbs	500 lbs	500 lbs	500 lbs	500 lbs	500 lbs
Carriage speed	160 - 6 ipm	160 - 6 ipm	160 - 6 ipm	160 - 6 ipm	160 - 6 ipm	160 - 6 ipm
Shop air required	100 psi	100 psi	100 psi	100 psi	100 psi	100 psi
Standard machine voltage	115/1/60	115/1/60	115/1/60	115/1/60	115/1/60	115/1/60

Standard Features

Water cooled mandrel
Copper tipped hold down fingers
up to 1-1/4" spacing between fingers for torch tip
Two stage clamping sequence
Auto retract to start position

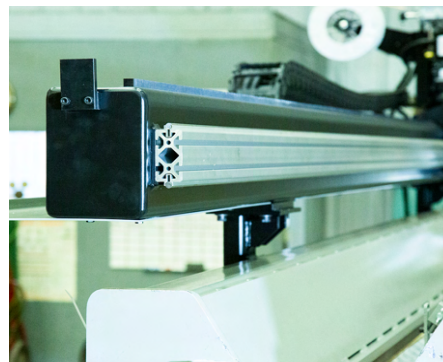
Options

Custom height risers for larger diameters
Adjustable part stops
Stainless clamping fingers
Material handling cart for loading
Laser pointer for visual carriage travel



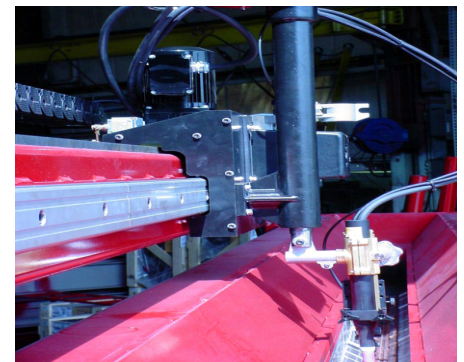
Equipment integration

Seamers can be purchased with a specified welding package, mounted and integrated directly from Koike or customers can mount existing or new packages on their own.



Back purge

Includes incoming gas solenoid controlled directly from HMI. Purge can be toggled on/off in manual mode or run in auto mode with start and stop delays, tied to arc on/off.



Optional Torch Lifter/slide

Powered torch lifter to adjust torch height and auto lift before carriage retract, or manual 5x5 cross slide for manual adjustment.

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HMI Control Features

Hand held 5.7 inch high-resolution display with E-Stop

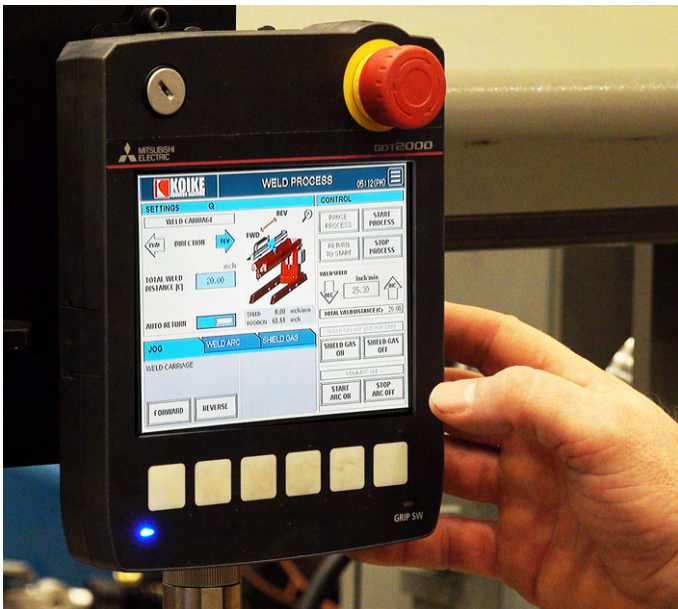
Four (4) operation Modes, Jog/Run/Position/Index

Programmable carriage speed and travel distance

Auto return to start position

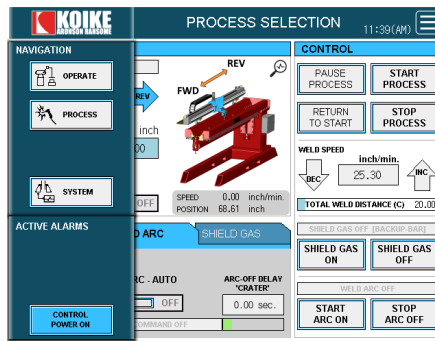
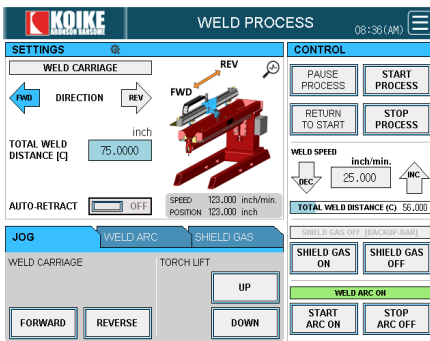
Automated weld arc ON/OFF with travel

Soft limits, no limit switches to fail



*Specifications are subject to change without notice

SMARTER CONTROLLER



Weld Carriage Controls

Forward / reverse direction
Jog to position
Total Weld Distance
(Optional) Back purge with programmable start / stop delay

Weld Process

Weld speed
Auto arc on
Motion delay (puddle)
Arc-off delay (crater)
Shield gas - Auto on or manual
Shield gas (pre-flow/ post flow) time

Diagnostics

Event messages with time and date
Status
Input / Outputs log
Errors / faults



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