

| ENG

WELDING SEAMERS

Horizontal or vertical

carpano.it

WELDING SEAMERS

Horizontal or vertical

The experienced user knows that the clamping bench is a particular machine that requires different attentions on each application.

On the following pages we show you just a few of the possible solutions, with the promise that in case of your requests we will certainly be more exhaustive. In any case, each machine already includes PLC as standard, in order to be able to manage at best all the possible variants.



We reserve the right of modifying the technical features of machinery as stated herein and we do not respond for any printing mistake.

All rights reserved. Text and images can be reproduced only after our written authorization.

- The updated version is the one in our web site



Horizontal for external welding on Central parts of tanks or flat sheet metal.



Horizontal for internal welding on central part of tanks or flat sheet metal.



Vertical model Meridiano.

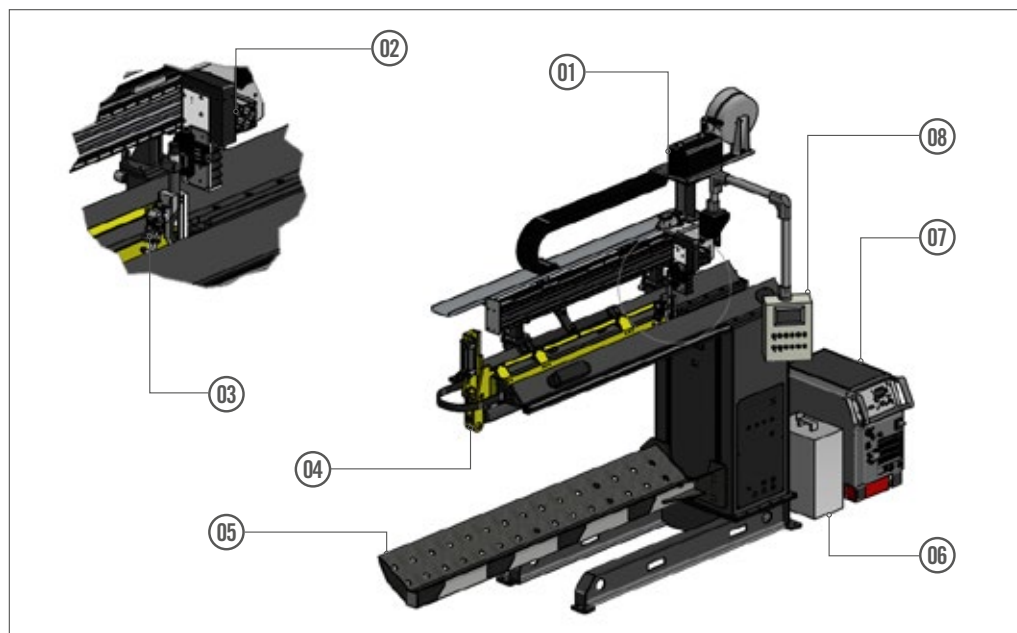
The vertical positioning of the workpiece, although the welding is more difficult, allows easier handling of large-sized workpieces.

Thus, Ø 500 to 12,000 mm can be welded.

Welding heights are usually 1,500 or 2,000 mm.

Meridiano 15 in the picture.

Each welding seamer has its own specific customizations, below is an example of a seamer set up for TIG welding in cold wire



1. VPR-4WD cold wire feeder with controls integrated into the seamer HMI
2. AVC, for torch height control, recommended for TIG and Plasma welding on seamers with lengths greater than 1000 mm. Alternatively, a pneumatic slide is installed
3. CEFF wire guide slide
4. Pneumatic latch for bar closure
5. Saddle for easy entry and exit of the workpiece, with adjustable height
6. Chiller for copper bar and torch
7. Welding generator, which can also be connected via digital interface, to associate JOB of the generator to each PLC program
8. Control panel with 7" touch screen
 - Ability to store at least 200 different programs
 - For each program setting of:
 - Carriage and vertical slide rest position
 - Welding speed in mm/min, starting position and length
 - Starting and finishing ramp
 - Job of the welding machine
 - Wire feeder parameters: speed , start delay, wire return, start and arrival ramp, pulsed or continuous wire
 - AVC parameters: rest and start height, arc voltage, trip delay and rise

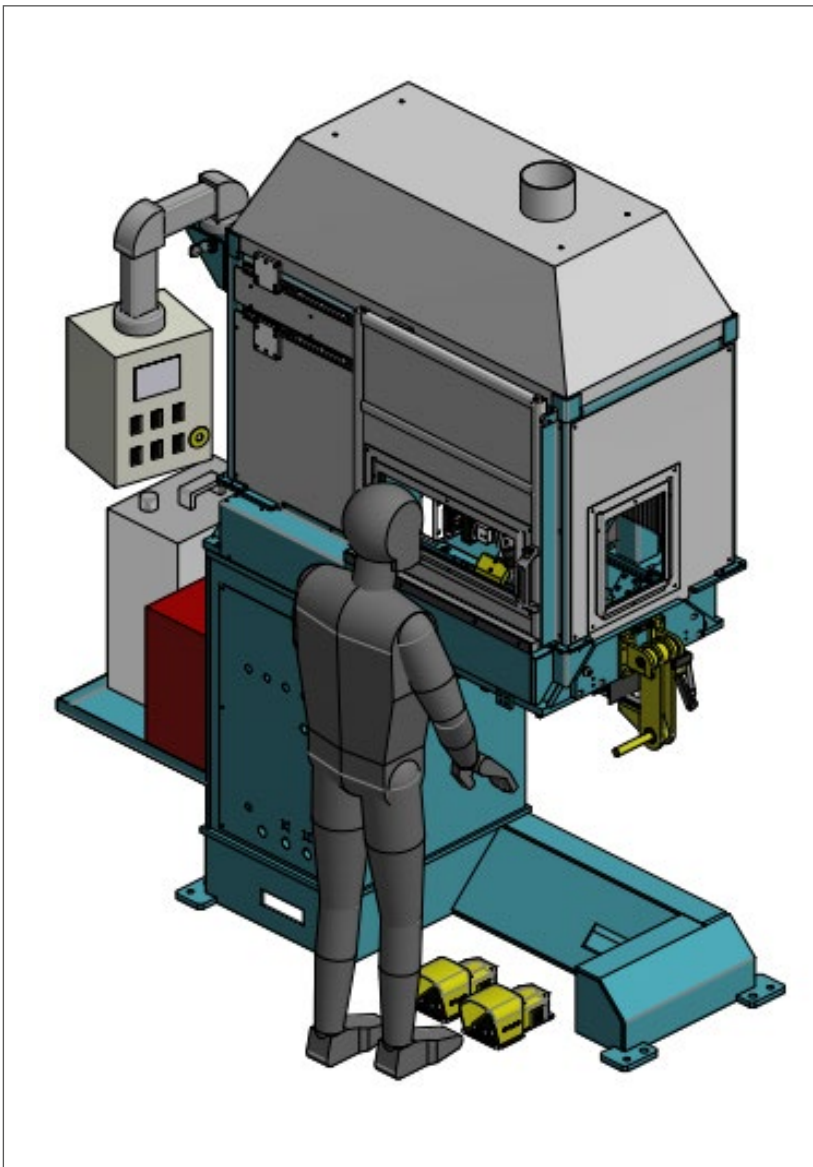
Important information to be able to make you an offer:

- External welding - internal welding - flat sheets
- Max length of pipe or sheet metal to be clamped
- Min and max thickness
- Material to be welded
- Desired welding process
- Bar with or without liquid cooling and with or without reverse gas

Some special executions



BP seamer with support saddle manually height adjustable. The same can also be supplied with motorized adjustment.



BP seamer with a length of 0.5 m, in special execution with protective cabinet and fume hood.

Double inactinic glass for observation of the welding arc.

VERTICAL SEAMERS 1500 or 2000 mm



STANDARD FEATURES

It's designed for automatic vertical seam welding of flat sheets or of cylinders Ø 500 mm or greater, thickness 0.8 to 3 mm without stitch welding, up to 10 mm with stitches, clamping lengths 1550 or 2050 mm.

Thanks to the robust structure of the mandrel, it doesn't need to install any AVC sensor.

After welding, a gear motor lifts the mandrel to allow unloading the job.

Description

- Base structure made of steel profiles and machined
- Steel mandrel with back-up copper bar
- Back-up copper bar fit for cooling (cooling unit not included)
- Back-up gas flow
- Pneumatic clamping by independent foot switches
- Side beam carriage driven by DC gear motor and rack&pinion transmission;
- The carriage is made of aluminium and it moves on linear ball bearing linear guides. On demand: wire feeder support
- 2-axis PLC cabinet with 5" touch screen complying with CE norms
- Pneumatic slide to release the torch after welding
- Cross slide (stroke 80 mm) for micrometric adjustment of the torch
- Centring jigs driven by pneumatic cylinders<<

Work cycle

MANUAL work cycle:

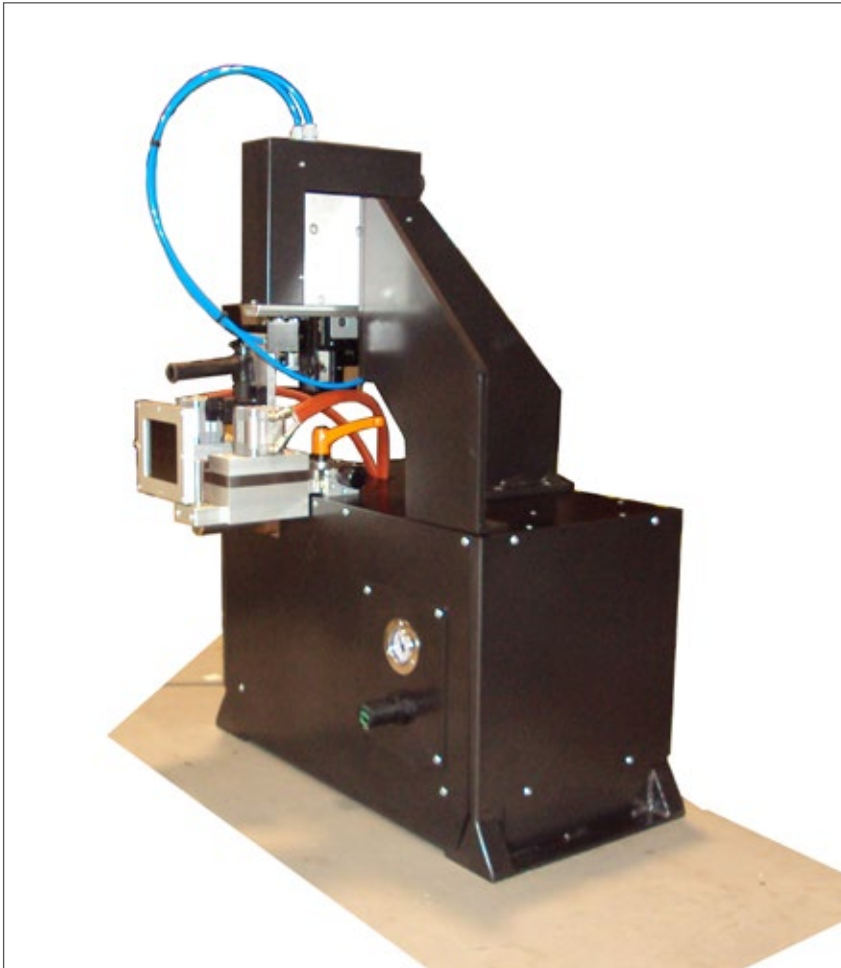
- Positioning of the left edge
- Clamping of left edge
- Positioning of the right edge
- Clamping of right edge

AUTOMATIC work cycle:

- Carriage onward from home to weld start position
- Down stroke of pneumatic slide and arc ignition
- Start delay and cold wire start (if any)
- Welding to recorded weld end position
- Arc extinction and post gas time
- Upstroke of pneumatic slide
- Carriage backward to home position



PARALLELO DESK SEAMER



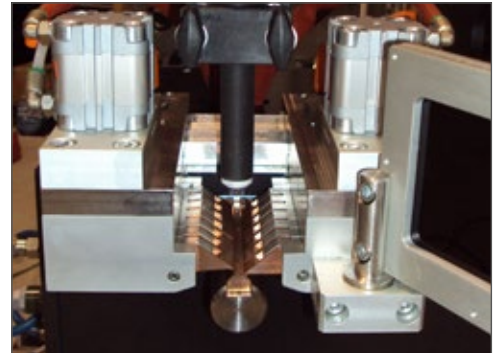
High precision for thin walls

Provided of pneumatic clamping fingers, it is suitable for vessel walls and for flat plates as thin as 0.2 mm.

Micrometric adjustment of fingers in between distance is made by high precision slides.

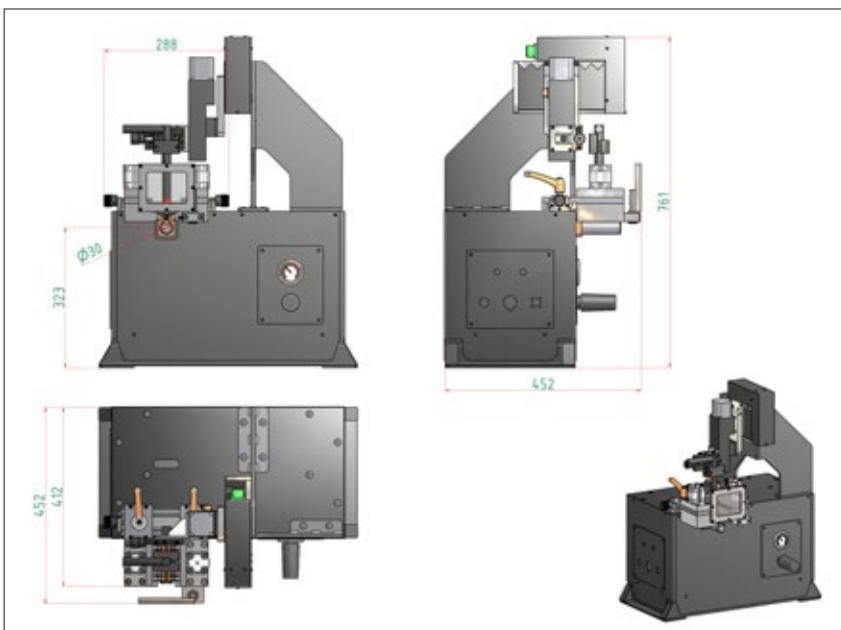
Torch longitudinal traversing by MM MINI 180 motorized by DC motor with encoder and driven by ball screw on ball linear guides.

Torch up/down strokes by JD PNEUMO 80 pneumatic slide.



Work cycle stepped by PLC with 3.5" soft touch screen, which allows setting of:

- Weld start point.
- Weld longitudinal stroke mm.
- Speed mm/min.
- Start delay sec.
- Torch up stroke delay in sec.



PARALLELO DESK

| | |
|------------------|---------------|
| Ø min -max | 35 - 300 |
| L min - max | 10 - 150 |
| Thickness | 0,2 - 3 mm |
| Gas back up | yes |
| Bar cooling | no |
| Feeding | 230 V - 50 Hz |
| Working pressure | 2 - 6 bar |



NOTE

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.



GENERAL SUPPLY CONDITIONS

1. SUPPLY OBLIGATION ARRANGEMENT

The following general terms of business are always to be considered applicable to every order made by the buyer. Therefore, any supply clause written by the buyer on his orders or any other document given to the seller, which may result to be conflicting with the present general conditions, will be considered not written. The buyer has to forward the orders to the seller in writing. The seller reserves the authority to accept telephone and verbal orders. The order is to be considered executed when the buyer receives the written acceptance of the same (order confirmation) by the vendor or, in the absence thereof, automatically 15 days after the order receipt by the seller. All offers and prices are just an indication and are not binding. Therefore the seller considers himself to be bound only to what is declared in his order confirmations.

2. TERMS FOR DELIVERY

The delivery dates indicated by the seller as well as the ones written on the buyers' orders have to be considered just as an indication and are not binding and are subject to the punctual supply by the buyer of all the specifics, to the variations due to the availability of the goods with the suppliers or to reasons of force majeure: delays in the delivery due to said availability variations are not attributable to the seller, who is not in duty bound to the compensation for damages suffered by the buyer. Reasons of force majeure have also to be considered the accidents (industrial injury, disease, etc) and any other circumstances which may cause a total or partial job reduction, as well as the lack of raw materials, troubles with transportation, etc. The seller reserves the authority to suspend the delivery of the goods if the buyer has not seen to the payment of the invoices relative to other supplies whose terms of payment are overdue. The goods are understood as being delivered for all intents and purposes to the buyer from the time they were picked up by the carrier or the buyer himself at the seller's warehouse.

3. PAYMENT AND TERMS OF PAYMENT

The payments have to be made to the seller's domicile and in accordance with the established conditions. In the event of a delay, the due amounts of money will automatically imply the charge of interests based on the official discount rate plus 5 points. In the event of a non-payment, the buyer is to be considered in default without the necessity of any formal notice by the seller. The presence of possible faults and/or defects in the products does not excuse the buyer for suspending the payment of the invoices. Should the client suspend and/or delay the payments, the seller may suspend the supplies, with the authority to consider the contract automatically terminated by rights and to demand for damages.

4. WARRANTY

CARPANO EQUIPMENT guarantees the products for a period of 24 months starting from the delivery date, for a daily work cycle of 8 hours. The warranty is intended ex works CARPANO EQUIPMENT. CARPANO EQUIPMENT guarantees the performance of its products in accordance with the instructions written in the relative manuals. For the products based on job orders, the warranty is pertaining to the specifics agreed with the client.

5. VOID WARRANTY

In case of any tampering or unauthorized intervention the warranty shall be deemed void.

6. LIABILITY FOR DAMAGE

The seller's liability is limited only to the obligations above and it's expressly agreed that the seller does not accept any liability for damages resulting from any cause connected with the use and utilization of the sold products.

CARPANO EQUIPMENT is not responsible and for no reason whatsoever may the expenses be charged for:

- Machine downtime.
- Direct or in direct damage due to the non-operation of the equipment.
- Working hours spent to solve possible problems on the equipment.

7. RESERVATION OF OWNERSHIP

Until the payment in full of any credit resulting from business relations has taken place, included any additional credit and until the payment of bills and cheques has been made, the property in the goods remains in the seller.

8. COMPETENT COURT

It's established that the court of Bologna will be the sole competent court for every dispute relative to this contract.

9. APPLICABLE LAWS

The applicable law is the Italian law.



CARPANO EQUIPMENT Srl

Via del Legatore, 7 / 40138 Bologna Italy

T. +39 051 6053215 / e-mail: info@carpano.it

carpano.it