

centerline®

connecting needs with capabilities

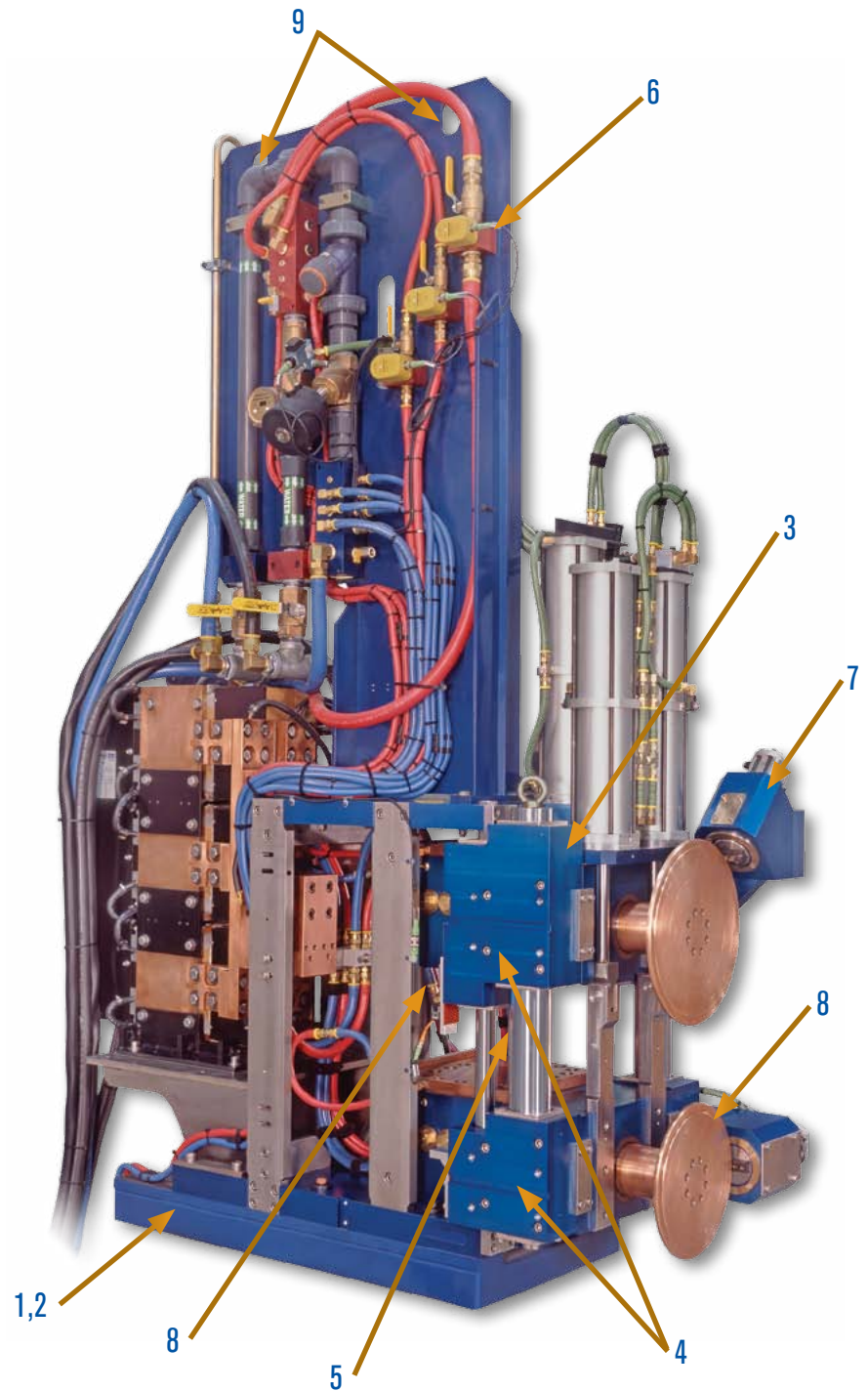
SeamTec™ Welder

Ver. 3.1

The SeamTec Advantage

Features

1. Designed for easy integration into roll mills, stand-alone or robotic applications.
2. Compact design allows for “on bed” mounting in roll mills adjacent to roll stand tooling and allows very tight stand-alone machine applications. Also allows for mounting on roll mill tooling rafts.
3. Self equalizing heads move linearly with little effort to help minimize force on the work piece and to provide automatic compensation for wheel wear or dressing.
4. Upper and lower head assemblies are interchangeable so less spares are required.
5. Designed with maintenance in mind. Main equalizing shafts “tip out” to allow the front end be lifted out as a package for service and head replacement.
6. All services on board, complete with water flow indicators for all circuits to help prevent over heating.
7. In-line automated wheel dressing is available that can accommodate both coated and uncoated materials.
8. Wheel wear limits are clearly indicated on wheels but a safety switch ultimately alerts of maximum wheel wear.
9. Lifting holes for moving entire welder.



Additional Features:

- Very low height from mounting surface to “pass line” eliminates the need to “split” roll tooling into two mills or have drive shafts wrap around as on typical floor mounted seam welders.
- No synchronization of drive speeds required between the material speed and welder. In most cases the wheels are driven by the part flow.
- High force capabilities combined with Mid Frequency DC welding technology allowing welding of high strength steels. (AC versions available on SeamTec1200 only)
- Travel speeds typically range from 100–180 mm/sec (20–35 feet/min.) depending on materials and weld requirements; 203 mm/sec (40 feet/min.) has been achieved for some applications.

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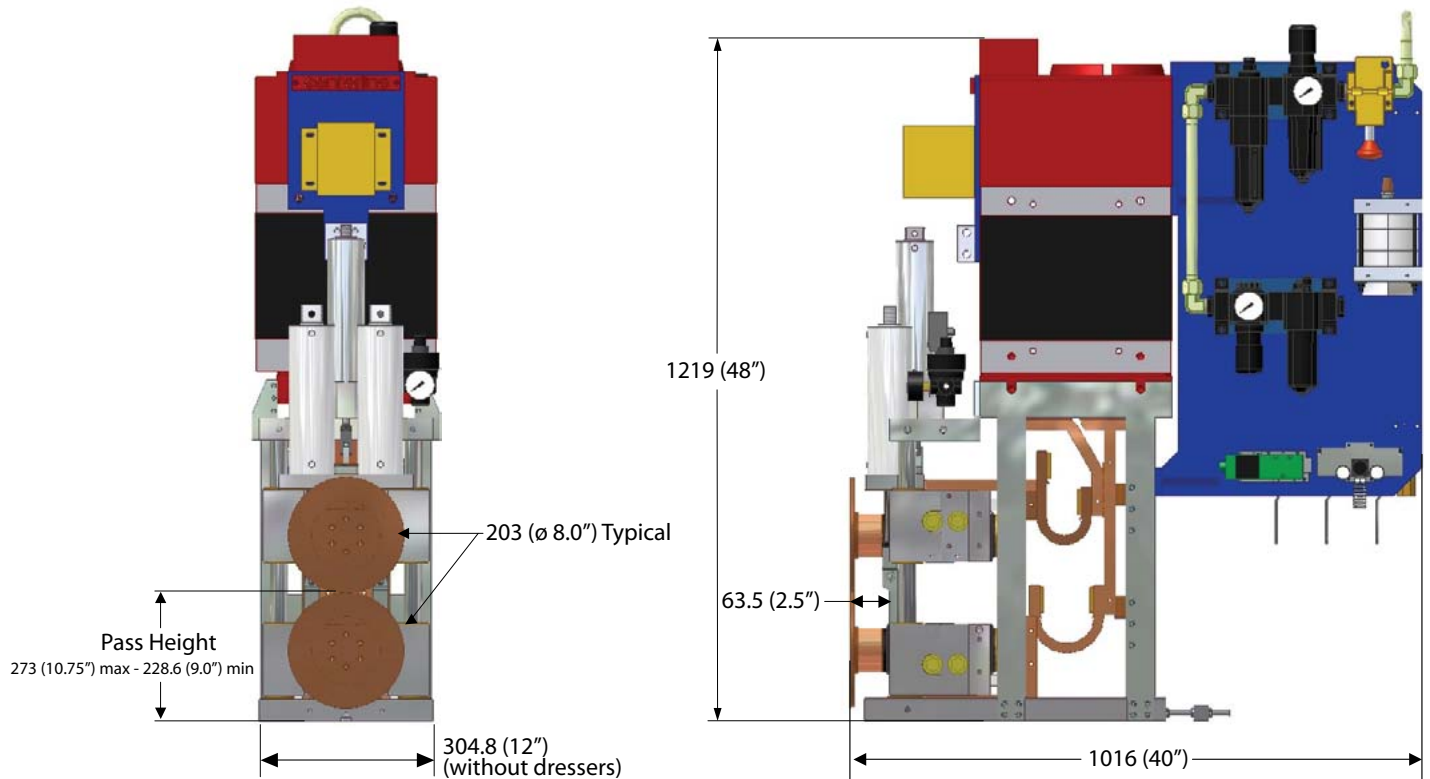
Specifications

Size		SeamTec 1200	SeamTec 3000	SeamTec 4000
Overall Width	mm (inches)	300 (11.81)	300 (11.81)	600 (23.62)
Max. Weld Force	N (lbs)	5337 (1200)	13344 (3000)	17792 (4000)
Standard Wheel Dia.	Max. Upper	mm (inches)	203 (8)	300 (11.81)
	Min. Upper	mm (inches)	120.6 (4.75)	238 (9.37)
	Max. Lower	mm (inches)	203 (8)	240 (9.45)
	Min. Lower	mm (inches)	120.6 (4.75)	168 (6.61)
Standard Wheel Thickness	mm (inches)	6.35 (0.25)	8 (0.31)	12.7 (0.50)
Max. Equalization with Max. Standard Wheels	mm (inches)	47 (1.85)	138.5 (5.45)	150 (5.90)
Max. Wheel Opening with Max. Standard Wheels	mm (inches)	48 (1.90)	140 (5.51)	152.5 (6.00)
Transformer Size	kVA	175	500	250/375
Weight (approx.)	kg (lbs)	567 (1250)	840 (1850)	1111 (2450)

Minimum Service Requirements	
WATER (GPM)	AIR PRESSURE (PSI)
10	85
38	85
38	85

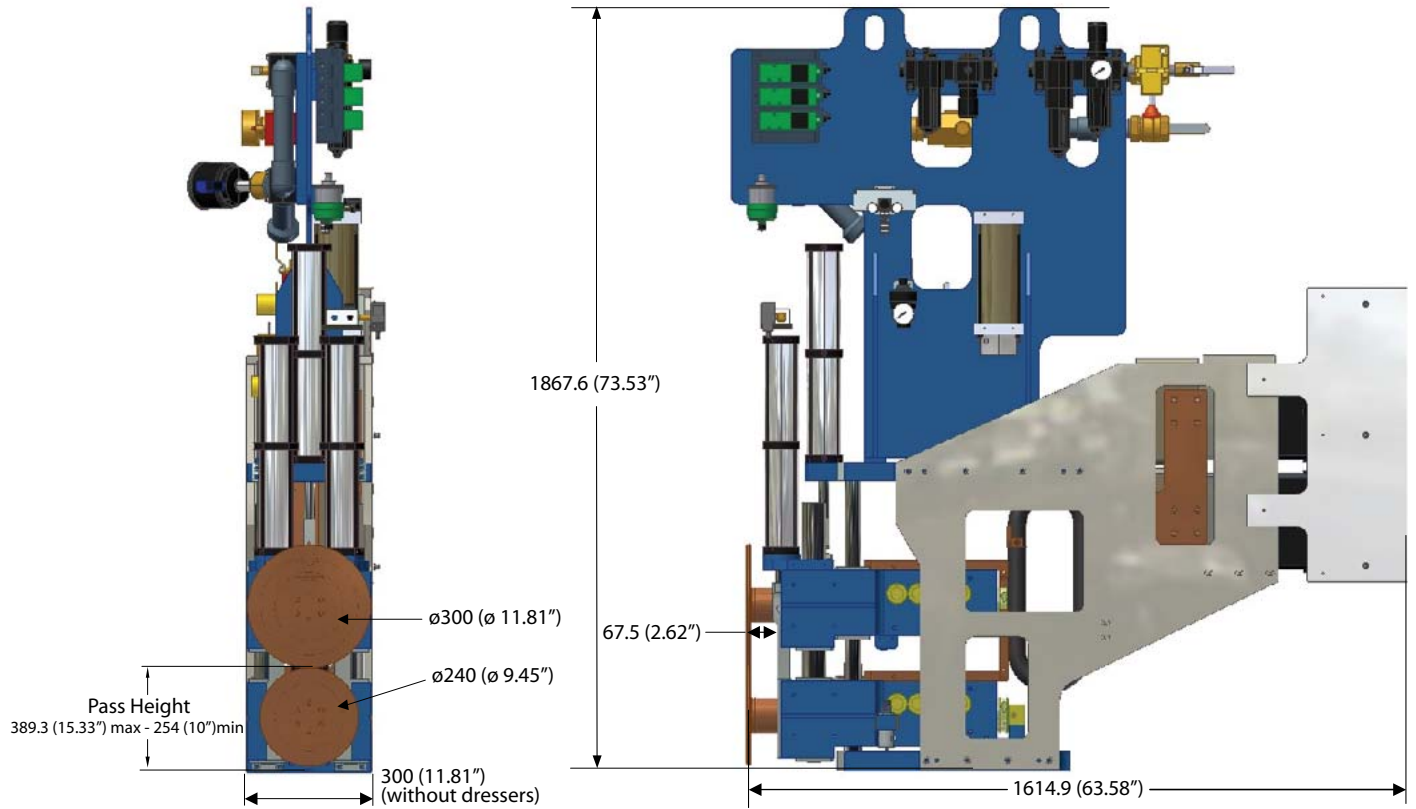
Electrical current requirements will vary depending on application. Contact CenterLine for specific information.

SeamTec 1200

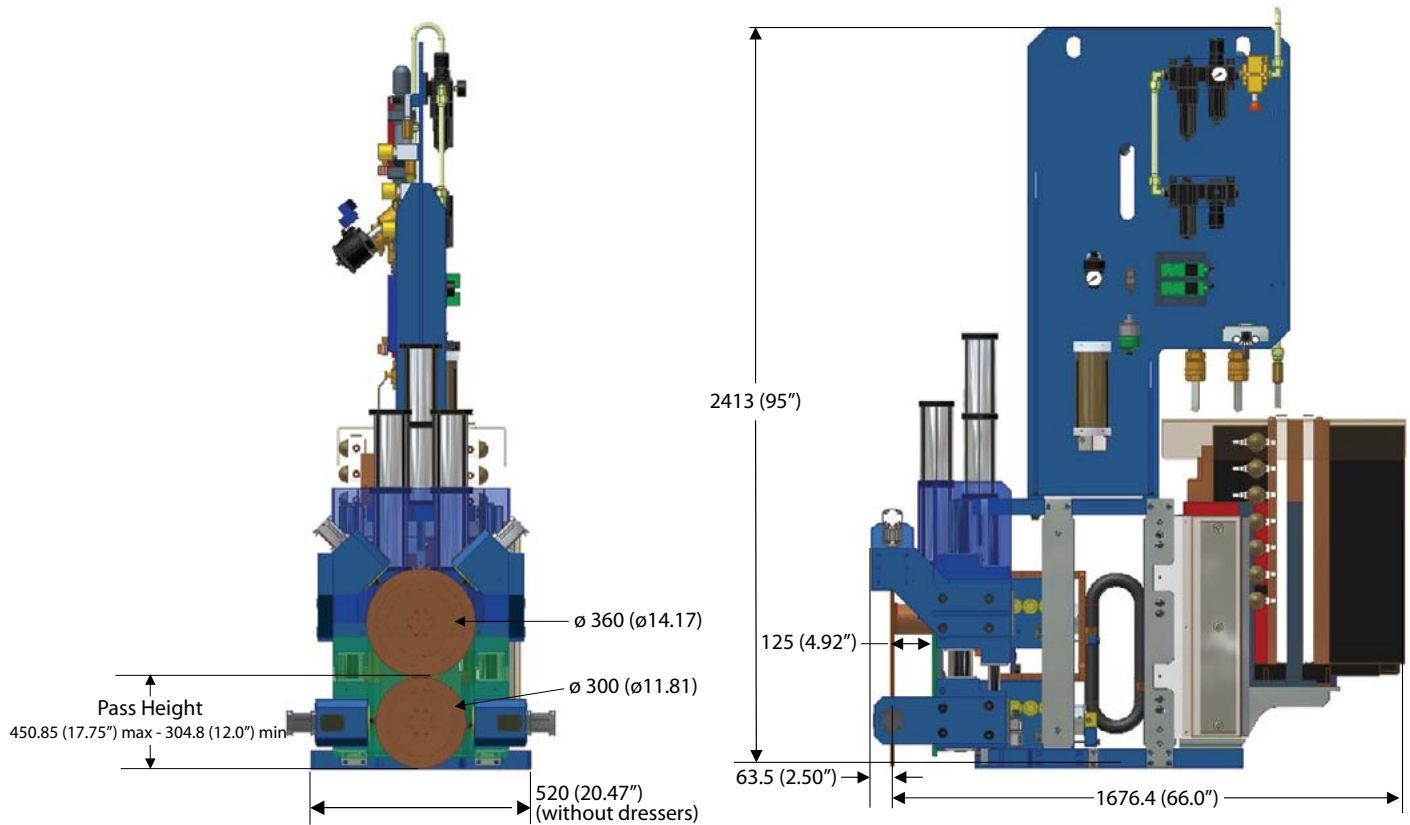


Dimensions shown are: mm (inches)

SeamTec 3000

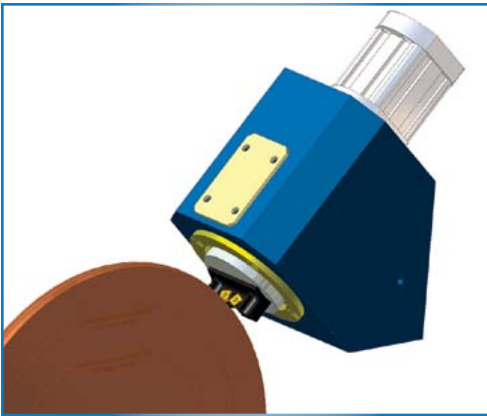


SeamTec 4000

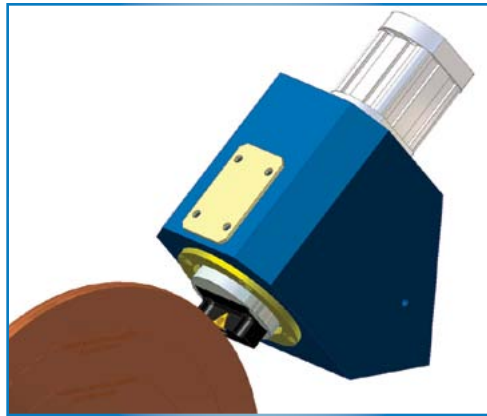


Dimensions shown are: mm (inches)

Wheel Dressers (Optional)



Dresses Sides of Wheel



Dresses Outer Edge of Wheel

Application Data

Material Type	<input type="checkbox"/> HSLA <input type="checkbox"/> HSS <input type="checkbox"/> MS	Material Thickness	<input type="checkbox"/> mm <input type="checkbox"/> inches
Material Stack Up	<input type="checkbox"/> 2T	<input type="checkbox"/> 3T (List thickness for each, if different)	
Coating	<input type="checkbox"/> Bare <input type="checkbox"/> Galvanneal <input type="checkbox"/> Galvanized		
Weld Speed	<input type="checkbox"/> mm/second <input type="checkbox"/> feet/min.		
Weld Spacing	<input type="checkbox"/> mm <input type="checkbox"/> inches	Min. Nugget Size	<input type="checkbox"/> mm <input type="checkbox"/> inches
Part Geometry	Clearance requirement	<i>Sketch</i>	
Primary Voltage	<input type="checkbox"/> 460 V <input type="checkbox"/> 575 V		
Installation Footprint	<input type="checkbox"/> Stand-alone <input type="checkbox"/> In Line <input type="checkbox"/> Roll Mill <input type="checkbox"/> Special mounting considerations		
Pass Line Height (Roll Mill Applications)	<input type="checkbox"/> mm <input type="checkbox"/> inches	<i>Sketch</i>	
Available space between Roll Mill stands	<input type="checkbox"/> mm <input type="checkbox"/> inches	<i>Sketch</i>	



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