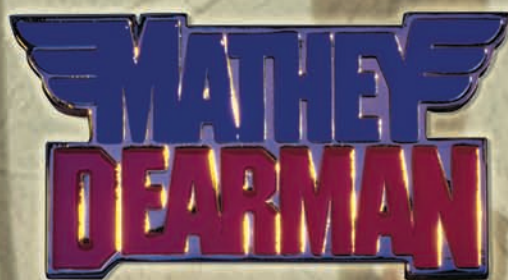



2010-2011
CATALOG



WHERE THERE'S PIPE, THERE'S MATHEY

A large-scale industrial scene showing a massive circular pipe being cut by a machine. The cutting process creates a dense spray of bright orange sparks that fill the center of the frame. In the background, several workers in white hard hats and safety gear are visible, along with various pieces of heavy machinery and structural elements of an industrial facility under a clear sky.

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Pipe Alignment and Reforming Clamps
Welding Electrode and Flux Ovens
Pipefitter's Tools**

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Thousands of dollars in labor are lost annually by companies continuing to use old-fashioned methods to align pipes and fittings, such as weld-on lugs, hydraulic bottle jacks, or ratchet cable pullers, to critically align pipe ends. Companies today cannot afford the loss in productivity or to have their product rejected if it fails to meet alignment criteria.

Personnel are sometimes asked to hold a heavy pipe or fitting in place while the welder tack welds the pipe to the fitting. This process presents a risk of back injury to the person holding the pipe or fitting. Also, the valve or fitting is sometimes incorrectly aligned and the tack welds must be removed and reworked.

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Who uses Mathey Dearman Equipment?

Oil Refineries • Pipelines • Tank Farms • Power Plants • Steel Mills • Paper Mills
• Utilities • Shipyards • Food Processing Plants • Construction Contractors •
Chemical Plants • U.S. Military Installations • Offshore Drilling Platforms • Natural
Gas Pump Stations

.....AND MANY OTHERS! (see page 85)

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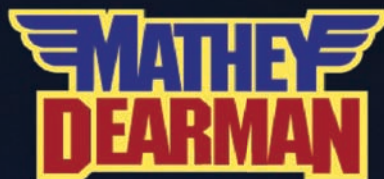
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WHY USE OUR CUTTING AND BEVELING MACHINES?



HAND CUTTING

Time: 30 Minutes

8" Schedule 40 Pipe being cut by hand.
Time includes measuring,
cutting and grinding.

- Longer than necessary layout time.
- Excessive amount of time to cut the pipe
- Inaccurate/uneven cut requiring grinding
- Extended fit-up time
- Uneven weld gap



MATHEY CUTTING

Time: 6 Minutes

8" Schedule 40 Pipe being cut
with a 1SA Saddle Machine.

- Perfect Cut
- No Grinding
- Perfect Fit-up



SADDLE MACHINES (Manual)

CE Approved

A Satisfied Mathey Customer:

"Just a brief note to say I am very pleased with my Mathey Short Saddle Machine ... it is older than I am and it has had new parts and pieces ... but it still performs very well and makes fast, accurate bevels. I keep it in a storage box when not in use, and always buckle it to a piece of pipe between cuts; so it has yet to be dropped!"

Most of my pipe work is bulk fuel storage facilities; setting tanks and piping them and the pumping systems. I perform all my work to ASME Code, with a super fit-up for welding in half the time ... hence the importance of these great little bevelers. It is good to find a product that does what it is intended to do, year after year.

"Keep up the good work!"

Sean M. Tatham

NORTH COUNTRY WELDING & MACHINE

Saddle Machine Kit Includes:

- Base machine
- Fully adjustable torch arm
- Torch carrier assembly - for mounting of torch arm
- Spacer bolts or step spacers are required to mount machine to different pipe sizes
- Parts and operating manual
- 6SA and 8SA also includes extension plate and spacers

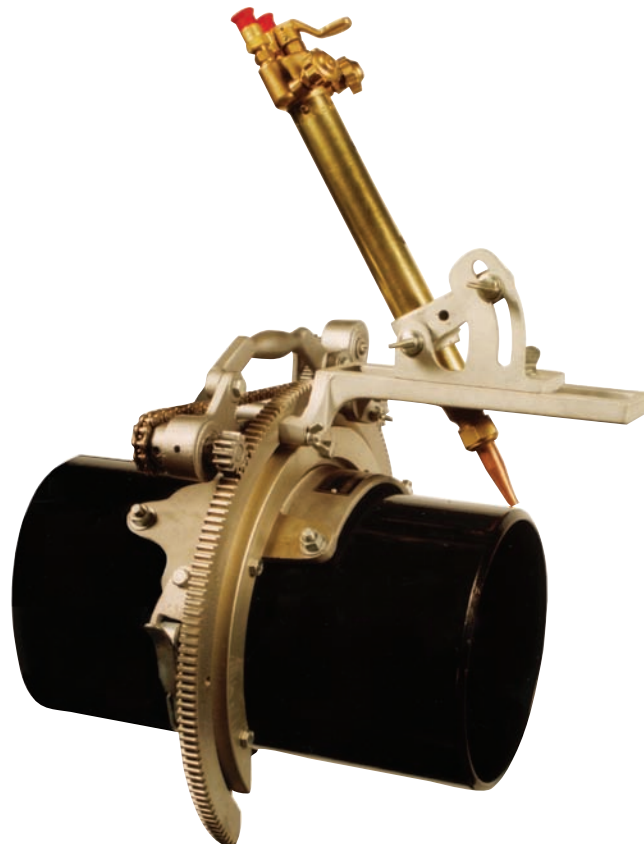
Extension plate and spacers lower torch arm and torch carrier assembly in relationship to the surface of the pipe, so the smaller diameters can be cut with a 10" plasma or Oxy/fuel machine torch.

Not Included:

- Machine cutting torch
- Storage box

Dependable and tough, the **Saddle Machine** was specifically designed for critical pipe applications that require a high degree of cut quality and accuracy. The lightweight, durable machine has been known for more than 70 years as the standard in the industry due to its long life, reliability and cutting accuracy. Both inexperienced and experienced welders can improve efficiency, accuracy and cut quality. Models available for pipe sizes 1 1/2"-48" (38mm-1219mm).

- **PORTABLE**—The light compact unit is an excellent tool for shop or field applications.
- **ACCURATE**—The spacer bolts, located on both sides of saddle, give the machine the accuracy required when cut quality and accuracy is critical.
- **EASY SET-UP**—Requires little or no operator skill or training to set up and achieve an accurate cut.
- **PROVEN**—The saddle, ring gear and cap ring are made of aluminum that is hard anodized to hold accuracy and last longer.



1SA Manual Short Saddle Cutting and Beveling Machine with 12" cutting torch (torch sold separately)



- **ADAPTABLE**—Can be used with oxy/fuel or plasma machine torch with 1 3/8" barrel diameter.
- **BUILT TO WITHSTAND** the construction, fabrication and welding jobsite environment.
- Up to 80% **FASTER** than hand cutting and grinding.

SADDLE MACHINES



MSA
Pipe Size Range
1.5"-4" / 38mm-102mm



1SA
Pipe Size Range
3"-8" / 76mm-203mm



2SA
Pipe Size Range
6"-12" / 152mm-305mm



3SA
Pipe Size Range
12"-20" / 305mm-508mm



4SA
Pipe Size Range
20"-26" / 508mm-660mm



5SA
Pipe Size Range
24"-30" / 610mm-762mm



6SA
Pipe Size Range
28"-36" / 711mm-914mm



8SA
Pipe Size Range
40"-48" / 1016mm-1219mm

Saddle Machine Quick Selection Chart

Machine Model	MSA	1SA	2SA	3SA	4SA	5SA	6SA	8SA
Manual with Spacer Bolts	03.0100.000	03.0101.000	03.0102.000	03.0103.000	03.0104.000	03.0105.000	03.0106.000	03.0108.000
115 vac Motorized with Spacer Bolts 230 vac	03.0100.M00 03.0100.M02	03.0101.M00 03.0101.M02	03.0102.M00 03.0102.M02	03.0103.M00 03.0103.M02	03.0104.M00 03.0104.M02	03.0105.M00 03.0105.M02	03.0106.M00 03.0106.M02	03.0108.M00 03.0108.M02
Manual with Step Spacers	-----	03.01S1.000	03.01S2.000	-----	-----	-----	-----	-----
115 vac Motorized with Step Spacers 230 vac	-----	03.01S1.M00 03.01S1.M02	03.01S2.M00 03.01S2.M02	-----	-----	-----	-----	-----
Pipe Size	in / mm	1.5-4 / 38-102	3-8 / 76-203	6-12 / 152-305	12-20 / 305-508	20-26 / 508-660	24-30 / 610-762	28-36 / 711-914 40-48 / 1016-1219
Net Weight	lbs / kg	10 / 5	16 / 7	26 / 12	50 / 22	75 / 34	110 / 50	180 / 82 287 / 130
Estimated Shipping Weight	lbs / kg	12 / 5.4	24 / 11	34 / 15.5	73 / 33	150 / 68	185 / 84	295 / 134 415 / 188
Shipping Dimensions	in / mm	12 x 12 x 10 / 305 x 305 x 254	18 x 18 x 11 1/2 / 457 x 457 x 492	23 x 23 x 12 1/2 / 584 x 584 x 318	34 x 32 x 12 / 864 x 813 x 305	40 1/2 x 41 x 19 / 1029 x 1041 x 423	40 1/2 x 41 x 19 / 1029 x 1041 x 423	57 x 43 x 18 / 1488 x 1002 x 483 69 x 60 x 21 / 1753 x 1524 x 533
Max. Speed (Motorized)	ipm* / mpm**	141 / 3581	71 / 1803	89 / 2261	47 / 1194	53 / 1346	34 / 864	35 / 889 36 / 914
Min. Speed (Motorized)	ipm* / mpm**	4 / 102	4 / 102	6 / 152	7 / 178	7 / 178	8 / 203	5 / 127 5 / 127
Includes Spacers to cut pipe sizes***		2", 3", 4" / 51, 76, 102mm	3", 4", 6", 8" / 76, 102, 152, 203mm	6", 8", 10", 12" / 152, 203, 254, 305mm	12", 14", 16", 18", 20" / 305, 356, 406, 457, 508mm	20", 22", 24", 26" / 508, 559, 610, 660mm	24", 26", 28", 30" / 610, 660, 711, 762mm	28", 30", 36" / 711, 762, 914mm 40", 42", 48" / 1016, 1067, 1219mm

* Inches per minute ** Millimeters per minute

SADDLE MACHINES (MOTORIZED)

Saddle Machine Kit Includes:

- Base machine
- Torch arm
- Torch carrier assembly - for mounting of torch arm
- Boomer assembly - fastens the machine to the pipe
- Spacer bolts for mounting to different sizes of pipe
- Parts and operating manual
- 6SA and 8SA also includes extension plate and spacers
Extension plate and spacers lower torch arm and torch carrier assembly in relationship to the surface of the pipe, so the smaller diameters can be cut with a 10" plasma or Oxy/fuel machine torch.
- Mounting bracket
- Right angle DC drive motor
- Motor control box

Not Included:

- Machine cutting torch

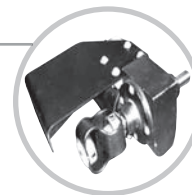
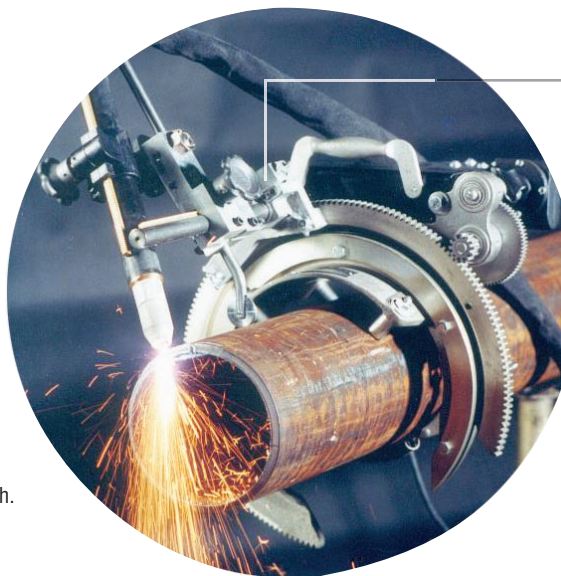
The **light weight durable motorized short saddle machine** is known throughout the welding industry for its longevity, dependability and precise cutting accuracy. The intent of the 115 vac and 230 vac 50/60Hz Motorized Saddle Machine is to rotate a cutting torch around the surface of a steel pipe, while producing a smooth high quality cut.

To accomplish accuracy and speed, the inexperienced as well as the experienced welder can improve productivity and quality. Smooth and precise cuts that require little or no grinding can be made with the Motorized Short Saddle Machine.

The **Motor Control Box**, with forward-stop-reverse positions and a rheostat, controls the rotational speed of the torch around the pipe. The motorized machines are available for pipe sizes 1 1/2" - 48" (38 - 1219mm).

- **EASY SET-UP**—requires little or no operator skill or training to set up and achieve an accurate cut.
- **ADAPTABLE**—Can be used with most plasma machine torches.
- **PRECISE**—The spacer bolts or step spacers, placed on both sides of ring gear, give the machine the ability to produce a high quality cut with extreme accuracy.
- **90% FASTER**—as it virtually eliminates grinding cleanup after cutting.

FAST ENOUGH FOR PLASMA!



Motorizing Kit for Short Saddle Machine Includes:

- All hardware required for assembly
- Assembly instruction sheet
- Operating manual
- 115 or 230 vac motor control box

Optional: Motorizing Kit for Manual Machines

The **Short Saddle Machine Motorizing Kit** is easily added to or removed from the Saddle Machine in minutes. The 115 vac and 230 vac, 50/60Hz Motorizing Kits gives the Saddle Machine the ability to produce cuts and bevels with accuracy, consistency and speed.

- **INCREASED PRODUCTIVITY**
- **ACCURATE CUTS**, with no need for grinding.
- **PLASMA SPEED**—the Motorizing Kit will rotate the plasma torch around the pipe at plasma speed.

Model	115 vac Part Number	230 vac Part Number	Shipping Weight (lbs / kg)
MSA	03.0100.A01	03.0100.A02	7 / 3.2
1SA	03.0101.A01	03.0101.A02	7 / 3.2
2SA	03.0102.A01	03.0102.A02	8 / 3.6
3SA	03.0103.A01	03.0103.A02	9 / 4.1
4SA	03.0104.A01	03.0104.A02	9 / 4.1
5SA	03.0105.A01	03.0105.A02	11 / 5.0
6SA	03.0106.A01	03.0106.A02	11 / 5.0
8SA	03.0108.A01	03.0108.A02	11 / 5.0
90 VDC Motor MSA - 2SA	03.0201.053	03.0201.053	7.8 / 3.5
90 VDC Motor 3SA and Larger	03.0201.053	03.0201.053	7.8 / 3.5
Motor Control Box	03.0203.009	03.0203.003	2.1 / 0.9
2 amp Fuse	01.0427.008	01.0427.008	0.0 / 0.0
230 - 115 vac Stepdown Transformer	01.0759.008		5.5 / 2.5

Saddle Machine Accessories

SADDLE MACHINE SPACER BOLTS

Spacer Bolts are now available in "Kit" Form.

The Mathey Dearman **Spacer Bolt Kit** includes the spacer bolts listed for the machine range and come in a separate storage box with label to illustrate each size of spacer bolt and the corresponding pipe diameter. All spacer bolts are precision machined to give the Saddle Machine the highest degree of cutting accuracy.

All spacer bolts have the part number and Mathey Dearman logo.

Spacer bolts can be replaced individually or in sets.

Actual size is shown on box lid to help you identify the correct spacer.



Spacer Bolt Kits

Description	Part Number	Includes Spacer for Pipe Sizes		Estimated Shipping Weight	
		in	mm	lbs	kg
MSA	03.0MSA.KIT	2, 3*	51, 76	1.0	0.5
1SA	03.01SA.KIT	3, 4, 6, 8	76, 102, 152, 203	4.0	1.8
2SA	03.02SA.KIT	6, 8, 10, 12	152, 203, 254, 305	5.0	2.3
3SA	03.03SA.KIT	12, 14, 16, 18, 20	305, 356, 406, 457, 508	9.0	4.1
4SA	03.04SA.KIT	20, 22, 24, 26	508, 559, 610, 660	10.0	4.5
5SA	03.05SA.KIT	24, 26, 28, 30	610, 660, 711, 762	10.0	4.5
6SA	03.06SA.KIT	28, 30, 36	711, 762, 914	20.0	9.0
8SA	03.08SA.KIT	40, 42, 48	1016, 1069, 1219	20.0	9.0

*No spacers required for 4" pipe set-up

Self Storing Step Down Spacer

Designed for the single piece Saddle, the **Step Spacer** eliminates lost or misplaced spacer bolts. Step spacers are precision machined to the same tolerances as the spacer bolts. They are made from high quality aluminum alloy and stainless steel is available upon request.

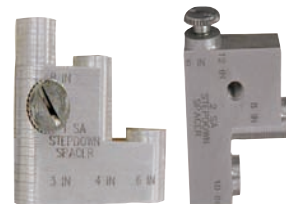
- **NO LOST OR MISPLACED SPACERS**—the step spacers are self-storing.
- **ACCURACY**—The step spacers give the Saddle Machine the same degree of accuracy as the spacer bolts.
- **ADAPTABLE**—The step spacers can be used with new or old Mathey Saddle Machines.
- **NO CHANGING**—No Saddle changes or part replacement required.

Step Spacer

Description	Part Number	Includes Spacer for Pipe Sizes		Estimated Shipping Weight	
		in	mm	lbs	kg
1SA Step Spacers	03.0110.1SA	3, 4, 6, 8 /	76, 102, 152, 203 /	0.4	0.2
2SA Step Spacers	03.0110.2SA	6, 8, 10, 12in	152, 203, 254, 305mm	0.4	0.2

Step Spacer Kit

Machine Model	Part Description	Part No	lbs / kg
1SA	3, 4, 6, 8in / 76, 102, 152, 203mm	03.0110.1SAKIT	1.8 / .8
2SA	6, 8, 10, 12in / 152, 203, 254, 305mm	03.0110.2SAKIT	1.8 / .8



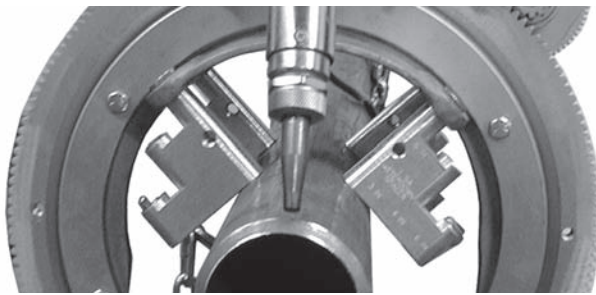
1SA STEP SPACER

2SA STEP SPACER

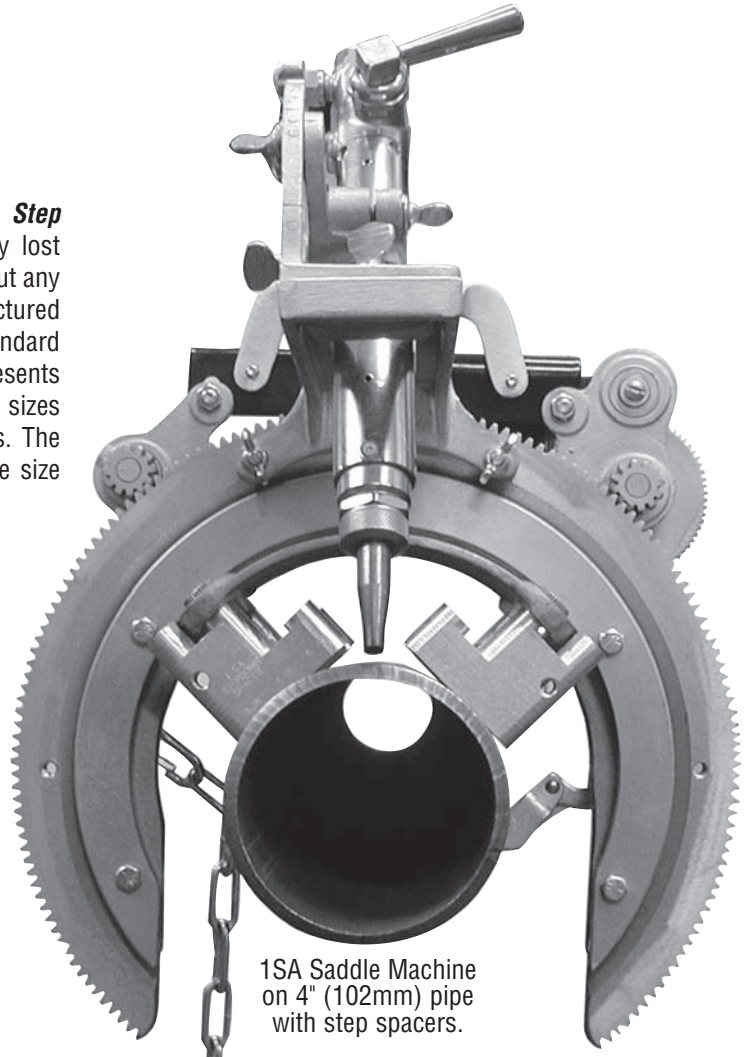
Saddle Machine Accessories

Saddle Machine with Step Down Spacers

Mathey Dearman's **NEW 1SA and 2SA Self-Storing Step Spacers** eliminate the need to purchase or identify lost spacer bolts. The step spacer can be installed easily without any modification to the Saddle Machine. Spacers are manufactured to the same quality and dimensional standards as the standard Mathey Dearman spacer bolt. Each step on the bolt represents a different pipe size and covers a range of four (4) pipe sizes to eliminate the need of storing twelve (12) spacer bolts. The machine size is etched on the spacer to identify the pipe size each step represents.

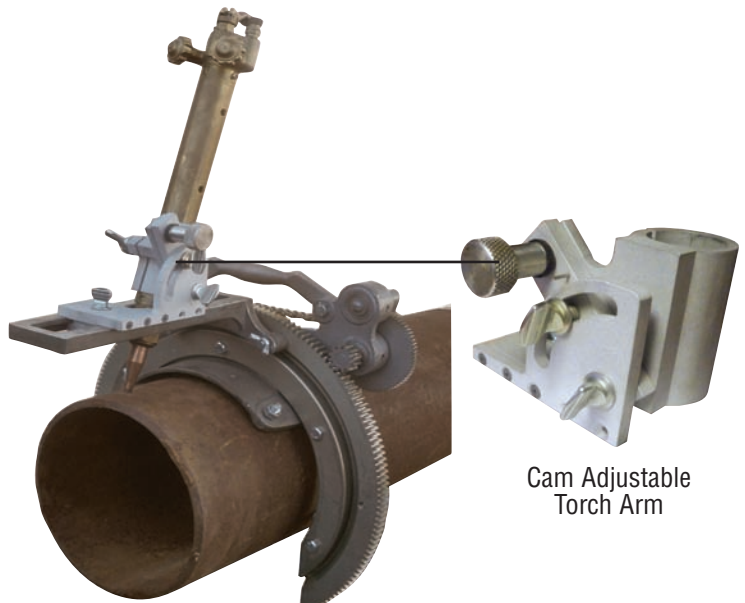


1SA Saddle Machine
on 3" (76mm) pipe



1SA Saddle Machine
on 4" (102mm) pipe
with step spacers.

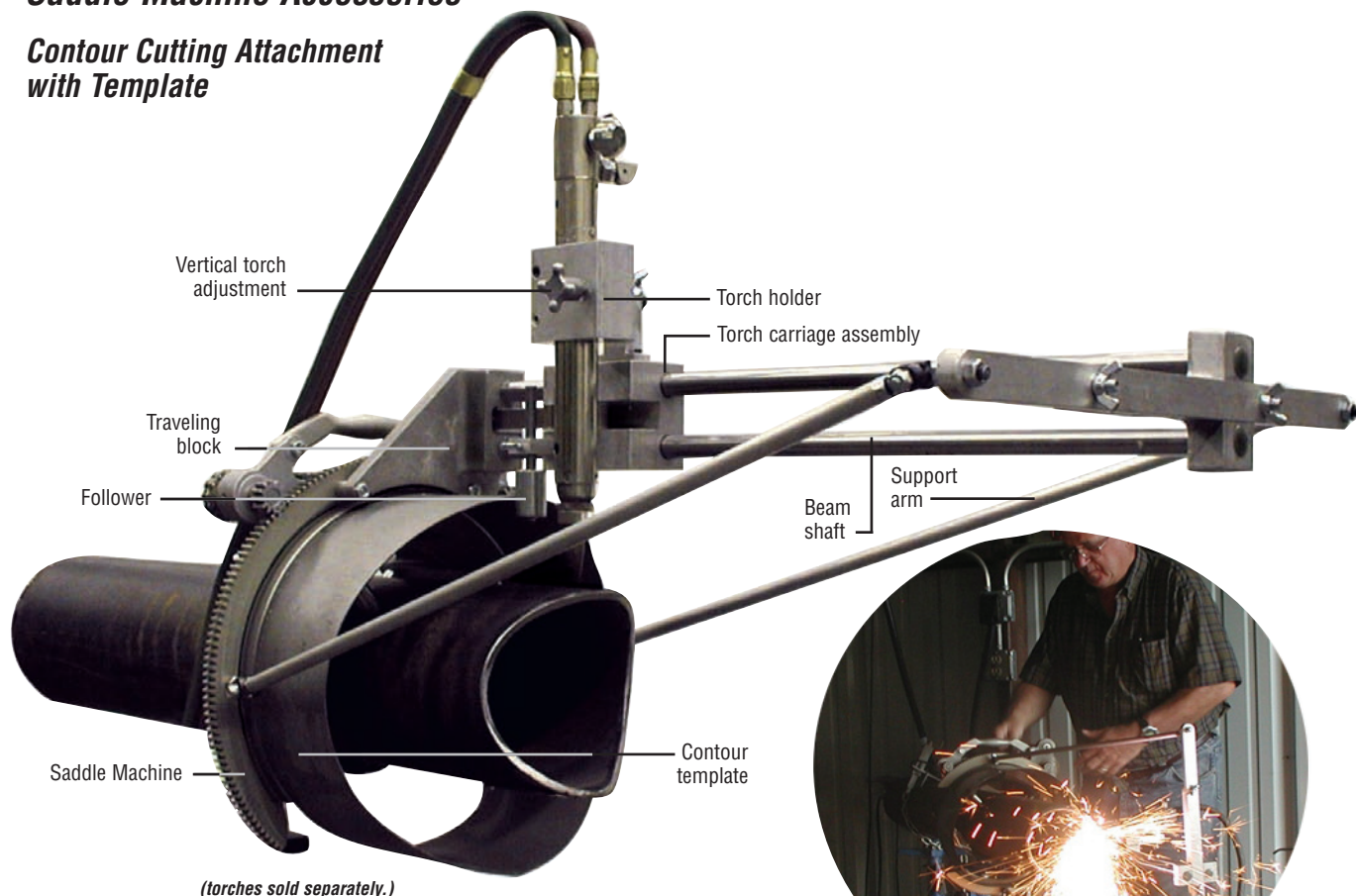
Mathey Dearman's new **Cam Adjustable Torch Holder** permits the torch to be moved away from the cutline and then moved back to the cutline to avoid notching of the pipe end. Another winning feature of the new torch holder is that the oxy/fuel or plasma machine torch can be rapidly moved to the forward or back bevel position without reversing the torch holder in the torch arm. A larger torch clamp wing screw permits the machine torch to be tightened in the torch holder when using welding gloves.



Cam Adjustable
Torch Arm

Saddle Machine Accessories

Contour Cutting Attachment with Template



Saddle and Miter Cutting

The **Contour Cutting Attachment with Template**, in combination with the Saddle Machine, enables the welder, regardless of experience, to produce perfect miter and saddle cuts time after time. Simply change the template to alter the pipe end configurations. The Contour Cutting Attachment provides lateral movement of the torch as it follows the template, while the Saddle Machine rotates the torch around the pipe. Contour Cutting Attachments and templates are available for 1 1/2" – 48" (38mm-1219mm) pipe.

When cutting a 90° saddle on 8" pipe, the combination of the Saddle Machine and Contour Cutting Attachment with template reduces cutting and grinding time by up to 80%.



All Templates are tested to provide proven results.

- Installation of the Contour Cutting Attachment and template to the Saddle Machine TAKES MINUTES.
- REDUCES LABOR required to obtain the desired cut.
- FAST ACCURATE shapes are obtained with oxy/fuel or plasma torches.

NOTE: Templates can be made for a variety of applications such as miters, saddles and diagonals.

Saddle Machine Accessories

Determining Specifications for Shape Templates

Contour Cutting Attachment

Model	Part Number	Pipe Size Range (in / mm)	Estimated Shipping Weight (lbs / kg)
MSA	03.0116.000	1.5 - 4 / 38 - 102	7 / 3
1SA	03.0116.002	3 - 8 / 76 - 203	8 / 4
2SA	03.0116.002	6 - 12 / 152 - 305	8 / 4
3SA	03.0116.003	12 - 20 / 305 - 508	9 / 4
4SA	03.0116.004	20 - 26 / 508 - 660	9 / 4
5SA	03.0116.005	24 - 30 / 610 - 762	11 / 5
6SA	03.0116.006	28 - 36 / 711 - 914	13 / 6
8SA	03.0116.008	40 - 48 / 1016 - 1219	16 / 7

Shape Templates

Model	Part Number	Pipe Size Range (in / mm)	Estimated Shipping Weight (lbs / kg)
MSA	03.0115.M---	1.5 - 4 / 38 - 102	3.5 - 5 / 1.6 - 2.3
1SA	03.0115.1---	3 - 8 / 76 - 203	4.5 - 6 / 2 - 2.7
2SA	03.0115.2---	6 - 12 / 152 - 305	6 - 8 / 2.7 - 3.6
3SA	03.0115.3---	12 - 20 / 305 - 508	11 - 15 / 5 - 7
4SA	03.0115.4---	20 - 26 / 508 - 660	18 - 27 / 8 - 12
5SA	03.0115.5---	24 - 30 / 610 - 762	22 - 31 / 10 - 14
6SA	03.0115.6---	28 - 36 / 711 - 914	27 - 35 / 12 - 16
8SA	03.0115.8---	40 - 48 / 1016 - 1219	31 - 40 / 14 - 1

Saddle and Miter Cutting

- Specify Mathey Dearman Machine Model (Example: 2SA).
- Specify size/schedule (wall thickness) of pipe branch to be cut. (Example: 8" / 203mm pipe-Schedule 80.)
- Specify size of main pipe to which the branch pipe will be fitted. (Example: 8" / 203mm pipe actual OD = 8 5/8" / 219mm.)
- Specify the angle of the cut and whether it is a saddle or miter. (Example: 45 degree miter) (See figure 2.)
- Specify whether the joint is "Saddle In" or "Saddle On" (See figure 1.)
- Specify if pipe is to be offset. If the answer is yes, specify how much the pipe is to be offset.

Please **copy** this sheet as a convenient reference. You can **fax** the completed form to us at 918 447-0188.

Please **include your contact information** so we can get in touch with you.

Figure 1

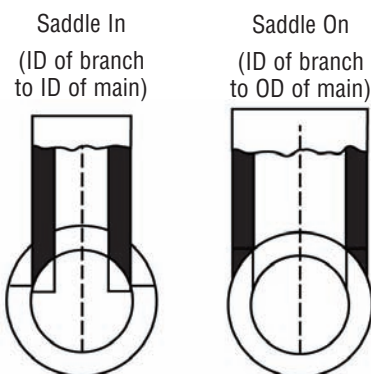
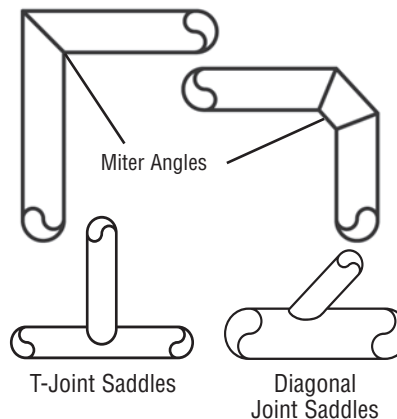


Figure 2



Saddle Machine Accessories

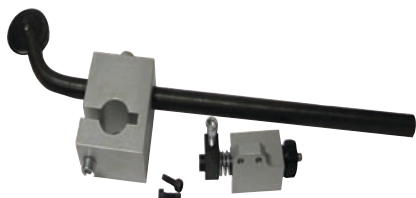
PRO Model Torch Arm

(PATENTED)

The **PRO Model Torch Arm with Out-of-Round Roller Assembly** used in conjunction with a Mathey Saddle Machine compensates for oversize, undersize or out-of-round pipe. The torch arm permits the torch to be precisely adjusted horizontally and vertically by means of racking knobs (torch sold separately).

- NOTCHING OF PIPE IS MINIMIZED due to the torch moving radially on the PRO Model torch arm as it crosses the pipe weld seam or surface imperfections.
- PRECISE PIPE-to-torch distance is maintained to insure a smooth and accurate bevel on the pipe end.
- VERSATILE—The PRO Model torch arm can also be used with a customer supplied torch holder and adaptor for over or undersized pipe.

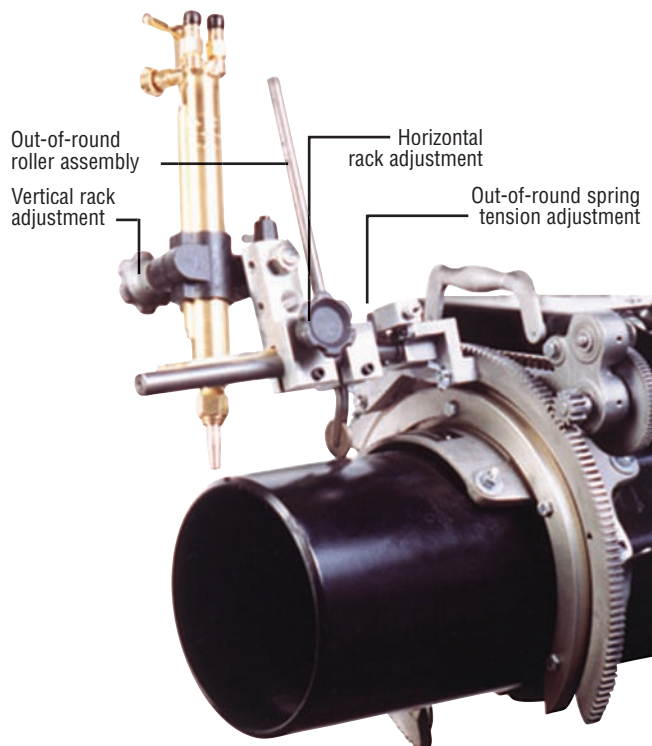
Out-of-Round Kit



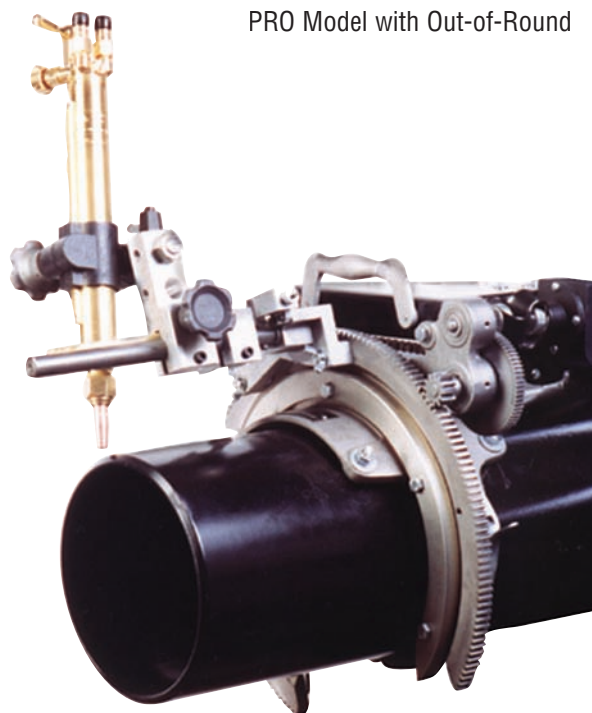
An **Out-of-Round Kit** can be added to the Pro Model base unit for out-of-round pipe and permits the torch to be elevated over the seam weld with little or no notching of the pipe end. (torch sold separately.)

Model	Part Number	Estimated Shipping Weight (lbs / kg)
Pro Model with Out-of-Round	03.0209.000	9.5 / 4.3
Pro Model Base Unit	03.0209.001	7 / 3.2
Out-of-Round Kit	03.0209.003	2.5 / 1.1

NOTE: Back beveling not recommended without the use of the Double torch arm (see page 13)



PRO Model with Out-of-Round



The PRO Model without Out-of-Round feature is being used in conjunction with the Motorized Saddle Machine.

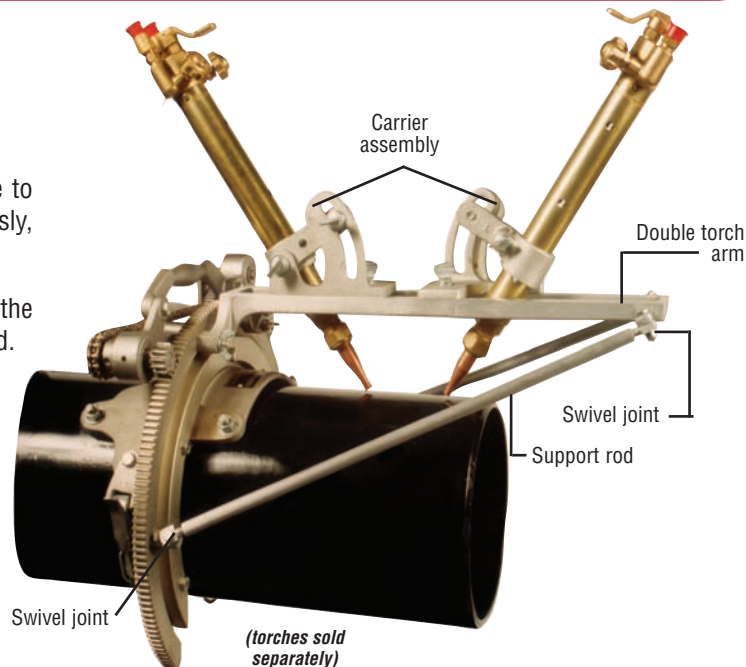
Saddle Machine Accessories

Double Torch Arm

The **Double Torch Arm** enables the Saddle Machine to cut and bevel both sides of the cut line simultaneously, reducing labor cost and time by up to 50%.

The Double Torch Arm eliminates the need to rotate the torch to obtain a forward or back bevel on the pipe end.

- REDUCES LABOR, TIME AND COST by eliminating a second cut.
- ADAPTABLE—Can be used with Oxy/Fuel or Plasma torches.



Double Torch Arm Specifications

Model	With Torch Holder for 1 3/8" (35mm) Diameter Torch	Estimated Shipping Weight (lbs / kg)
1SA	03.0101.030	5 / 2.3
2SA	03.0102.015	5 / 2.3
3SA	03.0103.030	5 / 2.3
4SA	00.0104.021	5 / 2.3
5SA	03.0105.025	5 / 2.3
6SA	03.0106.018	5.5 / 2.5
8SA	03.0108.014	5.5 / 2.5

MSA, 1SA, & 2SA Steel Storage Boxes



Saddle Machine Storage Box

The Saddle Machine, torch, torch arm, torch carrier and spacer bolts can be stored in the **Storage Box** to prevent damage and to reduce the risk of loss. The **MSA, 1SA and 2SA Storage Boxes** are made of 16 gauge steel, light blue powder coated. The Storage Boxes for the **MSA, 1SA, and 2SA** come with lifting handles.

NOTE: The **Storage Boxes for the Saddle Machines larger than the 2SA** are made of 1/4" plywood with reinforced 18 gauge metal corners and edges.

- INCREASES MACHINE LIFE
- REDUCES THE RISK OF ACCIDENTAL DAMAGE to the Saddle Machine
- REDUCES RISK of lost spacer bolts and other items required for operation

Saddle Machine Storage Box

Model	Part Number	Dimensions (in / mm)	For Manual or Motorized	Box Type	Estimated Shipping Weight (lbs / kg)
MSA	03.0100.BOX	17 x 17 x 17 / 432 x 432 x 432	Manual Only	METAL	23 / 11
1SA	03.0101.BOX	20 x 18 x 17 / 205 x 457 x 432	Manual Only	METAL	33 / 15
2SA	03.0102.BOX	25 x 22 x 18 / 635 x 559 x 457	Manual Only	METAL	41 / 19
3SA	03.0103.BOX	34 x 34 x 14 / 864 x 864 x 356	Manual or Motorized	WOOD	60 / 27
4SA	03.0104.BOX	40 x 38 x 14 / 1016 x 965 x 356	Manual or Motorized	WOOD	75 / 34
5SA	03.0105.BOX	42 x 40 x 14 / 1067 x 1016 x 356	Manual or Motorized	WOOD	75 / 34
6SA	03.0106.BOX	56 x 48 x 16 / 1422 x 1219 x 406	Manual Only	WOOD	75 / 34
8SA	03.0108.BOX	70 x 56 x 19 / 1778 x 1422 x 483	Manual Only	WOOD	75 / 34

Chain Cutting and Beveling Machines

Mini Chain Machine

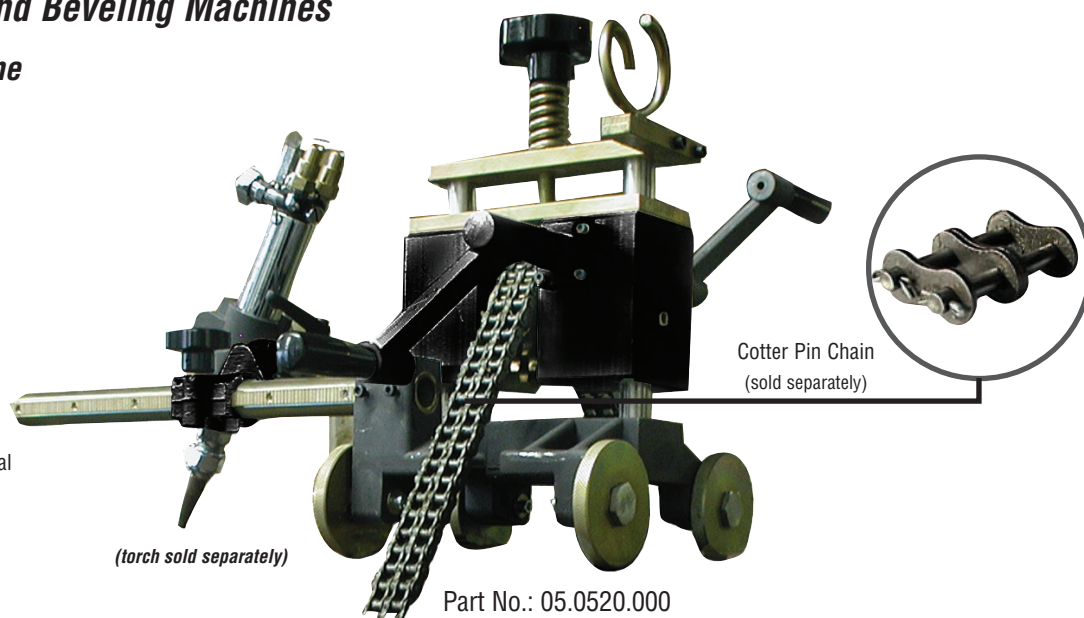
CE Approved

MINI Chain Machine Includes:

- Base machine
- Torch arm
- Service keys
- Sliding support
- Hose support
- Torch holder
- Service keys
- Parts and operating manual

Not Included:

- Machine cutting torch
- Cotter pin chain
- Storage box
- Out-of-round compensating device



Most popular of all chain machines, the lightweight **Mini Chain Machine** is recommended for cutting random lots of small or larger diameters of pipe. Easily adjustable from one pipe size to another, the Mini follows the pipe outside diameter to produce a consistent bevel. The Mini Chain Machine's compact and unique design delivers exceptional performance and consistent results, while reducing down time and maintenance costs. Cuts pipe diameters from 2" (51mm) to unlimited sizes.



Highly precise cut achieved on horizontal pipe when the Mini is used with a guide strip (shown here on 36" / 914mm pipe Schedule 40).

- BEST CHOICE for a small shop or maintenance facility.
- DURABLE and RUGGED enough to withstand the rigor of construction.
- VIRTUALLY ELIMINATES the need for more than one machine regardless of pipe diameters.
- ACCURACY of the Mini Chain Machine is attained through its two wheel positions and double mesh chain or with guide strips.
- Vertical pipe or vessels 18" (457mm) and larger can be accurately cut when used with the guide strips.
- The rack adjustable torch support allows the torch to pierce the pipe away from the cut line, and then move to the cut line, reducing notching of the weld bevel.
- Up to 50% FASTER than hand cutting and grinding.

Mini Chain Machines

Model	Part Number	Estimated Shipping Weight (lbs / kg)
Manual Mini	05.0520.000	34 / 15.4
Motorized Mini Chain Machine, 115 vac	05.0520.M00	67 / 30.4
Motorized Mini Chain Machine, 2 outlets 230 vac	05.0520.ME2	68 / 31
Motorized Mini Chain Machine, 230 vac USA	05.0520.M04	67 / 30.4
Mini Out-Of-Round Compensation Device	05.0520.300	8 / 3.6
230-115 vac Step-Down Transformer	01.0759.008	5.5 / 2.5

Chain Cutting and Beveling Machines

Mini Chain Machine

CE Approved

Options:

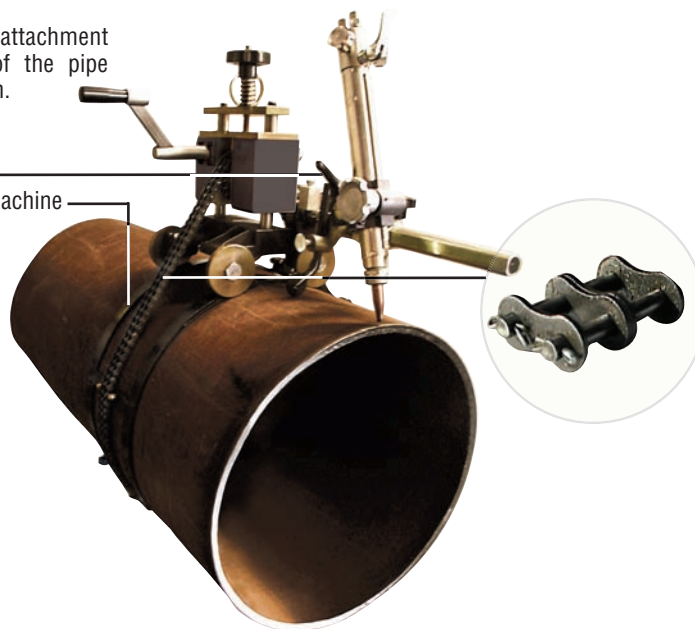
- Variable speed motorizing kit available for 115 or 230 vac at 50/60HZ operation reduces grinding by 90%.
- Available with torch holder for 1 3/8 inch (35mm) diameter machine torch with 32 pitch or metric torch rack.
- Chain Kits available for all standard pipe and tubing sizes. (special sizes available on request)

Accessories:

- 2nd torch holder support and torch holder available for dual torch operation.
- Out-of-round compensating device enables the machine to cut smoothly over pipe imperfections and weld seams.
- Guide strips for fast set up and accurate cutting of large pipe and vessel diameters. Individual sections can be purchased to extend the range of the guide strip.
- 9' (2.7M) or 14' (4.3M) flexible drive cable for remote operation
- Torches and tips available for all types of cutting gases
- Torch shut-off valve to minimize adjustment of gas mixture to the cutting torch
- Machine cutting torch
- Double cottered chain

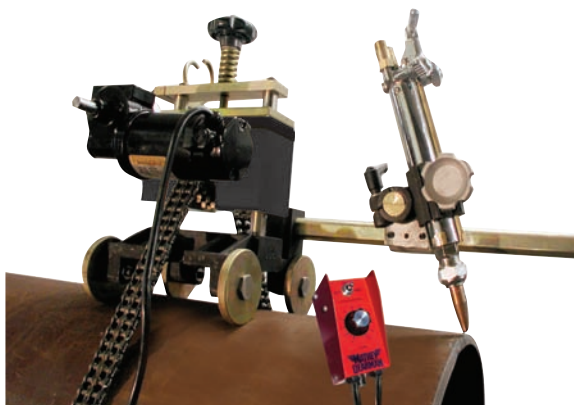
New mini out-of-round attachment minimizes the notching of the pipe when crossing a weld seam.

Mini Chain Machine guide strips



The 230 vac Motorized Mini Chain Machine has multiple outlets for operating powered hand tools.

Part No.: 05.0520.ME2



Accurate precise cuts requiring minimal grinding can be made with the 115 vac or 230 vac Motorized Mini Chain Machine.

Part No.: 05.0520.M00

Part No.: 05.0520.M04

Chain Cutting and Beveling Machines

Maxi Chain Machine

CE Approved

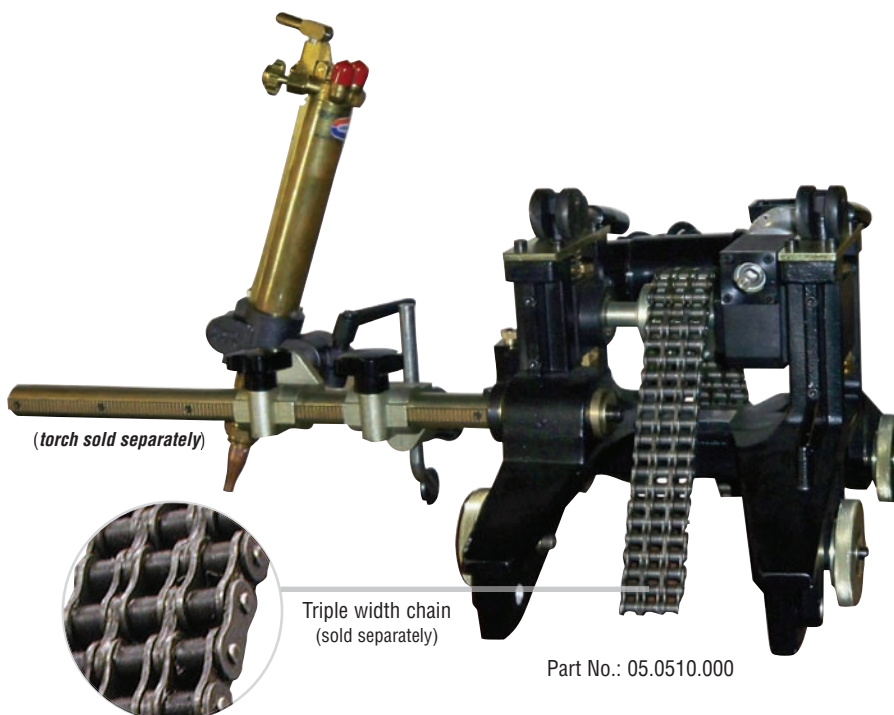
Maxi Chain

Machine Includes:

- Base machine
- Torch arm
- Torch carrier assembly
- Service keys
- Sliding support
- Hose support
- Torch holder
- Parts and operating manual

Not Included:

- Machine cutting torch
- Triple width chain
- Torch head angle adaptor
- Out-of-round compensation device
- Storage box



Cutting seam-welded, spiral-welded or out-of-round pipe is no challenge for the **Maxi Chain Machine** because of its unique out-of-round device that follows the contour of the pipe. The Maxi is recommended for cutting a wide range of large diameter pipe and is a precision machine designed for maximum cutting versatility.

The combination of the Maxi Chain Machine's three (3) wheel positioning and triple-width chain makes it the most accurate chain driven cutting and beveling machine on the market today. The Maxi Chain Machine, which cuts pipe diameters from 4" (102mm) to unlimited diameters is designed to provide many years of service.

Maxi Chain Machines

Model	Part Number	Estimated Shipping Weight (lbs / kg)
Manual Maxi Chain Machine	05.0510.000	63 / 28.4
Motorized Maxi Chain Machine 115 vac	05.0510.M00	67 / 30.4
Motorized Maxi Chain Machine two (2) outlets CE Approved -230 vac	05.0510.ME2	73 / 33
Motorized Maxi Chain Machine three -230 vac USA	05.0510.M04	67 / 30.4
230-115 vac Step-Down Transformer	01.0759.008	5.5 / 2.5

(Drive chain ordered separately)

- **MOST ACCURATE** of the chain machines because of its triple-width chain.
- Out-of-round compensating device can be moved to any point on the torch arm.
- **VERSATILE**—Regardless of whether it's round or out-of-round, this machine can be used to accurately cut seam welded, spiral welded and API Line Pipe.
- The rack adjustable torch support allows the torch to pierce pipe away from the cut line and then to move to the cut line reducing notching.
- **WILL CUT VERTICAL** pipe or vessels 18" (457mm) and larger when used with the guide strips.
- Up to 50% **FASTER** than hand cutting and grinding.

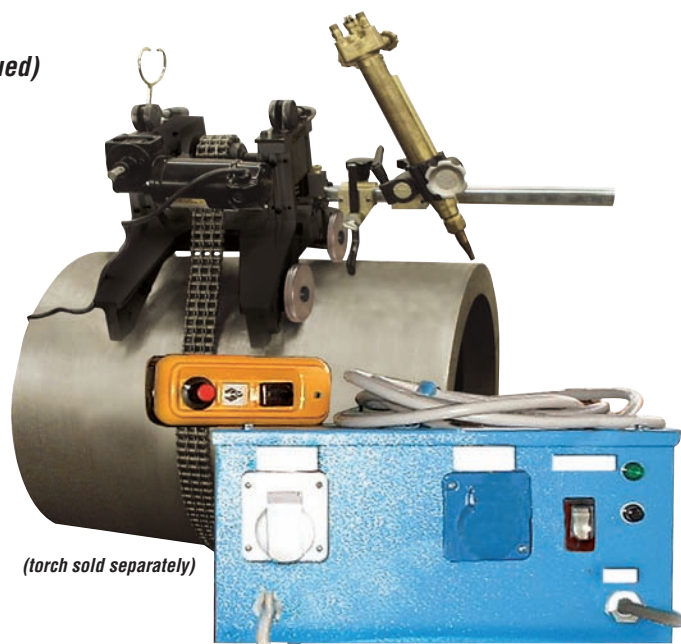
Options:

- Variable Speed Motorizing Kit available for 115 or 230 vac at 50/60Hz operation reduces grinding by 90%.
- Available with rack adjustable torch holder for 1 3/8 inch (35mm) machine torch with 32 pitch or metric torch rack.
- Chain Kits available for all standard pipe and tubing sizes. (special sizes available on request)

Chain Machine

Maxi Chain Machine (Continued)

CE Approved



(torch sold separately)

The 230 vac Motorized Maxi Chain Machine has multiple outlets for operating powered hand tools.

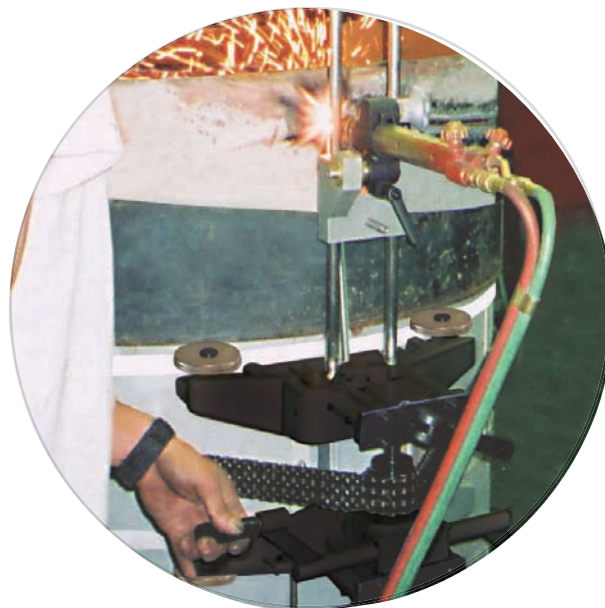
Part No.: 05.0520.ME2



The Maxi Chain Machine with 9' (2.7M) or 14' (4.3M) flexible drive cable is the best option when cutting over water or in a damp environment.

Accessories:

- 2nd torch holder support and torch holder available for dual torch operation.
- Out-Of-Round compensating device enables the machine to cut smoothly over pipe imperfections and weld seams.
- Torches and tips available for all types of cutting gases.



The coping device, when used with the Maxi Chain Machine, allows the operator to cut quality saddle and shallow miter angles consistently and securely with little or no grinding.

- Guide strips should be used for fast set up and accurate cutting of larger pipe diameters. Individual sections can be purchased to extend the range of the guide strip.
- 9' (2.7M) or 14' (4.3M) flexible drive cable for remote operation
- Torch shut-off valve to minimize adjustment of gas mixture to the cutting torch

Chain Machine Accessories

CE Approved

120 vac / 50/60Hz Motorized Kit

USA Motorizing Kits

The **Motor Control Box** of the 115 vac / 50/60Hz Maxi and Mini Chain Machine Motorizing Kit converts the AC current to 90 vdc. The motor control box contains a forward / reverse switch with a neutral center position and a rheostat to control the speed of rotation around the pipe.

The 90 vdc drive motor is attached to the Mini Chain Machine by means of a motor adaptor. A motor coupling, located inside the motor adaptor, transmits the torque of the motor to the worm shaft of the Maxi or Mini Chain Machine. The motor kit can be added to the machine in five (5) minutes or less.

European Motorizing Kits

The 230 vac 50/60Hz **Maxi and Mini Chain Machine European Kit** comes with a 48 vdc right angle drive gear motor, motor adaptor, motor coupling, remote control pendant and power supply control box. The remote control pendant is attached to the power supply box by means of an 11 Ft. (3.5M) electrical cord.

Two (2) Models of the 230 vac Single Phase / 50/60Hz are available:

- 230 vac motor control box 1 - has 230 vac and 48 vdc outlets for power tool or oven operation.
- 230 vac motor control box 2 - has 230 vac, 48 vac and 48 vdc outlets for power tool or oven operation.

*See Page 11: Fill out and submit Saddle and Miter Cutting form contour template when ordering the coping device template.

Maxi and Mini Accessories

Accessory Description	Part Number	Estimated Shipping Weight (lbs / kg)
Maxi/Mini Motorizing Kit 115 vac	05.0510.A01	13 / 6
Maxi/Mini Motorizing Kit - 230 vac/48 vdc with 2 wall sockets	05.0510.A02	18 / 8
Maxi/Mini Motorizing Kit - 230 vac	05.0510.A04	24 / 13.6
Sliding Support for 2nd Torch (Maxi or Mini)	05.0510.114	1 / .5
1 3/8" (35mm) Torch Holder with 32 pitch Pinion	05.0510.117	.7 / .3
1 3/8" (35mm) Torch Holder with metric Pinion	05.0510.117E	.7 / .3
9' (274cm) Flexible Drive Cable (Maxi or Mini)	05.0510.FDC	12 / 5.4
14' (427cm) Flexible Drive Cable (Maxi or Mini)	05.0510.FD14	15 / 6.8
Mini Out-of-Round Device	05.0520.300	7 / .3
Coping Device (Maxi only)	05.0510.126	15 / 6.8
Special Coping Device	05.0510.126SS	15 / 6.8
Coping Device Template*	05.0115.J---	15-35 / 7-16
Maxi Storage Box	05.0510.BOX	38 / 17.2
Mini Storage Box	05.0520.BOX	28 / 12.7
Plasma Adaptor - customer supplied torch	05.0510.301	2 / 1
Plasma Adaptor - elevates Maxi or Mini Torch Holder	05.0510.302	4 / 2
Grinding Tool Kit for US Grinder (does not include grinder)	05.0510.148	2 / 1
15' Extension Cord (USA Model only)	03.0203.020	1.2 / 0.5
Leather Sheath	05.0550.SLV	1.5 / 0.7

NOTE: A step-down transformer is also available for European voltages.



Maxi Chain Machine is rotating a two (2) inch diameter plasma torch around the pipe.

Chain Machine Accessories

(CONTINUED)

Sliding Support and Torch Holder

The addition of a second sliding support and torch holder gives the chain machine the ability to bevel both sides of the cut line simultaneously.

Part No.: 05.0510.114
05.0510.117

Cable Drive

The Cable Drive attachment enables the Maxi and Mini Chain Machine to be operated remotely when cutting large diameter pipe. Cable available in lengths of 9' (2.7m) and 14' (4.3m).

Part No.: 05.0510.FDC

Heavy Duty Storage Boxes

The durable Storage Box is made of steel with a powder coated paint finish.

Part No.: 05.0510.BOX



Grinding Attachment

The Grinding Attachment, for Maxi or Mini with guide strip, is an excellent accessory for refacing bevels or lands on pipe ends.

Part No.: 05.0510.148



Optional Torch Holder for Plasma Torch

Elevates the Mini and Maxi torch holder to position the plasma torch in the right position for excellent clean cuts.

Part No.: 05.0510.301



Adaptor for Plasma Torch Holders

Adapts customer-supplied torch holder to the Mini or Maxi Chain Machine.

Part No.: 05.0510.302



Chain Machine Accessories

Cotter Pin Roller Chain

The **Cotter Pin Roller Chain** (sold separately) makes the Mini Chain Machine quick and easy to change from one pipe size to another. Simply remove the cotter pins from the end of the chain link and remove or add a section of chain. The chain can be joined with a cotted chain link or a standard connecting link if additional chain links are needed.



Triple Link Chain

The Maxi Chain Machine utilizes triple link chain for improved tracking. The combination of the triple chain and the machine gives the machine versatility and cutting accuracy. A connecting link or screw and nut are used to join the chain ends.

Mini Chain Kits

Description	Wheel Position	Part Number	Estimated Weight (lbs / kg)
Chain Kit for 2" Pipe	1	01.0520.002	2 / 1
Chain Kit for 3" Pipe	1	01.0520.003	2 / 1
Chain Kit for 4" Pipe	2	01.0520.004	2 / 1
Chain Kit for 6" Pipe	2	01.0520.006	3 / 1.4
Chain Kit for 8" Pipe	2	01.0520.008	4 / 1.8
Chain Kit for 10" Pipe	2	01.0520.010	4 / 1.8
Chain Kit for 12" Pipe	2	01.0520.012	5 / 2
Chain Kit for 16" Pipe	2	01.0520.016	6 / 2.7
Chain Kit for 18" Pipe	2	01.0520.018	6 / 2.7
Chain Kit for 20" Pipe	2	01.0520.020	7 / 3
Chain Kit for 24" Pipe	2	01.0520.024	8 / 3.6
Chain Kit for 28" Pipe	2	01.0520.028	9 / 4
Chain Kit for 30" Pipe	2	01.0520.030	9 / 4
Chain Kit for 32" Pipe	2	01.0520.032	10 / 4.5
Chain Kit for 36" Pipe	2	01.0520.036	11 / 5
Chain Kit for 40" Pipe	2	01.0520.040	12 / 5.4
Chain Kit for 42" Pipe	2	01.0520.042	13 / 5.9
Chain Kit for 48" Pipe	2	01.0520.048	14 / 6.4
Chain Kit for 50" Pipe	2	01.0520.050	15 / 6.8
Chain Kit for 52" Pipe	2	01.0520.052	15 / 6.8
Chain Kit for 56" Pipe	2	01.0520.056	17 / 7.7
Chain Kit for 60" Pipe	2	01.0520.060	18 / 8.2

Maxi Chain Kits

Description	Wheel Position	Part Number	Estimated Weight (lbs / kg)
Chain Block with Pin Driver	--	05.0510.009	3 / 1.4
Chain Kit for 4" Pipe	1	01.0510.004	3 / 1.4
Chain Kit for 6" Pipe	2	01.0510.006	4 / 2
Chain Kit for 8" Pipe	2	01.0510.008	5 / 2.3
Chain Kit for 10" Pipe	2	01.0510.010	5 / 2.3
Chain Kit for 12" Pipe	2	01.0510.012	6 / 2.7
Chain Kit for 16" Pipe	2	01.0510.016	7 / 7
Chain Kit for 18" Pipe	2	01.0510.018	8 / 3.6
Chain Kit for 20" Pipe	2	01.0510.020	8 / 3.6
Chain Kit for 24" Pipe	2	01.0510.024	10 / 4.5
Chain Kit for 28" Pipe	2	01.0510.028	11 / 5
Chain Kit for 30" Pipe	3	01.0510.030	12 / 5.4
Chain Kit for 32" Pipe	3	01.0510.032	13 / 5.9
Chain Kit for 38" Pipe	3	01.0510.038	15 / 6.8
Chain Kit for 40" Pipe	3	01.0510.040	15 / 6.8
Chain Kit for 42" Pipe	3	01.0510.042	16 / 7.3
Chain Kit for 48" Pipe	3	01.0510.048	18 / 8.2
Chain Kit for 50" Pipe	3	01.0510.050	19 / 8.6
Chain Kit for 52" Pipe	3	01.0510.052	19 / 8.6
Chain Kit for 56" Pipe	3	01.0510.056	21 / 9.8
Chain Kit for 60" Pipe	3	01.0510.060	22 / 10

Visit our website at www.mathey.com, under [Product Formulas](#), for automatic calculations of the chain length required.

Chain Machine Accessories

Guide Strips - Extra Precision on Larger Pipe

The **Maxi and Mini Chain Machine Guide Strips** insure an accurate cut and fit-up as well as reduction of set-up time by 20%. The guide strip is designed for use on horizontal and vertical pipes 18" (457mm) and larger. The guide strip is required when using the contour cutting attachment.

Add or remove guide strip sections as needed when changing pipe diameters.

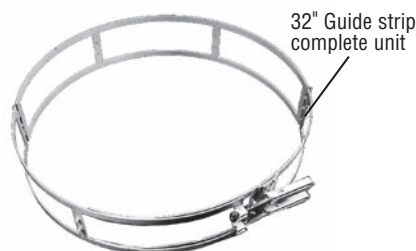
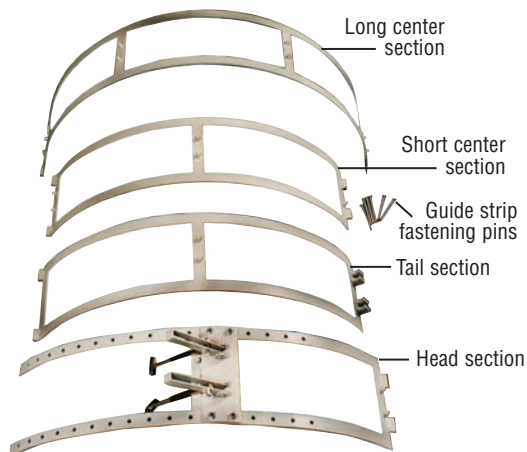
Chain Machine Guide Strips are sold in four (4) main sections:

1. Head section
2. Long center section
3. Short center section
4. Tail section

Each section includes: two (2) pins and two (2) washers.



Guide strip insures a precise square cut on 18" (457mm) and larger pipes.



Guide Strip Chart

Model	Head Section	Tail Section	Short Center Section	Long Center Section
Mini	05.0520.013B	05.0520.013D	05.0520.013C	05.0520.013A
Maxi	05.0510.013B	05.0510.013D	05.0510.013C	05.0510.013A
Weight (lbs / kg)	4.7 / 2	3.6 / 1.6	3.2 / 1.5	4.3 / 2
Pipe Range (in / mm)	Guide Strip Section Required			
18 - 22 / 458-559	1	1		
18 - 32 / 610 - 813	1	1	1	
18 - 36 / 864 - 914	1	1	1	1
18 - 48 / 1118 - 1219	1	1	2	2
18 - 52 / 1270 - 1321	1	1	2	2
18 - 58 / 1372 - 1473	1	1	2	2
18 - 64 / 1524 - 1625	1	1	3	2
18 - 72 / 1674 - 1829	1	1	3	2

For pipe sizes above 72" (1828mm) contact Mathey Dearman's sales department for the number of sections required.

Monarch Band Pipe Cutting and Beveling Machine

CE Approved

The **Monarch Band, with the Band Crawler**, is ideal for use when there is a minimum amount of clearance around the pipe. The stainless steel band can be positioned in tight areas of pipe runs that need repair as it requires only 6" (153mm) clearance. The light flexible band will allow the Band Crawler to give a consistent bevel on severely out-of-round pipe, as the band conforms to the pipe shape.

Bands from 6" to 12" (152mm to 305mm) are made from 14 gauge stainless steel. Bands 14" (356mm) and larger are made from 12 gauge stainless steel.

The lightweight Band Crawler enables one man operation on diameters as large as 60" (1524mm). Bands for pipe sizes 6" to 60" (152 to 1524mm) and larger are available upon request.

Band Machines

Model	Part Number	Estimated Shipping Weight (lbs / kg)
Band Machine with 9' (2.7M) Flex Drive Cable	05.0116.009	26 / 12
Band Machine with 14' (4.3M) Flex Drive Cable	05.0116.014	30 / 14
115 vac Motorized Band Machine, standard speed	05.0116.M00	27 / 12.35
230 vac Motorized Band Machine, standard speed	05.0116.M04	27 / 12.35
115 vac Motorized Band Machines, plasma speed	05.0116.M07	27 / 12.35
230 vac Motorized Band Machine, plasma speed	05.0116.M08	27 / 12.35



Band Crawler Machine includes:

- Base crawler machine
- Eccentric torch carrier
- 9' (2.7m) or 14' (4.3m) drive cable
- Parts and operating manual

Not Included:

- Machine cutting torch
- Torch angle head adaptor



The band with Band Crawler is being used to cut a back bevel on the inside of this 116" (2.9m) diameter pipe.



The stainless steel band forms to the 116" (2.9M) diameter pipe keeping the torch in the crawler at a preset distance off the pipe.

Monarch Band Pipe Cutting and Beveling Machine Accessories

Motorized Monarch Band Machine

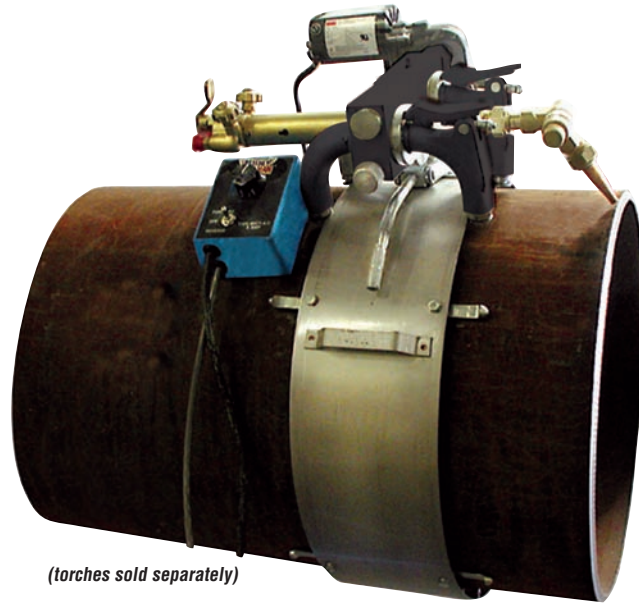
- **ONE MAN OPERATION**—one man can set-up and cut pipes as large as 48" (1219mm).
- **BAND CONFORMS** to the out-of-round condition of the pipe to keep the torch at a preset distance from the pipe wall.
- **EASE OF SET-UP** is realized when cutting horizontal or vertical pipes due to lightweight Band design.
- **LOW PROFILE** of the Crawler only requires 6" (152mm) of radial clearance around the pipe when used with a right angle drive adapter.
- **QUICK INSTALLATION and CLOSURE** with the latching mechanism of the band on the pipe.
- **POSITIVE ALIGNMENT** of the band ends by aligning the fingers on each end of band tightly together.
- One Band Crawler **FITS ALL BAND SIZES**.
- **60% FASTER** than hand cutting and grinding.

Options:

- Band Crawler is available with 9' (2.7M) or 14' (4.3M) flexible drive cable for manual operation.
- 115 vac and 230 vac variable speed Motorizing Kits are available to reduce the amount of grinding time required.
- Bands for odd sizes of pipe and vessels are available on request.

Accessories:

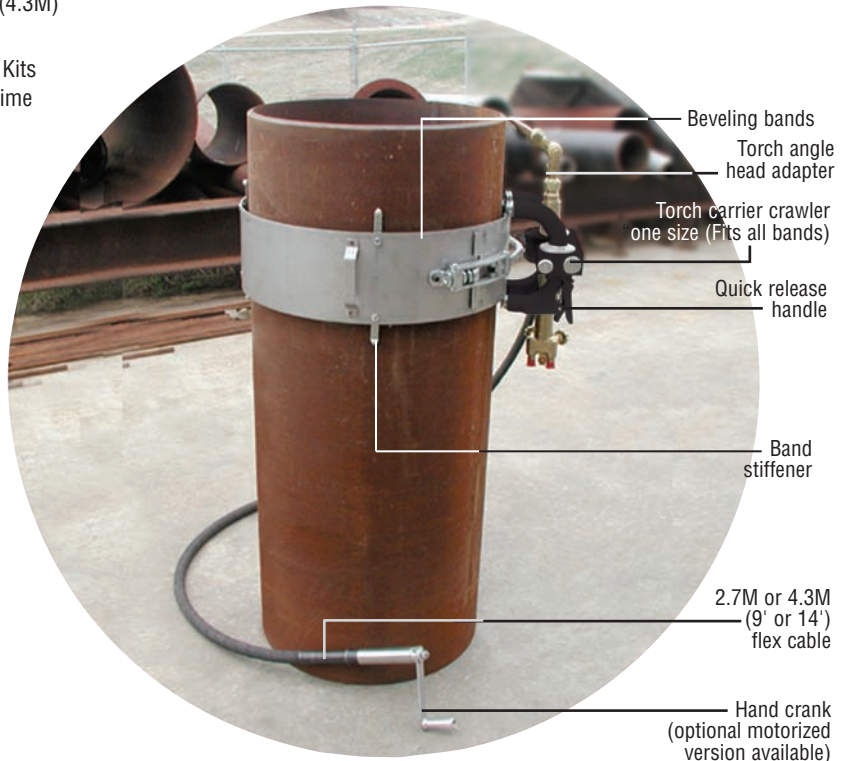
- Rack adjustable torch arm permits horizontal movement of the torch parallel to the pipe axis.
- Double torch arm allows cuts or bevels to be made simultaneously.
- Torches and tips available for all types of cutting gases.
- Torch shut-off valve to minimize adjustment of gas mixture to the cutting torch.



(torches sold separately)

Motorized Crawler mounted on 18" (457mm), Schedule 40 pipe.

When cutting large diameter pipes, operator efficiency can be improved by 60% with the Motorized Band Machine.



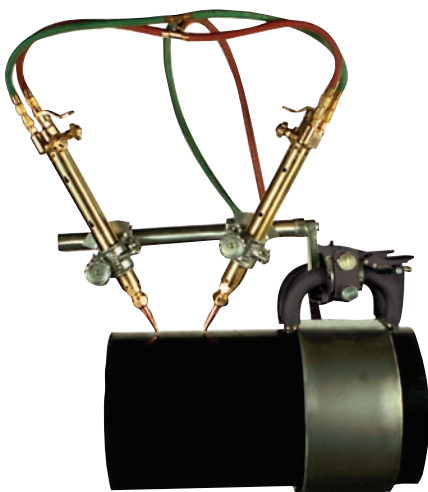
The Band and Crawler is the quickest and easiest tool to set up on vertical pipe. (Shows cutting of 24" vertical pipe with oxy/acetylene.)

Monarch Band Pipe Cutting and Beveling Machine Accessories (Continued)

Double Torch Arm

Beveling both sides of the cut simultaneously reduces manufacturing time and labor cost to accomplish cutting out pipe section.

Part No. 05.0117.039



Right Angle Drive Adaptor

The **Right Angle Drive Adaptor** permits the flexible drive cable to pivot 180 degrees on the end of the Monarch Band Crawler body. The adaptor lowers the profile of the Crawler to 6" (153mm).

Part No. 05.0117-030



Rack Adjustable Torch Arm

The **Rack Adjustable Torch Arm** permits vertical and horizontal adjustment of the torch in relationship to pipe surface.

Part No. 05.0116.032



Flexible Drive Cable

A 9' (2.7M) and 14' (4.3M) **Flexible Drive Cable** enables the Band Crawler to be operated remotely when cutting large diameter pipe.

Part No. 05.0116.022

Part No. 05.0116.031



Torch Angle Head Adaptor

The **Torch Angle Head Adaptor Attachment** allows the torch tips to be adjusted for any angle from a square cut (no bevel), to a bevel angle up to 90 degrees. It also permits adjustments for a lead or lag angle of the torch.

Part No.: 05-0200-003



Monarch Band Pipe Cutting and Beveling Machine Accessories (Continued)

Monarch Bands

Item/ Assembly Description	Part Number	Estimated Shipping Weights (lbs / kg)
6" (152mm) Band	05.0104.006	5 / 2
8" (203mm) Band	05.0104.008	6 / 3
10" (254mm) Band	05.0104.010	7 / 3
12" (304mm) Band	05.0104.012	7 / 3
14" (356mm) Band	05.0104.014	11 / 5
16" (406mm) Band	05.0104.016	12 / 5
18" (457mm) Band	05.0104.018	14 / 6
20" (508mm) Band	05.0104.020	16 / 7
22" (559mm) Band	05.0104.022	17 / 8
24" (610mm) Band	05.0104.024	18 / 6
26" (660mm) Band	05.0104.026	20 / 9
28" (711mm) Band	05.0104.028	22 / 10
30" (762mm) Band	05.0104.030	25 / 11
32" (813mm) Band	05.0104.032	26 / 12
34" (864mm) Band	05.0104.034	27 / 12
36" (914mm) Band	05.0104.036	29 / 13
38" (965mm) Band	05.0104.038	31 / 14
40" (1016mm) Band	05.0104.040	33 / 15
42" (1067mm) Band	05.0104.042	36 / 16
44" (1118mm) Band	05.0104.044	39 / 18
46" (1168mm) Band	05.0104.046	43 / 20
48" (1219mm) Band	05.0104.048	90 / 41
50" (1270mm) Band	05.0104.050	92 / 42
52" (1321mm) Band	05.0104.052	96 / 44
54" (1372mm) Band	05.0104.054	100 / 45
56" (1422mm) Band	05.0104.056	106 / 48
58" (1473mm) Band	05.0104.058	110 / 50
60" (1524mm) Band	05.0104.060	115 / 52

Monarch Band Machine Accessories

Item/ Assembly Description	Part Number	Estimated Shipping Weight (lbs / kg)
Electric Motorizing Retrofit Kit, 115 vac	05.0116.A07	9 / 4
Electric Motor Kit 230 vac	05.0116.A08	9 / 4
Rack Adjustable Torch Arm	05.0116.032	3 / 1.4
Double Torch Arm	05.0117.039	4 / 1.8
Right Angle Drive Adaptor (for Flexible Drive Cable)	05.0116.030	2 / .9
Torch Angle Head Adaptor	05.0200.003	1.2 / .5
Leather Sheath	05.0550.SLV	1.5 / .7

Monarch Band and Band Parts

Item/Assembly Description	Part Number	Estimated Shipping Weight (lbs / kg)
Standard Latch		
Band Latch Assembly, 6" to 12" / 153 to 305mm	05.0103.100	1.5 / .68
Band Latch Assembly, 14" and up / 356mm and up	05.0103.102	1.7 / .77
Crawler Parts		
Grease Zerk	01.0469.003	.1 / .05
Worm Gear Shaft Assembly	05.0116.002	.3 / .14
Worm Gear Shaft Bearing	05.0116.003	.1 / .05
Drive Wheel Assembly (4 Req.)	05.0116.083	.15 / .07
Crank Handle Assembly	05.0116.026	.3 / .14
Torch Handle Eccentric	05.0116.008	.4 / .18
Set Screw	05.0116.011	.25 / .11
Connector	05.0116.012	.15 / .07
End Plug	05.0116.021	.15 / .07
Flexible Drive Cable, 9' / 2.7m	05.0116.022	12 / 5.4
Flexible Drive Cable, 14' / 4.3m	05.0116.031	15 / 6.8

NOTE: Bands from 6" to 12" (152mm to 305mm) are made from 14 gauge stainless steel. Bands 14" (356mm) and larger are made from 12 gauge stainless steel.

MagnaCut XM Pipe and Plate Cutter & Welder

(PATENTED)

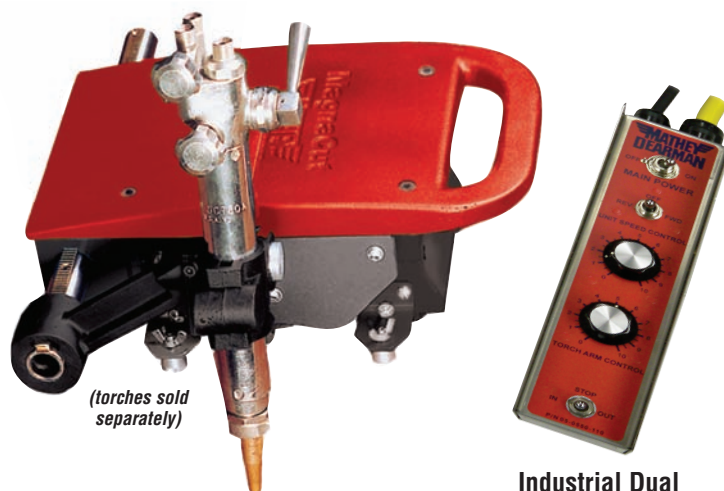
Mathey Dearman's revolutionary **MagnaCut XM** enables the welder and pipefitter to cut, bevel, and even weld steel pipe and steel plate without having to secure the machine to the work surface by means of chains, clamps, or any other device. The secret is in the MagnaCut's magnetic wheels that secure the machine to the surface with 300lbs of pull. Inside the wheels are rare-earth magnets, the strongest permanent magnets made.

The MagnaCut XM is an excellent choice when cutting a variety of sizes and thicknesses of pipe and plate. It will cut materials with wall thicknesses up to 3" (76mm) using either

a plasma or an oxy/acetylene cutting torch. When cutting steel plate, the use of a 1 3/8" angle as a guide strip ensures perfectly straight tracking.

In addition, the remotely-operated motor control box allows the machine to cut in hard-to-reach locations such as overhead pipes and vertical walls.

Even on pipe or plate with coating material up to .015 (.4mm) thick, the MagnaCut XM tracks straight, and the torch-to-work surface distance is held constant.



(torches sold separately)

MagnaCut XM
Part No.: 05.0550.000XM

**Industrial Dual
Motor Control Box**
Part No.: 05.0550.110

MagnaCut XM Kit includes:

- Base machine
- Motor control box
- Electric torch arm
- Torch holder
- Torch support
- Hose support
- 74" (1880mm) long safety strap for up to 24" (610mm) pipe
- Two (2) snap hooks
- Service keys
- Storage box
- 115 vac motor control box
- Protective leather sheath
- Parts and operating manual
- MINIMUM SET-UP TIME—just set the distance between the torch tip and the work surface
- VERSATILE—cuts pipe, plate, walls and overheads
- SAFE—Speed and direction of both machine and torch arm speed are remotely controlled
- AMAZING HOLDING POWER—strong rare-earth magnets hold fast to any magnetic receptive surface with coating up to .015" (.4mm) thick.
- FAST—Up to 80% faster than cutting by hand.

Not Included:

- Machine cutting torch

MagnaCut XM

(PATENTED)



MagnaCut XM can be used on coated pipes having thickness up to 0.015" (0.4mm).



MagnaCut XM can be used on wall thickness up to 3" (76mm).

WARNING: The following may void warranty

The MagnaCut XM should not be used on heavy wall pipe or plate thicker than 3" (76mm).

The MagnaCut XM is not designed for use with 1 3/4" (44mm) or 2 1/2" (64mm) barrel Plasma torches.

ALWAYS SECURE the machine to the pipe with a safety strap.

Mathey Dearman should be contacted prior to attempting any application not listed in the catalog.

MagnaCut XM is not designed for cutting spiral welded pipe.

MagnaCut XM and Accessories

Model	Part Number	Estimated Shipping Weight (lbs / kg)
MagnaCut XM, 115 vac 50/60Hz	05.0550.000XM	60 / 27
230-115 vac Step-Down Transformer	01.0759.008	5.5 / 2.5

MagnaCut XM Technical Specifications

Description	MagnaCut XM
Method of Attachment to Pipe or Plate	Rare Earth Magnets
Magnetic Pull per Wheel Assembly	150lbs / 68kg
Polyurethane, Carbon Zinc or Epoxy Coatings	Up to 15mils or .015" / .4mm thick.
Set Up Time	2 Minutes or less
Cutting Range (Pipe O.D.)	6 5/8" / 168mm and up
Cutting Range (Pipe I.D.)	24" / 610mm and up
Vertical Cutting Capability	Pipe or Plate
Horizontal Cutting Capability	Pipe or Plate
Diagonal Cutting Capability	Plate only
Miter or Saddle Cutting Capability on Pipe	Shallow Miters or Saddles only
Minimum Speed	2" / 51mm per Minute
Maximum Speed	40" / 1016mm per Minute
Net Weight	37 lbs / 16.7 kg
Estimate Shipping Weight	60lbs / 27 kg
Shipping Dimensions	20" x 9" x 25" / 508 x 229 x 635
Machine Dimensions	
Width (Torch Arm Extended)	17" / 432mm
Length	14" / 356mm
Height	5 1/4" / 133mm
Electrical Requirement	115 vac or 230 vac 50/60Hz (With Transformer)

* A Guide Strip made of 1 3/8" Angle Iron is available for MagnaCut XM to cut pipe 18" and larger.

MagnaCut XM

(PATENTED.)

MagnaCut XM Spare Parts and Accessories

Description	Part Number	Estimated Shipping Weight (lbs / kg)
1 3/8" / 35mm Torch Holder with 32 Pitch Pinion	05.0510.117	0.7 / 0.3
1 3/8" / 35mm Torch Holder with Metric Pinion	05.0510.117E	0.7 / 0.3
115 vac Motor Control Box	05.0550.110	7.7 / 3.5
Fuse, 3 amp Time Delay	05.0550.038	0.0 / 0.0
230-115 vac Step-Down Transformer	01.0759.008	5.5 / 2.5
12' / 3.7mt Extension Cord	05.0550.014	0.9 / 0.4
24 vdc Torch Arm Motor	05.0550.055	0.8 / 0.4
100 vdc Drive Motor	05.0550.016	0.9 / 0.4
Snap Hook (2 required)	05.0550.035	0.1 / 0.0
Safety Cable, 24" / 610mm Diameter	05.0550.052	1.8 / 0.8
Plasma Adapter, Customer Supplied Torch	05.0510.301	2.0 / 0.9
Plasma Adapter, Elevates MagnaCut Torch Holder	05.0510.302	4.0 / 1.8
Leather Sheath	05.0550SLV	1.5 / 0.7

MagnaCut XM Guide Strips

Pipe Diameter In/mm	Part Number	Estimated Shipping Weight (lbs / kg)
18 / 457	05.0550.218	6 / 3
20 / 508	05.0550.220	7 / 3
24 / 610	05.0550.224	8 / 4
28 / 711	05.0550.228	8.5 / 4
30 / 762	05.0550.230	9 / 4
32 / 813	05.0550.232	10 / 5
36 / 914	05.0550.236	11 / 5
42 / 1076	05.0550.242	13 / 6
48 / 1219	05.0550.248	15 / 7

The **MagnaCut XM Motor Control Box** permits precise speed control of the MagnaCut XM in the forward and reverse direction. The operator can accurately control the speed of the torch arm as it moves in and out perpendicular to the line of travel of the machine. The torch arm toggle switch is spring loaded to the center or off position to control precise placement of the cutting or welding torch.

A 230-115 vac Step-Down Transformer (P.N. 01.0759.008) is available for 230 vac 50/60Hz operation.

Optional Torch Holder:



Designed to elevate the MagnaCut XM torch holder to accommodate plasma machine torch or machine welding torch. (torch and torch rack sold separately)

Part No.: 05.0510.301

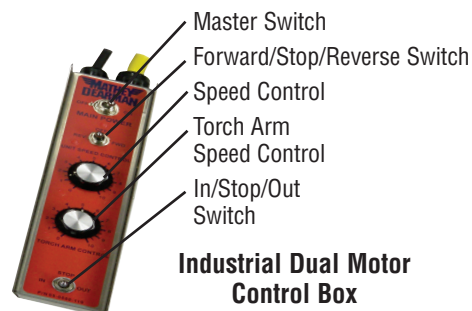
Optional torch bracket:



Designed to adapt to plasma machine's torch holder.

(Torch and torch rack sold separately)

Part No.: 05.0510.302



Part #: 05-0550-110

MagnaCut XM

(PATENTED)

APPLICATIONS:



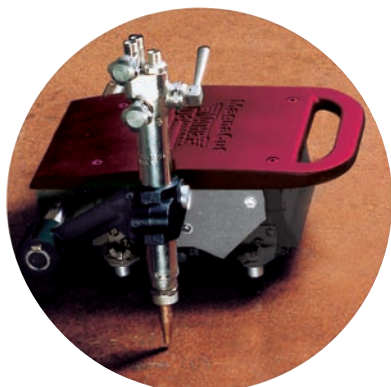
The MagnaCut XM cuts outside diameters 6 5/8" (167mm) and larger.



The MagnaCut XM cuts pipe with inside diameter of 24" and larger.



Vertical or horizontal I-Beam 20" wide or wider can be precision cut with MagnaCut XM.



Vertical or horizontal Plate 12" (305mm) wide or wider can be precision cut with MagnaCut XM.



Pipe diameter 16" (406mm) and larger can be cut parallel to the pipe axis.



Mathey Dearman produces guide strips upon request for 18" (457mm) and larger pipes.

Guide Strip

MagnaCut XM has been one of Mathey Dearman's most popular machines because of the potential cost savings for pipe diameters up to 18" (457mm).

Guide strips may be used to cut pipe or plate if the user needs extreme accuracy. A piece of 1" x 1" x 1/8" (25 x 25 x 3mm) thick angle iron can be used as a guide strip when cutting horizontal or vertical plate. Guide strips for pipe can be made by rolling angle iron to fit a specific diameter of pipe and by cutting it into two (2) sections and bolting it together to make a guide strip.

WARNING: A safety strap should be used in conjunction with the guide strip in case the MagnaCut XM releases from the pipe.



Vertical pipes 18" (457mm) and larger can be precision cut when MagnaCut XM is used with the guide strip.

MagnaCut XM (Continued)

Many fabricators are using the **MagnaCut XM** in conjunction with a Bernard Machine Welding Torch or Tweeco Tam Welding Torch. These welding torches fit directly into the 1 3/8" (35mm) torch holder supplied with the machine.

APPLICATIONS VARY WIDELY:

One application required a stringer weld with .060" flux core wire. Another application required a stringer weld with .035" (1.9mm) ER70S-6 welding wire.

The welding speeds vary from 8" (203mm) per minute to 40" (1016mm) per minute depending on the welding source, gas mixture, wire composition and weld deposition rate.



MagnaCut XM

Part No.: 05.0550.000XM



Plate to plate stringer welds and plate to angle or channel are no problem for the MagnaCut XM.



The machine is equipped with guides that can be used to track on 1" X 1" X 1/8" (25mm x 25mm x 3mm) angle iron for vertical (up or down) welding accuracy.

Mini-MAG XM

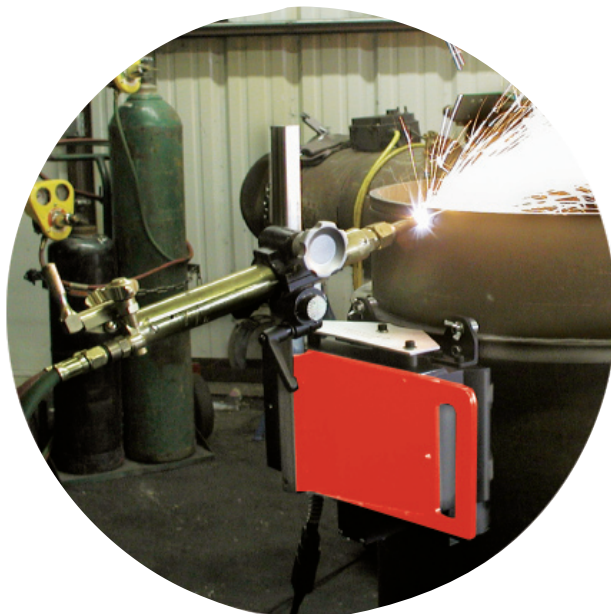
Mini-MAG XM is capable of cutting 6" (153mm) pipes and larger from the outside, and 24" (610mm) pipes and larger from the inside. The machine will cut 16" (406mm) pipes and larger parallel to the pipe centerline.

Mini-MAG XM's rare earth magnets hold the machine to the material with an astounding 300lbs (136kg) of magnetic force. The Mini-MAG XM is designed for cutting thicker pipe coatings and heavier wall thicknesses and may be used for welding applications.

Mini-MAG XM is designed for pipes having a wall thickness from .250 to 3" (6.4mm to 76mm) with coatings up to 0.015" (.4mm) thick.

WARNING:

The **Mini-MAG XM** should not be used on heavy wall pipe or plate thicker than 3" (76mm).

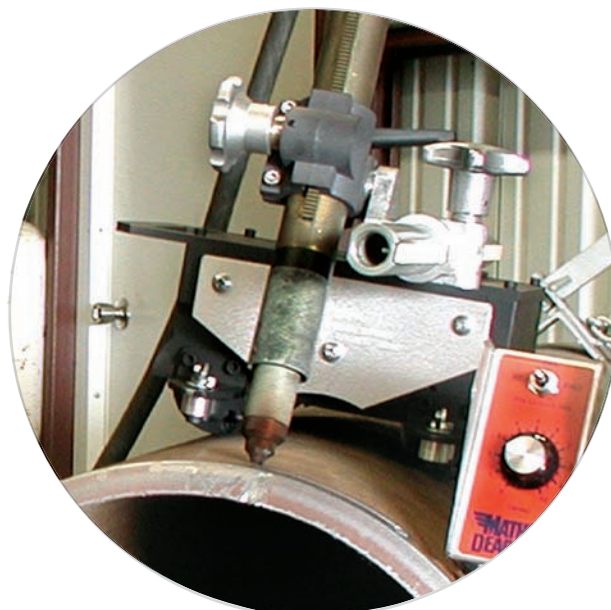


Vertical applications can be done safely and with ease when the Mini-MAG XM is used with a guide strip.



Part No.: 05.0550.MMBOX

Machine includes
Storage Box



Precise control of Mini-MAG XM speed can reduce grinding time by 85% with plasma cutting.

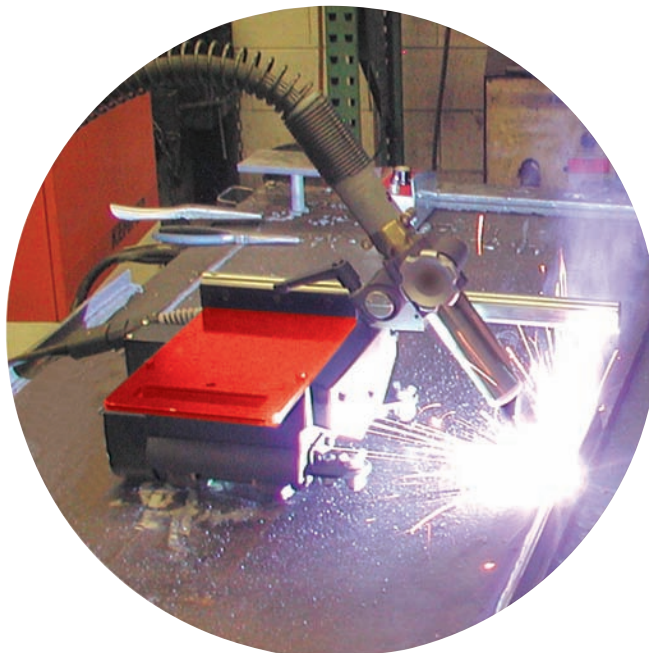
Mini-MAG XM Welding

Welding with the Mini-MAG XM

Many companies have gained a decisive advantage by using the Mini-MAG XM as a tractor for a machine welding torch for long tedious horizontal stringer welds.

The torch holder will accept 1 3/8" (35mm) welding torch with a 32 pitch rack.

The Mini-MAG XM can propel the welding torch at speeds from 2" to 40" (51mm to 1016mm) per minute depending on the welding source, gas mixture, and deposition rate.



Mini-MAG XM and Accessories

Model	Part Number	Estimated Shipping Weight (lbs / kg)
Mini-MAG XM, 115 vac	05.0550.MINIXM	39 / 17.6
Mini-MAG XM, 230 vac	05.0550.MINIXM2	39 / 17.6

Many users have found that the Mini-MAG XM is an excellent tool for tedious stringer weld applications.

Mini-MAG XM Technical Specifications

Description	Feature
Method of Attachment Mini-MAG XM	RARE EARTH MAGNETS
Holding Force Mini-MAG XM	150 lbs / 68 kg per Wheel Assembly
Set-Up Time	2 minutes or less
Minimum Cutting Range	O.D. - 6 5/8" / 168mm I.D. - 24" / 610mm
Minimum Speed	2" / 51mm per minute
Maximum Speed	40" / 1016mm per minute
Net Weight	31 lbs / 14 kg
Shipping Weight	39 lbs / 17.6 kg
Shipping Dimensions	18" x 18" x 10" / 457mm x 457mm x 254mm
Dimensions	
Width	17" / 431mm
Length	13" / 330mm
Height	9" / 229mm
Electrical Requirement	115 vac or 230 vac 50/60Hz

Contact
Mathey Dearman Technical Sales for details
about welding with the Mini-MAG XM

NOTE: The Mini-MAG XM is equipped with guides that can be used with 1" X 1" X 1/8" (125mm x 125mm x 3mm) angle iron for vertical (up or down) welding applications.

Mini-MAG XM

Mini-MAG XM has all of the outstanding features of the MagnaCut XM except for the Electronic Torch Arm. The cutting torch of the Mini-MAG XM moves backward and forward instead by means of a manually rotated rack with knob.

Mini-MAG XM is capable of cutting both horizontal and vertical pipe and plate.

The Mini-MAG XM is equipped with guide rollers for use with 1" x 1" x 1/8" (25mm x 25mm x 3mm) angle iron or the MagnaCut XM Guide Strip for vertical cutting.

A Guide Strip is recommended when using the Mini-MAG XM to cut pipes 18" (457mm) and larger to improve cutting accuracy.

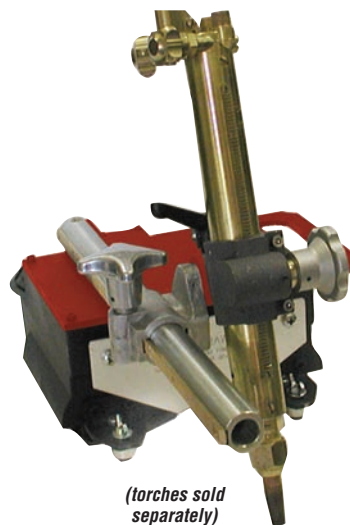
- **VERSATILE**—Bevels plate and pipe at angles to 45°.
- **MINIMUM SET-UP TIME**—Just strap on and begin cutting!
- **ADAPTABLE**—Can be used with oxy/fuel or plasma machine torches having a 1 3/8" (35mm) barrel diameter.
- **ELIMINATES** the need for more than one machine for different pipe and plate sizes.

Mini-MAG XM includes:

- Base machine
- Storage box
- Motor control box 115 vac or 230 vac
- Torch arm
- Sliding support
- Torch holder
- 74" (1880mm) long safety cable for pipe diameters up to 24" (610mm) pipe
- Two (2) snap hooks
- Cable latch
- Protective leather sheath
- Parts and operating manual

Not Included:

- Machine Cutting Torch



(torches sold separately)

Mini-MAG XM
Part No.: 05.0550.MINIXM



Motor Control Box



The Versatile Mini-MAG XM (shown plasma cutting 16" (406mm) pipe) can be used as a plate track burner or as a pipe cutting and beveling machine.

Torch Shut-Off Valve

The **Torch Shut-Off Valve** gives the operator the ability to shut-off the flow of oxygen and fuel to the cutting torch, without disturbing the oxygen and fuel settings, with only a flip of the switch. The ports of the Shut-Off Valve are only available in 9/16" - 18 hose threads.

Part No.: 05.0200.014



Torches and Accessories

Torches

Mathey Dearman is proud to offer quality accessories such as our oxy/acetylene torches with a 1 3/8" (35mm) barrel diameter with and without rack. All torches sold in the USA come with a check valve. Torches and tips are available for most fuel gases.

(Please refer to chart on next page for torches and accessories.)



Harris torch
05.0300.001
05.0300.002



Machine torch (Mathey)
without rack 05.0300.005
with rack 05.0300.008



Machine Torch Selection Chart

Model	05-0200-001 Victor MT204A 8" Machine Torch	05-0200-002 Victor MT210A 10" Machine Torch	05-0200-003 Victor Torch Angle Adaptor	05-0300-001 98-6E Harris 10" Machine Torch	05-0300-002 98-6E Harris 10" Machine Torch with Rack	05-0300-003 Harris 10M Machine Torch Angle Head Adaptor	05-0300-005 8" Mathey Torchless Rack	05-0300-008 8" Mathey Torch with Rack
MSA	4" / 102mm Only	1 1/2" to 4" / 38 to 102mm		1 1/2" to 4" / 38 to 102mm			4" / 102mm Only	
1SA	8" / 203mm Only	3" to 8" / 76 to 203mm		3" to 8" / 76 to 203mm			8" / 203mm Only	
2SA	12" / 305mm Only	6" to 12" / 152 to 305mm		6" to 12" / 152 to 305mm			12" / 305mm Only	
3SA		12" to 20" / 305 to 508mm		12" to 20" / 305 to 508mm				
4SA		20" to 25" / 508 to 660mm		20" to 25" / 508 to 660mm				
5SA		24" to 30" / 610 to 762mm		24" to 30" / 610 to 762mm				
6SA		24" to 30" / 610 to 762mm		24" to 30" / 610 to 762mm				
8SA		40" to 48" / 1016 to 1219mm		40" to 48" / 1016 to 1219mm				
MagnaCut XM	all diameters and angles to 20 degrees	all diameters with bevel angles to 37 1/2 degrees		all diameters with bevel angles to 37 1/2 Degrees	all diameters with bevel angles to 37 1/2 degrees			
Mini MAG	all diameters with bevel angles to 20 degrees	all diameters with bevel angles to 37 1/2 degrees		all diameters with bevel Angles to 37 1/2 degrees	all diameters with bevel angles to 37 1/2 degrees			
MINI	all diameters with bevel angles to 30 degrees	all diameters with bevel angles to 37 1/2 degrees		all diameters with bevel angles to 37 1/2 degrees	all diameters with bevel angles to 37 1/2 degrees		all diameters with bevel angles to 37 1/2 degrees	all diameters with bevel angles to 37 1/2 degrees
MAXI	all diameters with bevel angles to 30 degrees	all diameters with bevel angles to 37 1/2 degrees		all diameters with bevel angles to 37 1/2 degrees	all diameters with bevel angles to 37 1/2 degrees		all diameters with bevel angles to 37 1/2 degrees	all diameters with bevel angles to 37 1/2 degrees
Monarch Band Machine		all diameters	all diameters		all diameters	all diameters		

Torches and Accessories

Torches (Oxy/Acetylene and Propane)

Description	Part Number	Gas	Barrel Diameter (in / mm)	Barrel Length (in / mm)	Maximum Cutting Capacity (in / mm)	Estimated Shipping Weight (lbs / kg)
Torches						
Victor MT204A Machine 4.5" Cutting Torch**	05.0200.001	Act*	1 3/8" / 35	4 1/2" / 104	7 / 178	3.4 / 1.54
Victor MT210A 10" Machine Cutting Torch	05.0200.002	Act*	1 3/8" / 35	10 / 254	7 / 178	4 / 1.8
Victor BHA Torch Angle Head Adapter	05.0200.003	All	N/A	N/A	N/A	1.3 / .59
32 Pitch Rack for Victor MT210A Machine Torch**	05.0200.004	N/A	N/A	N/A	N/A	.15 / .07
Harris 10" Machine Torch 98-6E	05.0300.002	Act*	1 3/8" / 35	10 / 254	8 / 203	3.8 / 1.7
Harris 10" Machine Torch with 32 Pitch Rack 96-6ER-32	05.0300.001	Act*	1 3/8" / 35	10 / 254	8 / 203	3.8 / 1.7
Harris Torch Angle Head Adapter S-98-C	05.0300.003	All	N/A	N/A	N/A	1.3 / .59
Machine Torch less Rack, Mathey	05.0300.005	Act*	1 3/8" / 35	10 / 254	8 / 203	3.8 / 1.7
Machine Torch with Rack, Mathey	05.0300.008	Act*	1 3/8" / 35	10 / 254	8 / 203	3.8 / 1.7
Torch Shut-off Valve						
Torch Manifold Block	05.0200.014	All	N/A	N/A	N/A	.95 / .43
Fuel Gas Valve	05.0200.018	All	N/A	N/A	N/A	.4 / .18
Oxygen Valve	05.0200.019		N/A	N/A	N/A	.4 / .18
Y Connector	05.0200.015	All	N/A	N/A	N/A	.3 / .14
Oxygen Hose	05.0200.016		N/A	N/A	N/A	.4 / .18
Fuel Gas Hose	05.0200.017	All	N/A	N/A	N/A	.4 / .18

*May also be used on other pressurized fuel gases.

**Torch Rack (PN. 05-0200-004) can not be used with torch (PN. 05-0200-001).

Cutting Tips (Oxy/Acetylene and Propane)

Description	Part Number	Gas	Tip Length (in / mm)	Max Cutting Capacity (in / mm)	Estimated Shipping Weight (lbs / kg)
Victor Cutting Tip	05.0201.001	Act	3 / 76.2	3/4 / 19	.2 / .1
Victor Cutting Tip	05.0201.002	Act	3 / 76.2	1 / 25	.2 / .1
Victor Cutting Tip Button	05.0201.003	Act	3/4 / 19	3/4 / 19	.15 / .07
Victor Cutting Tip	05.0201.013	P/NG	3 / 76.2	3/4 / 19	.2 / .1
Victor Cutting Tip	05.0201.014	P/NG	3 / 76.2	1 / 25	.2 / .1
Harris Cutting Tip	05.0301.001	Act	3 / 76.2	1 / 25	.15 / .07
Harris Cutting Tip	05.0301.002	Act	3 / 76.2	2 / 51	.15 / .07
Mathey No. 1 Cutting Tip	05.0301.041	Act	3 / 76.2	1 / 25	.15 / .07
Mathey No. 2 Act. Cutting Tip	05.0301.042	Act	3 / 76.2	2 / 50	.15 / .07
Mathey No. 3 Act. Cutting Tip	05.0301.043	Act	3 / 76.2	1 / 100	.15 / .07
Mathey No. 1 Cutting Tip	05.0301.033	P	3 / 76.2	2 / 25	.15 / .07
Mathey No. 2 Cutting Tip	05.0301.034	P	3 / 76.2	2 / 50	.15 / .07
Mathey No. 3 Cutting Tip	05.0301.035	P	3 / 76.2	2 / 100	.15 / .0

Act – Acetylene All – Can be used with all gases.
P – Propane NG – Natural Gas

Torch Tip Selection

A rule for calculating material thickness in order to select the right torch tip is:

- 15 degree bevel angle is 1 times the pipe wall thickness.
- 30 degree bevel angle is 1.2 times the pipe wall thickness.
- 37 1/2 degree bevel angle is 1.3 times the pipe wall thickness.
- 45 degree bevel angle is 1.4 times the pipe wall thickness.

Example: 8" - Schedule 80 has a wall thickness of .5" (12.7mm).

To calculate the material thickness to be cut at torch bevel angle of 37 1/2 degrees—multiply .500" (12.7mm) x 1.3 = .650" (16.5mm).

Victor torch tip



Harris torch tip



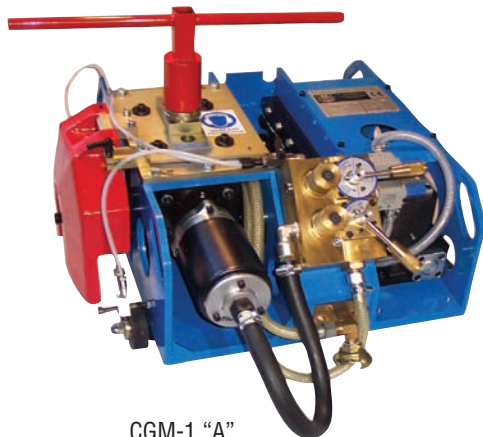
Mathey torch tip



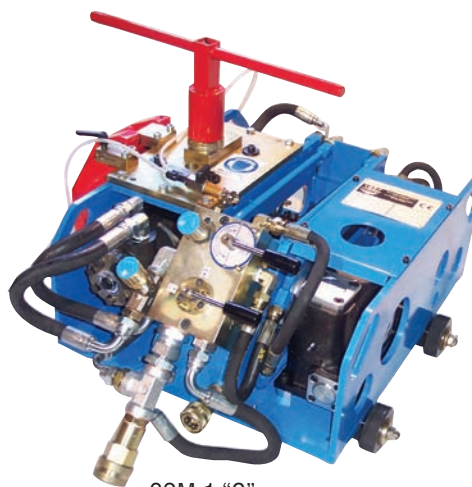
CGM-1 COLD CUTTING & BEVELING MACHINE

in Pneumatic and Hydraulic versions

CE Approved



CGM-1 "A"
Pneumatic Driven
Part No.: 05.5500.559



CGM-1 "O"
Hydraulic Driven
Part No.: 05.5500.560

The CGM Cold Cutting and Beveling Machine includes:

- Base cold cutting machine
- Blade guard
- blade shut-off valve
- Service wrenches
- Parts and operating manual
- "T" handle for lowering and raising the cutting blade
- Torque wrench for tensioning the drive chain
- Rugged steel storage box

NOTE: severing blades, beveling blade and drive chain required—order separately.

The **MATHEY Pneumatic or Hydraulic Powered CGM-1 Chain Driven Cold Cutting System** will cut and bevel most machinable materials such as carbon steel, stainless steel, ductile Iron, cast iron and most other alloys without spark or flame. The rugged and powerful CGM-1 is ideal for new construction, fabrication, tear down or removal of components for replacement.

The heavy-duty chain tensioning mechanism, encased in an all high strength alloy frame, provides the necessary rigidity and strength for cutting pipe at the highest travel speed possible. The frame of the CGM has six (6) wheel positions to closely follow radius of the pipe for improved tracking.

The CGM's two-speed-drive gear box provides positive movement of the machine around the pipe in all types of pipe cutting conditions. No out-of-round compensation is needed, as the machine follows the pipe outside diameter, producing an even and consistent cut. The drive chain can be shortened or lengthened to accommodate 6" to 72" (152-1829mm) pipe or vessels.

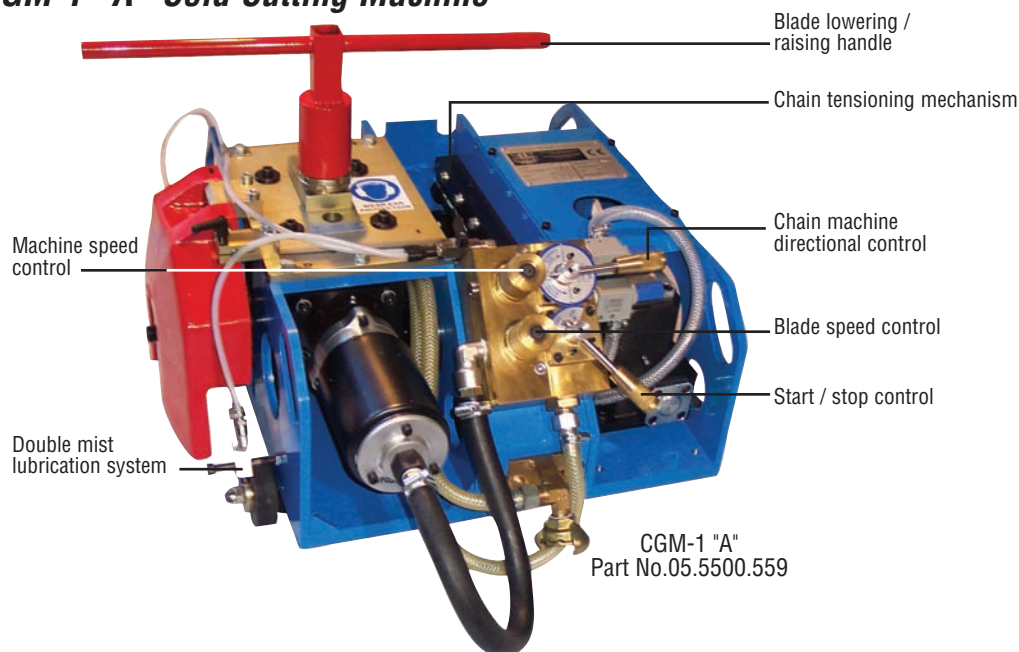
The tough gearbox of the blade drive system is designed to take the heavy sustained cutting loads encountered with

continuous operation. The severing blade and right and left beveling blades can be changed without removing the machine from the pipe. Right and left beveling blades are available in 30°, 37 1/2°, "U" joint and "J" prep configurations for heavier wall thickness. A cut that is machine-like in appearance with typical tolerances of .01" (.3mm), is normal on pipes as large as 40" diameter. Guide strips and grooved wheels are available for cutting vertical pipe.

Model	Part Number	Estimated Shipping Weight lbs / kg
CGM-1 "A" - Pneumatic Chain Drive Cold Cutting Machine with Blade Shut-Off Device. Cutting Range: 6" - 72" / 152 - 1829mm	05.5500.559	476 / 216
CGM-1 "A" - Pneumatic Chain Drive Cold Cutting Machine with Blade Shut-Off Device for Corrosive Environment. Cutting Range: 6" - 72" / 152 - 1829mm	05.0550.559-COR	476 / 216
CGM-1 "O" Hydraulic Chain Drive Cold Cutting Machine with Blade Shut-Off Device. Cutting Range: 6" - 72" / 152 - 1829mm	05.0550.560	492 / 223
CGM-1 "O" - Hydraulic Chain Drive Cold Cutting Machine with Blade Shut-Off Device for Corrosive Environment. Cutting Range: 6" - 72" / 152 - 1829mm	05.0550.560-COR	492 / 223

Pneumatic CGM-1 "A" Cold Cutting Machine

CE Approved



The **Pneumatic Drive CGM-1 "A"** is an excellent tool for shop or field use. The machine is used best for mechanically cutting pipes in explosive environments such as refineries or pipelines conveying natural gas, crude oil or crude oil by-products.

Machine speed and blade RPM are precisely controlled by means of two (2) metering valves located on the machine control block. Airflow to the blade motor and main drive motor can be shut-off simultaneously with start/stop control valve located on the lower part of the control block.

Two (2) highly reliable heavy-duty pneumatic motors are incorporated into the design of the CGM-1 "A". A 3.7HP (2.75KW) pneumatic motor

coupled to an extra heavy-duty transmission rotates the cutting blades at speeds up to 80rpm. A .75HP (.56KW) pneumatic motor connected to a two speed drive transmission moves the machine around the pipe at speeds up to 1.52 in/min (38.6mm/min).

To reach its maximum cutting potential, the CGM-1 "A" requires an air compressor that delivers 120psi at 142 cubic ft / min (8 bar at 4000 l / min). Pressure to the machine is regulated to 6 bar by means of a regulator on the filter block.

Beveling blades are available in various configurations—for example, 30° or 37 1/2° bevel angle, "U" joint and "J" prep configurations.



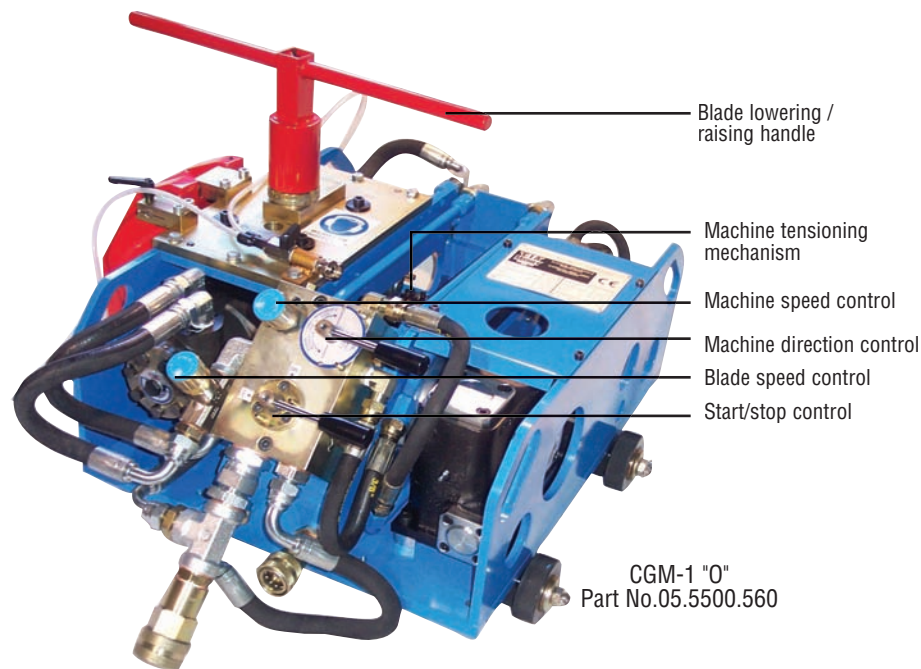
One revolution around this 35" (889mm) pipe is all it takes to center the machine on the pipe for a perfect cut.



The double mist coolant system provides lubrication to the cutting and beveling blades so that many cuts can be made on this 36" (914mm) pipe before re-sharpening is required.

Hydraulic CGM-1 "O" Cold Cutting Machine

CE Approved



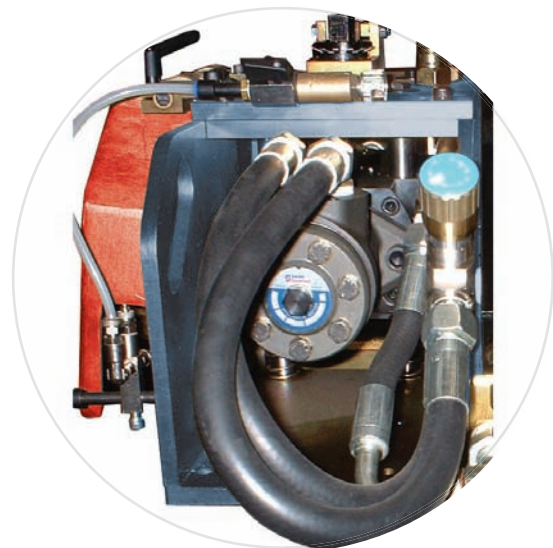
The **Hydraulic Drive CGM-1 "O"** is specifically designed for continuous cutting of heavier wall high alloy pipes. The CGM-1 "O" will cut material thickness up to 1 1/2" (38mm) in one pass with special blades (depending on material hardness).

The closed loop hydraulic system of the CGM-1 "O" insures proper lubrication to the blade and drive motors. The dual hydraulic motors are infinitely adjustable and deliver consistent horsepower to the cutting and beveling blades and drive motors.

The CGM-1 "O" has two (2) hydraulic motors incorporated into the design of the CGM-1 "O". A 5.4HP (4KW) hydraulic motor, coupled to an extra heavy-duty transmission rotating the cutting blades at speeds up to 80rpm. A 1.3HP (1KW) hydraulic motor, connected to a two speed drive transmission, moves the machine around the pipe at speeds up to 1.52 in/min (38.6mm/min).



The CGM is capable of cutting diagonal and vertical pipes when used with the guide strip and grooved wheels.



Consistent hydraulic force, applied to the hydraulic motor, insures constant blade and machine speed, producing a cut machine-like in appearance.

CGM-1 Cold Cutting and Beveling Machine - Specifications

Specifications

Cutting Range of Horizontal Pipe.	6" – 72" / 152mm – 1.8m*
Cutting Range of Vertical Pipe.	16"-72" / 406mm - 1.8m**
Maximum Cutting Depth of 45,000 psi Tensile Strength with 37 1/2° Bevel Angle.	Pneumatic – 1 1/4" / 31.8mm***
	Hydraulic – 1 1/2" / 38mm***
Maximum Cutting Depth of 70,000 PSI Tensile Strength with 37 1/2° Bevel Angle.	Pneumatic – 5/8" / 16mm***
	Hydraulic – 1 1/16" / 27mm***
Maximum Cutting Depth of 70,000 PSI Tensile Strength with Severing Blade Only. ****	Pneumatic – 1 1/4" / 31.8mm
	Hydraulic – 1 1/2" / 38mm
Cutter Motor	Pneumatic – 3.75HP / 2.75KW
	Hydraulic – 5.4HP / 4KW motor connected to a Worm Drive Transmission
Cutter Speed	Pneumatic – 71 RPM
	Hydraulic – 76 RPM
Drive Motor	Pneumatic - .75HP / .56KW Motor connect to a Multi-Gear Transmission
	Hydraulic - 1.3HP / 1KW Motor connect to a Multi-Gear Transmission
Maximum Forward Speed	Pneumatic – 0 – 1-1/2" / 38mm per minute
	Hydraulic – 0 – 2 9/16" / 65mm per minute
Feed Method	Positive Non-slip 4-mesh Chain Drive
Air Requirement	90 psi at 142 Cubic feet per minute
	6.2 bar at 4,000 liter per minute
Hydraulic Requirement	1420 psi at 20 gallons per minute / 100 bar at 72 liters
Controls	Main Control shuts off all Air or Hydraulic Pressure to CGM. The Valve is interlocked to Feed Control avoiding damage to the Blade. Forward/Neutral/Reverse Valve to control machine. Cutter and Drive Motor Metering Valves that control blade and forwarding speed.
Finish	Powder Paint Coated
Machine Dimensions	22" x 25-5/8" x 14-1/8" / 560 x 650 x 360mm
Storage Box	38" x 28 1/2" x 26" / 965 x 724 x 660mm
Net Weight (lbs / kg)	Pneumatic – 302 / 137
	Hydraulic – 317 / 144
Shipping Dimensions (W x D x H)	38" x 29" x 26" / 965 x 737 x 660mm
Shipping Weight (lbs / kg)	Pneumatic – 476 / 216
	Hydraulic – 592 / 223

* Special wheels required for 6" pipe.

** Guide strips and grooved wheels required when cutting vertical pipe.

*** Single pass cutting depth. Special beveling blades required. When cutting at maximum depth listed an extended amount of time will be required to cut the pipe.

**** Blade spacer - (see chart next page.)



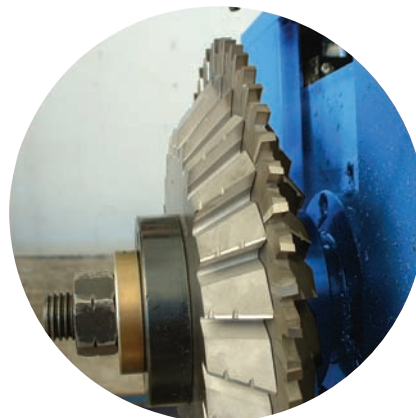
Rugged steel storage box

The CGM Heavy-Duty Storage Box is large enough to hold the CGM and all of its accessories, and strong enough that it can also be used for maintenance of the CGM or as a work platform.

CGM Accessories

The CGM has enhanced severing and beveling blades to make the cutting and beveling of higher tensile strength pipes effortless. The new blades freely cut the higher strength material reducing vibration. The superior design and material composition of the new blades make them last longer and require less grinding.

The CGM can produce almost any type of pipe end configuration including standard bevels, "U" bevels, "J" preps and compound bevel angles by simply changing the beveling blades. The machine will cut and bevel any machinable material such as carbon steel, stainless steel, ductile iron, cast iron, and most other alloys without spark or flames. The machine cuts and bevels both sides of the cut simultaneously with a second cut not required.



The CGM cutting system will sever and bevel both sides of the pipe regardless of the pipe diameter.



Beveling Blade Severing Blade Beveling Blade

CGM-1 Accessories

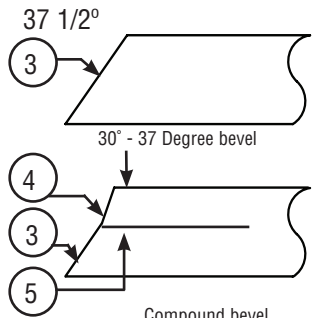
Part Number	Description	Estimated Shipping Weight (lbs / kg)
05.5500.517	Blade Lubrication Fluid	2 / 1
Severing Blades		
05.5500.6579	Standard Blade, 8-3/8" x 3/16" / 212 x 4.57mm	2 / 1
Beveling Blades		
05.5500.BLNK*	Blade Spacer, used when severing only (2 required)	5.5 / 2.5
05.5500.6251	Right 30°, 7-1/4" x 5/8" / 184 x 16.45mm	5.5 / 2.5
05.5500.6252	Left 30°, 7-1/4" x 5/8" / 184 x 16.45mm	5.5 / 2.5
05.5500.6510	Right 37-1/2°, 7-1/4" x 5/8" / 184 x 16.45mm	5.5 / 2.5
05.5500.6511	Left 37-1/2°, 7-1/4" x 5/8" / 184 x 16.45mm	5.5 / 2.5

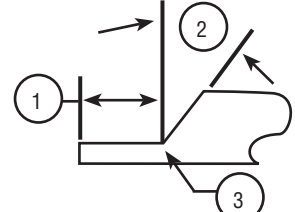
*The CGM can be used to sever the pipe without the beveling blades when the blade spacers are used.

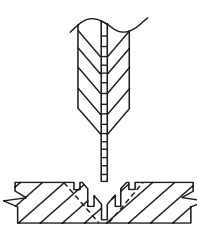
NOTE: The above CGM severing blades are not interchangeable with the old style severing and beveling blades.

NOTE: We can also offer special steel discs to replace the beveling blades at a fraction of the cost for customers who need the machine to cut the pipe without beveling.

QUOTING AND ORDERING INFORMATION

 <p>37 1/2° 30° - 37 Degree bevel Compound bevel</p>	<p>Beveling Blades - if other than 30° or 37 1/2°</p> <ol style="list-style-type: none"> 1. Pipe outside diameter _____ 2. Pipe wall thickness _____ 3. Bevel angle _____ 4. 2nd bevel angle if compound bevel _____ 5. Height of second bevel _____
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 <p>1, 2, 3</p>	<p>J Prep Beveling Blades</p> <ol style="list-style-type: none"> 1. Length of land _____ 2. Bevel angle _____ 3. Radius at point land meets beveling angle _____
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	<p>Thick-walled pipes can be cut with the CGM by making multiple passes with the severing blade only or with the combination of the beveling blades and the severing blades. While the finish of the bevel is not smooth, it is a practical means of severing heavier-walled pipes that are up to 1 1/2" / 38mm thick without needing special blades.</p>
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CGM Accessories (Continued)



Four (4) link chain

CGM Chain Kits

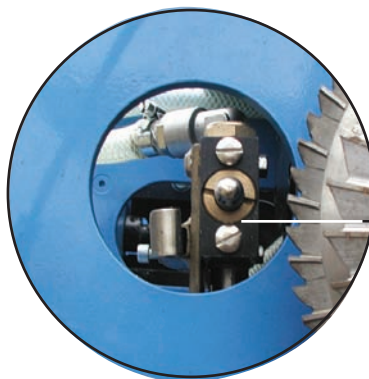
Part Number	Wheel Position	Description	Estimated Shipping Weight (lbs / kg)
01.5500.006	3 - 4	Chain Kit for 6" pipe	7 / 3
01.5500.008	3 - 4	Chain Kit for 8" pipe	8 / 4
01.5500.010	3 - 4	Chain Kit for 10" pipe	9 / 4
01.5500.012	3 - 4	Chain Kit for 12" pipe	10 / 5
01.5500.016	3 - 5	Chain Kit for 16" pipe	11 / 5
01.5500.018	3 - 5	Chain Kit for 18" pipe	13 / 6
01.5500.020	2 - 5	Chain Kit for 20" pipe	14 / 6
01.5500.024	2 - 5	Chain Kit for 24" pipe	15 / 7
01.5500.030	2 - 5	Chain Kit for 30" pipe	18 / 8
01.5500.036	2 - 6	Chain Kit for 36" pipe	22 / 10
01.5500.042	2 - 6	Chain Kit for 42" pipe	25 / 11
01.5500.048	1 - 6	Chain Kit for 48" pipe	27 / 12
01.5500.054	1 - 6	Chain Kit for 54" pipe	29 / 13
01.5500.060	1 - 6	Chain Kit for 60" pipe	34 / 16
01.5500.072	1 - 6	Chain Kit for 72" pipe	39 / 18

CGM Cutter and Chain Information Chart

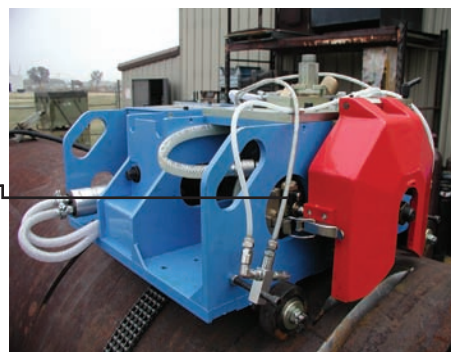
Nominal Pipe Size		Wheel Position	Chain Length		Quantity to Purchase in Feet	Depth of Cut			
						Cutter 6" / 152mm		Cutter 8 3/8" / 212mm	
Inches	mm		Inches	mm		Inches	mm	Inches	mm
6*	152	3 & 4	42	1065	4	1 3/8	35	2 5/16	60
8	203	3 & 4	47	1192	4	1 1/16	28	2 1/16	53
10	254	3 & 4	55	1395	5	3/4	20	1 3/4	45
12	305	3 & 4	61	1547	6	9/16	15	1 9/16	40
14	356	3 & 5	63	1598	6	1 1/8	30	2 1/8	55
16	408	3 & 5	69	1750	6	7/8	25	1 15/16	50
18	457	3 & 5	76	1918	7	3/4	20	1 3/4	45
20	508	2 & 5	82	2070	7	1 3/8	35	2 5/16	60
24	610	2 & 5	92	2335	8	1 1/16	28	2 1/16	53
30	762	2 & 5	114	2892	10	3/4	20	1 3/4	45
32	810	2 & 5	116	2940	10	9/16	15	1 9/16	40
36	914	2 & 6	137	3476	12	1 1/8	30	2 1/8	55
40	1016	2 & 6	144	3650	12	7/8	25	1 15/16	50
42	1067	2 & 6	156	3950	13	3/4	20	1 3/4	45
48	1200	1 & 6	165	4180	14	1 3/8	35	2 5/16	60
54	1400	1 & 6	183	4644	16	1 1/8	30	2 1/8	55
60	1500	1 & 6	214	5431	18	1 1/16	28	2 1/16	53
72	1800	1 & 6	244	6193	21	3/4	20	1 3/4	45

* Special four (4) wheels required for 6" (152mm) pipe.

- **DEPENDABLE** cutting and beveling of thin or thick wall pipes or tubes.
- **PRECISE CONTROL** of cutter and machine speeds produce a machine finish required for automated welding.
- **A SECOND CUT IS NOT REQUIRED** as the CGM bevels both sides of the cut **SIMULTANEOUSLY**.
- **ONE MACHINE** can cut and bevel pipe or tube 6" to 72" (152 to 1826mm) in diameter.
- **RUGGED DESIGN** permits the machine to be operated in desert, ocean or mountainous environments.
- **ACCURATE** cold cutting and beveling of large pipes and vessels.
- **SAFETY SHUT-OFF VALVE** turns the machine off automatically if blade guard is raised.
- **ELIMINATES RISK** of fire or explosion due to no spark or flame.



Blade shut-off device does not allow the machine to be operated until the blade guard is locked into position.



CGM Power Supply



Part No. : 05-5500-501

380 vac three (3) phase 50/60Hz electric motor-driven hydraulic power supply available. Outlet couplings are 1/2"-3/4" (12.7-19mm).



Part No. : 05-5500-501H

Diesel engine-driven hydraulic power supply is available.



Part No. : 05-5500-556

Engine-driven air compressor is available powered by a gas or diesel engine.

PNEUMATIC

The air compressor delivers 120 pounds per square inch at 142 cubic feet/minute (8 bar at 4000 liters/minute). Mounted on a trailer, the unit is easily towed behind most vehicles. The compressor is available with gas or diesel engine.

HYDRAULIC

Hydraulic power supply is available driven by either an electric motor or a diesel engine.

The electric motor driven hydraulic power supply utilizes 380 volt/50Hz - electric motor (15 HP) to drive the vane type hydraulic pump. The electric motor meets IEC - UNEL MEC Standards. The unit has a maximum output of 2,000 psi (138 bar) that is regulated with a pressure relief valve.

The unit has a reservoir capacity of approximately 52 gallons (200 liters). An indicator level located on the side of the reservoir indicates fluid level.

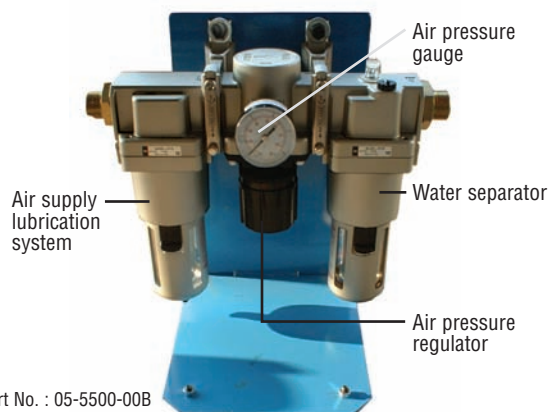
A 25-micron steel mesh filter is incorporated into the reservoir. The pressure outlet coupling is 1/2" (12.7mm) and the return coupling is 3/4" (19mm). The unit is moved about the shop easily with a forklift or pallet truck. Lifting lugs come standard for moving the power supply in the field.

The diesel-driven hydraulic power supply utilizes a diesel engine to drive the axial piston hydraulic pump. An adjustable-volume stop provides a means of controlling flow to the CGM-1. The unit has a maximum output of 2,000-psi (138 bar) that is regulated with a pressure relief valve.

CGM Power Supply

Part Number	Description	Shipping Weight (lbs / kg)
05.5500.556	Air Compressor, 116psi / 8bar 1057 gallons / 400 liters per minute	875 / 397
05. 5500.501	Electric Motor Driven Hydraulic Power Supply	450 / 204
05.5500.501H	Diesel Engine Driven Hydraulic Power Supply	560 / 254

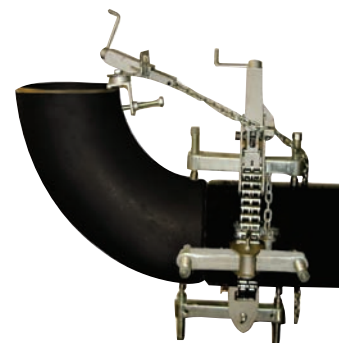
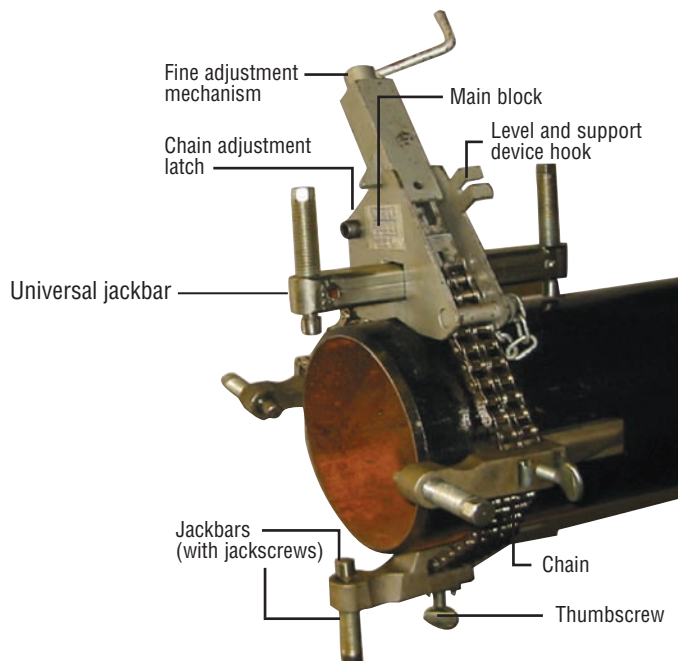
Lubrication/air regulator assembly



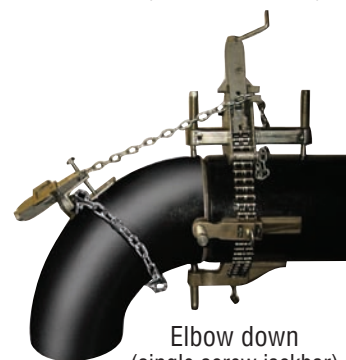
Part No. : 05-5500-00B

The lubrication/air regulator assembly for the air-driven CGM regulates the pressure from the air compressor down to the CGM operating pressure of 90 psi (6 bar). The lubrication/air regulator assembly also provides a mist of oil to lubricate the blade and drive air motor to help operate more efficiently.

ALIGNMENT AND REFORMING CHAIN CLAMPS



Elbow up
(Universal jackbar)



Elbow down
(single screw jackbar)

Process Improvement

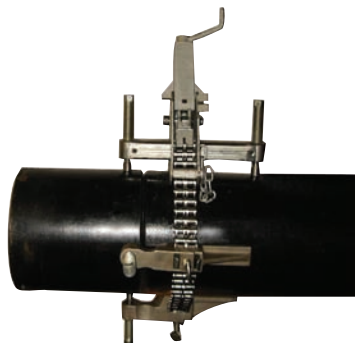
Mathey Dearman Chain Clamp align Schedule 80 and reform Schedule 40 pipes, elbows, tees and other fittings within their range, while providing the maximum degree of safety for the welder. Whether the process involves aligning and/or reforming small tubes or large vessels, a Mathey Dearman clamp is available to do the job.

Several different chain clamp models are available to accomplish the critical alignment and reforming of pipes and fittings, with a substantial impact on the quality and performance of the final weld.

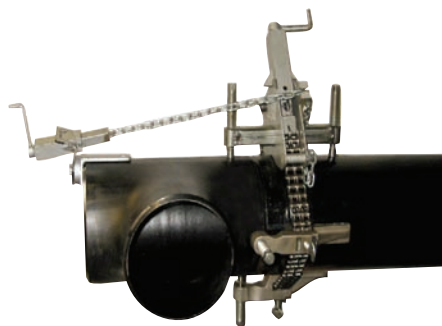
**MATHEY DEARMAN CHAIN CLAMPS ELIMINATE THE NEED FOR SUCH ITEMS
AS BOTTLE JACKS, WELD-ON LUGS AND CABLE HOISTS,
ALL OF WHICH PRESENT A SAFETY RISK TO THE WELDER.**



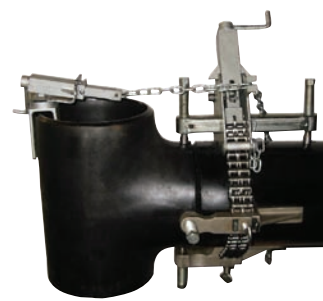
Cross-tee horizontal
(single screw jackbar)



Cross-tee horizontal
(single screw jackbar)

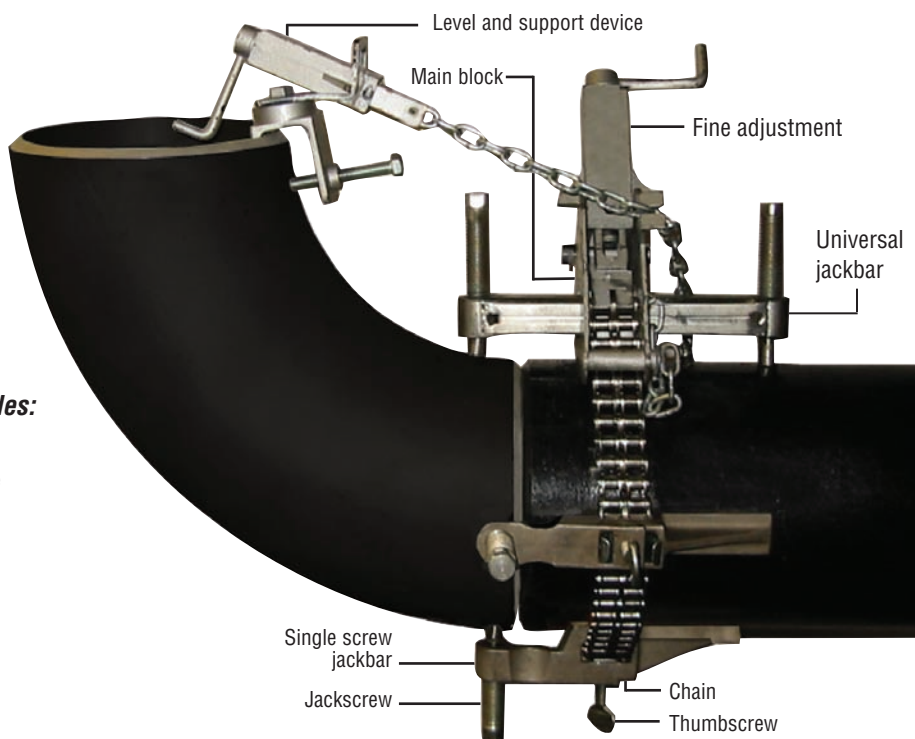


Tee in-line
(single screw jackbar)



Cross-tee vertical
(single screw jackbar)

Single Jackscrew Chain Clamp



Single Jackscrew Chain Clamp includes:

- Length of chain required for the pipe range
- Single jackscrew jackbars listed for pipe range
- Main block
- Fine adjustment
- Level and support device
- Jackscrew wrench
- Carbon or stainless steel
- Spacing screws (optional)
- Storage box
- Parts and operating manual

The Single Chain Clamp reduces fatigue as elbows, tees and other fittings can be held effortlessly in place while being accurately aligned with the level and support device.

The **Single Jackscrew Chain Clamp** reforms the mating side of the weld gap only, and is capable of reforming up to Schedule 40 pipe. The jackscrews of the jackbar exert pressure on the high points of the mating pipe eliminating "Hi-Lo" as pipe and fittings are aligned. Pipe wall thickness to Schedule 80 can be aligned with the Single Jackscrew Chain Clamp.

The level and support device of the chain clamp allows the pipe, elbow, tee, flange and other fittings to be held safely and securely in place during the alignment and welding process. For stainless steel or specialty alloy applications, replace the chain of the standard chain clamp with stainless steel chain.

Available in carbon steel and stainless steel models to fit pipe from 1" to 54" (25mm to 1372mm).

- **ACCURATE**—The single screw jackbars, spaced around the circumference of the pipe, provide precise alignment of the inside or outside diameter of the mating pipe to the main pipe within 1/64 of an inch.
- **PRECISELY ALIGNS** pipe wall thickness to Schedule 80.
- **EFFORTLESSLY REFORMS** mating pipe wall thickness to Schedule 40 pipe.
- **SAFE**—Elbows, tees, flanges and other fittings can be supported with the level and support device, reducing the risk of back injury.
- **VERSATILE**—The clamp will align and reform pipe, elbows, tees and other fittings.

SPECIAL BENEFITS: One chain clamp covers the range of eight (8) cage clamps. Pipe and other fittings can be fully welded without removal of the clamp. The jackscrew pads independently pivot to handle uneven surfaces. An add-on jackbar can be added if pressure needs to be applied between the clamp jackbars. Spacing screws can be added for precise weld gap adjustment.

Single Jackscrew Chain Clamp



Single Jackscrew Jackbar



The "High-Lo" of the 42" (1067mm) pipe can be effortlessly reformed to meet the inside or outside diameter of the mating pipe with jackscrews in the jackbar.

Single Jackscrew Chain Clamp - Specifications

Model	Number of Jackbars	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Estimated Shipping Weight (lbs / kg)
D231	3	1-8 / 25-203	40	80	21 / 9
D231SS	3	1-8 / 25-203	40	80	21 / 9
D232	7	4-16 / 102-406	40	80	68 / 31
D232SS	7	4-16 / 102-406	40	80	68 / 31
D233	8	10-36 / 254-914	40	80	144 / 67
D233SS	8	10-36 / 254-914	40	80	144 / 67
D234	13	10-54 / 254-1372	40	80	170 / 79
D234SS	13	10-54 / 254-1372	40	80	170 / 79

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

SS - Indicates clamp is for stainless steel application

WARNINGS

The clamp should never be used as the sole support for the pipe, nor should it ever be used to lift the pipe.

Do not exceed pipe size range listed without first contacting the Mathey Dearman sales department.

Do not use any type of chain other than those listed without first contacting Mathey Dearman sales department.

Use of chain not supplied with clamp by Mathey Dearman will void the warranty of the clamp.

Single Jackscrew Chain Clamp Kit (without chain)

Model	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Type of Chain Required	Chain Length Required (Ft. / M)	Estimated Shipping Weight (lbs / kg)
D231-KIT	1-8 / 25-203	40	80	Note: 1	3 / 1	19 / 9
D232-KIT	4-16 / 25-203	40	80	Note: 2	5 / 1.5	59 / 27

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

Does not include storage box.

Clamp Kit consists of main block, fine adjustment, level and support, single jackscrew jackbars as required for its range, and operating manual.

Note 1. 40-2: riveted nickle plated roller or 40-2: riveted stainless steel roller chain (ANSI#: 40-2R or equal)

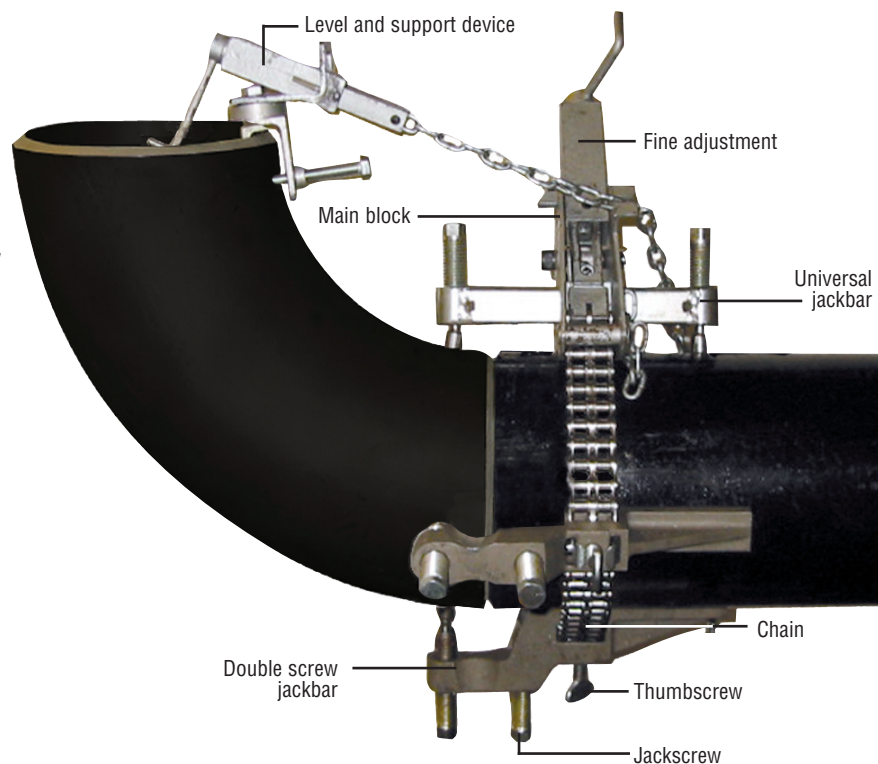
Note 2. 60-2: riveted nickle plated roller or 60-2: riveted stainless steel roller chain (ANSI#: 60-2R or equal)

NOTE: Mathey Dearman Chain Clamps can be reconfigured for stainless steel and other specialty alloy applications. Simply replace the carbon steel roller chain with stainless steel chain to align stainless steel pipe. All other components of Chain Clamps are made of stainless steel.

Double Jackscrew Chain Clamp

Double Jackscrew Chain Clamp includes:

- Length of chain required for the pipe range
- Double jackscrew jackbars listed for the pipe range
- Main block
- Fine adjustment
- Level and support device
- Jackscrew wrench
- Carbon or stainless steel spacing screws (optional)
- Storage box
- Parts and operating manual



All Double Jackscrew Chain Clamps come with level and support device.

The **Double Jackscrew Chain Clamp** reforms Schedule 40 pipe on either side of the joint to be welded. The jackscrews of the jackbar exert pressure on the high points of both sides of the weld joint to eliminate "Hi-Lo". Pipe wall thickness up to Schedule 80 can be aligned with the clamp.

The level and support device of the chain clamp allows the pipe, elbow, tee, flange and other fittings to be held safely and securely in place during the alignment and welding process.

For stainless steel or specialty alloy applications replace the chain of the standard chain clamp with stainless steel chain.

Available in steel and stainless steel models to fit pipe from 1" to 54" (25mm to 1372mm).

- **EXTRA CLEARANCE**—Double jackscrew jackbar has extra clearance under the jackbar to better facilitate tig welding torch.
- **CRUCIAL ALIGNMENT**—The double jackbars, spaced around the outside diameter of the pipe, provide concise alignment and reforming of the internal or external diameters of both pipes within 1/64 of an inch.

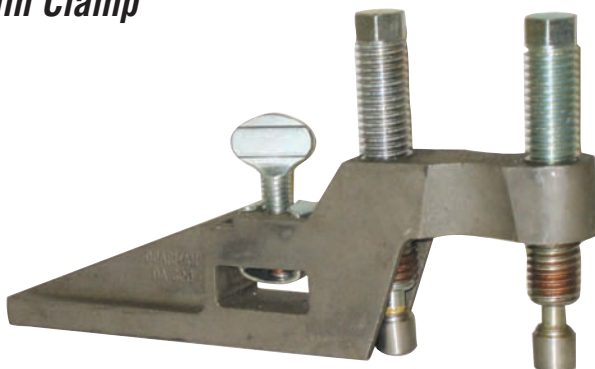
- **SAFE**—Elbows, tees and other fittings can be held safely and securely in place during alignment with the level and support device.
- **VERSATILE**—The Chain Clamp can be used to support, align, and reform elbow, tees and other fittings that a cage clamp can not manage. One Chain Clamp covers the range of eight (8) cage clamps.
- **READILY REFORMS** pipes on both sides of the weld joint to Schedule 40 pipe and aligns Schedule 80 pipes, elbows, tees and other fittings.

NOTE: Complete welding of the pipe and fittings can be accomplished without removal of the clamp.

Add-on jackbar can be added if pressure needs to be applied between the clamp jackbars.

Jackscrew pads independently pivot to handle uneven surfaces. Spacing screws can be added for precise weld gap adjustment.

Double Jackscrew Chain Clamp



Double Jackscrew Jackbar

Double Jackscrew Chain Clamp – Specifications

Model	Number of Jackbars	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Estimated Shipping Weight (lbs / kg)
D250	3	1-8 / 25-203	40	80	27 / 12
D250SS	3	1-8 / 25-203	40	80	27 / 12
D249	7	4-16 / 102-406	40	80	72 / 33
D249SS	7	4-16 / 102-406	40	80	72 / 33
D235	8	10-36 / 254-914	40	80	144 / 67
D235SS	8	10-36 / 254-914	40	80	144 / 67
D236	13	10-54 / 254-1372	40	80	180 / 72
D236SS	13	10-54 / 254-1372	40	80	180 / 72

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

SS - Indicates clamp is for stainless steel applications.

WARNINGS

The clamp should never be used as the sole support for the pipe, nor should it ever be used to lift the pipe.

Do not exceed pipe size range listed without first contacting the Mathey Dearman sales department.

Do not use any other type of chain other than those listed at bottom of this page without first contacting Mathey Dearman sales department.

Use of chain not supplied with clamp will void the warranty of the clamp.

NOTE: Mathey Dearman Chain Clamps can be reconfigured for stainless steel and other specialty alloy applications. Simply replace the carbon steel roller chain with aligning stainless steel pipe. All other components of Chain Clamps are made of stainless steel.

Double Jackscrew Chain Clamp Kit (does not include chain)

Model	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Type of Chain Required	Chain Length Required (Ft. / M)	Estimated Shipping Weight (lbs / kg)
D250-KIT	1-8 / 25-203	40	80	Note: 1	3 / 1	19 / 9
D249-KIT	4-16 / 25-203	40	80	Note: 2	5 / 1.5	59 / 27

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

Does not include storage box.

Clamp kit consists of main block, fine adjustment, level and support device, double jackscrew jackbars as required for its range, and operating manual.

Note: 1. 40-2: riveted nickel plated roller or 40-2: riveted stainless steel roller chain (ANSI#: 40-2R or equal)

Note: 2. 60-2: riveted nickel plated roller or 60-2: riveted stainless steel roller chain (ANSI#: 60-2R or equal)

Dearman Light Chain Clamp

Single and Double Light Jackscrew—reforms pipe up to Schedule 20 and aligns pipe to Schedule 40.

Light Chain Clamps include:

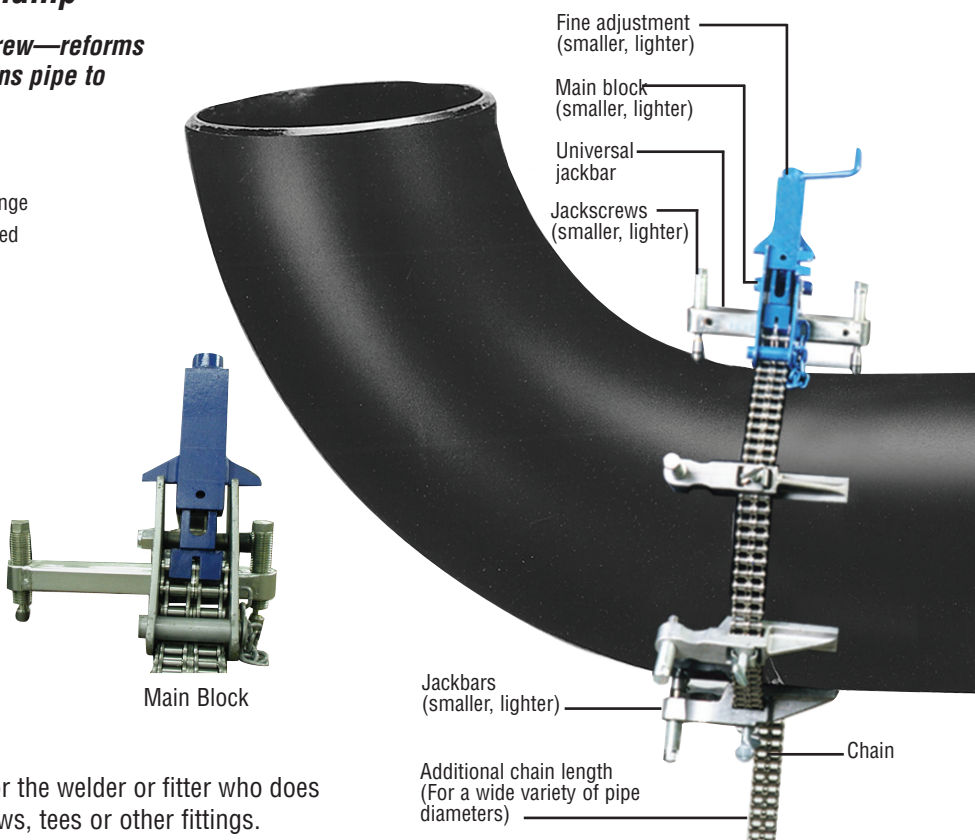
- Length of chain required for the pipe range
- Single or double jackscrew jackbars listed for the pipe range
- Main block
- Fine adjustment
- Level and support device (level and support device not included with D231-LT and D231-LTSS)
- Jackscrew wrench
- Parts and operating manual

Not Included:

- Storage box (storage box not included with D231-LT and D231-LTSS)

Optional:

- Carbon or stainless steel
- Spacing screws (optional)



The ideal chain clamp for the welder or fitter who does not need to reform elbows, tees or other fittings.

The **Dearman Light series of Chain Clamps** are durable and versatile and, like the original Dearman Chain Clamp, reform up to Schedule 20 and align up to Schedule 40 pipe. The jackscrews in the jackbar give the welder the ability to obtain the optimum fit-up of the pipes or fittings to be joined.

This light-weight clamp is rapidly adjusted to any pipe diameter by pulling the chain through the main block. Precision outside or inside diameter alignment can be quickly obtained without operator fatigue.

Optional:

- The level and support device assists the welder in holding and accurately positioning pipe or fittings for welding.
- Available in steel and stainless steel models for pipe 1" to 36" (25mm to 914mm) in diameter.

- **ACCURATE**—Within 1/64 of an inch alignment of internal or external pipe with jackbars spaced around the pipe joint.
- **LESS FATIGUE**—The lightweight Dearman Light Chain Clamp is the best tool for alignment of pipes and fittings when reforming is not required.
- **THINK LIGHT**—The 1" – 12" (25 – 305mm) Dearman Light Chain Clamp weighs 50% less than the 8" (203mm) hand lever cage clamp and covers the pipe size range of eleven (11) cage clamps.
- **SAFE**—Elbows, tees, flanges and other fittings can be held safely and securely in place during alignment with the level and support device (optional).
- **VERSATILE**—One chain clamp covers the pipe size range of eleven (11) cage clamps.
- **PRECISELY ALIGNS** pipe with wall thickness to Schedule 40, and reforms pipes to Schedule 40.

NOTE: Complete welding of the pipe and fittings can be accomplished without removal of the clamp.

Add-on jackbar can be added to most models when pressure needs to be applied between the camp jackbars.

Jackscrew pads independently pivot to handle uneven surfaces. Spacing screws can be added for precise weld gap adjustment.

Dearman Light Chain Clamp

Dearman Light Single Jackscrew Chain Clamp

Model	Number of Jackbars	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Estimated Shipping Weight (lbs / kg)
D231-LT**	5	1-12 / 25-305	20	40	13 / 6
D231-LTSS**	5	1-12 / 25-305	20	40	13 / 6
D232-LT	7	4-20 / 102-506	20	40	31 / 14
D232LTSS	7	4-20 / 102-506	20	40	31 / 14
D233-LT	10	6-36 / 152-914	20	40	84 / 38
D233LTSS	10	6-36 / 152-914	20	40	84 / 38

*Calculations are based on pipe with a tensile strength of 45,000 lbs (20,412kg).

SS - Indicates clamp is for stainless steel application.

** Does not include level and support device or storage box.

Dearman Light Double Jackscrew Chain Clamp

Model	Number of Jackbars	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Estimated Shipping Weight (lbs / kg)
D249-LT	7	4-20 / 102-506	20	40	36 / 17
D249-LTSS	7	4-20 / 102-506	20	40	36 / 17
D235-LT	10	6-36 / 152-914	20	40	90 / 41
D235LTSS	10	6-36 / 152-914	20	40	90 / 41

*Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

Dearman Light Single Jackscrew Chain Clamp Kit (does not include chain)

Model	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Type of Chain Required	Chain Length Required (Ft. / M)	Estimated Shipping Weight (lbs / kg)
D231-LTKIT*	1-12 / 25-305	20	40	1	4 / 1.2	10 / 5
D232-LTKIT	4-20 / 25-508	20	40	2	7 / 2.1	25 / 11
D233-LTKIT	6-36 / 152-914	20	40	2	10 / 3	69 / 31.3

*Does not include level and support device.

Does not include storage box.

Dearman Light Double Jackscrew Chain Clamp Kit (does not include chain)

Model	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Type of Chain Required	Chain Length Required (Ft. / M)	Estimated Shipping Weight (lbs / kg)
D249-LTKIT	4-20 / 25-508	20	40	Note: 1	7 / 2.1	29 / 13
D235-LTKIT	6-36 / 152-914	20	40	Note: 2	10 / 3	50 / 22.6

*Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

Does not include storage box.

Clamp includes: main block, fine adjustment, level and support device, Dearman light single jackscrew jackbars / double light jackscrew jackbars as required and operating manual.

Note: 1. 40-2: riveted nickel plated roller or 40-2:
riveted stainless steel roller chain (ANSI#: 40-2R or equal)

Note: 2. 60-2: riveted nickel plated roller or 60-2:
riveted stainless steel roller chain (ANSI#: 60-2R or equal)



Dearman Light Double Jackscrew Chain Clamp aligning 24" Schedule 40 pipe prior to welding.

WARNINGS

The clamp should never be used as the sole support for the pipe, nor should it ever be used to lift the pipe.

Do not exceed pipe size range listed without first contacting the Mathey Dearman sales department.

Do not use any type of chain other than those listed below without first contacting Mathey Dearman sales department.

Use of chain not supplied with clamp by Mathey Dearman will void the warranty of the clamp.

NOTE: Mathey Dearman Chain Clamps can be reconfigured for stainless steel and other specialty alloy applications. Simply replace the carbon steel roller chain with stainless steel chain. All other components of Chain Clamps are made of stainless steel.

Universal Chain Clamp

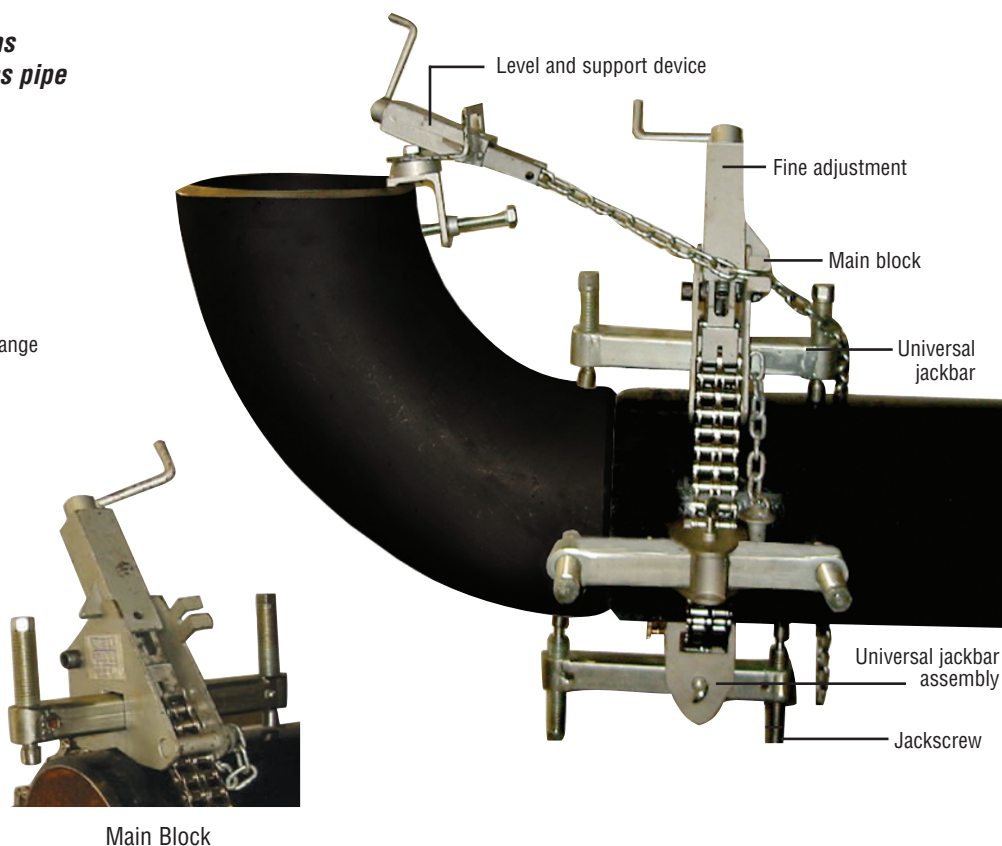
Universal Chain Clamps reforms pipes to Schedule 20 and aligns pipe to Schedule 40.

Includes:

- Length of chain required for the pipe diameter specified
- Universal jackbars listed for the pipe range
- Main block
- Fine adjustment
- Level and support device
- Jackscrew wrench
- Storage box
- Parts and operating manual

Optional:

- Carbon or stainless steel
- Spacing screws (optional)



Main Block

The **Universal Chain Clamp's** design gives the welder the ability to accurately fit-up, weld and grind the pipe without removal of the clamp. The level and support device of the chain clamp allows the pipe, elbow, tee, flange and other fittings to be held safely and securely in place during the alignment and welding process.

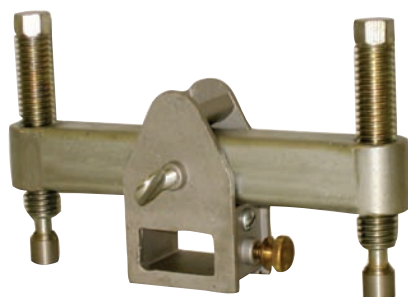
Replace the chain of the standard Chain Clamp with stainless steel chain for stainless steel or specialty alloy applications.

Available in carbon steel and stainless steel models to fit pipe from 1" to 36" (25mm to 914mm).

- **VERSATILE**—Jackbars will pivot on uneven surfaces. One Chain Clamp covers range of eight (8) cage clamps.
- **PRECISE**—Jackbars, spaced around the pipe, provide support and concise alignment of the pipe internal or external diameter within 1/64 of an inch.
- **SAFE**—Jackbars can be moved backward and forward in the jackbar holder as needed for extra support of elbows, tees and other fittings.
- **REFORMS** pipes to Schedule 20 pipe and aligns pipes to Schedule 40.

NOTE: Complete welding and grinding of the pipe and fittings can be performed without removal of the clamp. Add-on jackbar can be added to most models when pressure needs to be applied between the clamp jackbars. Jackscrew pads independently pivot to handle uneven surfaces. Spacing screws can be added for precise weld gap adjustment.

Universal Chain Clamp



Universal jackbar



The Universal Chain Clamp jackbars will slide backward and forward in the holder block to provide support as required under mating pipes, elbows, tees and other fittings.

Universal Chain Clamp – Specifications

Model	Number of Jackbars	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Estimated Shipping Weight (lbs / kg)
D2250	3	1-8 / 25-203	20	40	25 / 11
D2250SS	3	1-8 / 25-203	20	40	25 / 11
D2249	7	4-16 / 102-406	20	40	70 / 32
D2249SS	7	4-16 / 102-406	20	40	70 / 32
D2235	8	10-36 / 254-914	20	40	145 / 65
D2235SS	8	10-36 / 254-914	20	40	145 / 65

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

SS - Indicates clamp is for stainless steel application.

NOTE: Mathey Dearman Chain Clamps can be reconfigured for stainless steel and other specialty alloy applications. Simply replace the carbon steel roller chain with aligning stainless steel pipe. All other components of Chain Clamps are made of stainless steel.

Universal Chain Clamp Kit (Less Chain)

Model	Pipe Size Range (in / mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Type of Chain Required	Chain Length Required (Ft. / M)	Estimated Shipping Weight (lbs / kg)
D2250-KIT	1-8 / 25-203	20	40	Note: 1	3 / 1	19 / 9
D2249-KIT	4-16 / 102-406	20	40	Note: 2	5 / 1.5	59 / 27

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

Does not include storage box.

Clamp Includes: main block, fine adjustment, level and support, universal jackscrew jackbars as required, and operating manual.

Note: 1. 40-2: riveted nickel plated roller or 40-2: riveted stainless steel roller chain (ANSI#: 40-2R or equal)

Note: 2. 60-2: riveted nickel plated roller or 60-2: riveted stainless steel roller chain (ANSI#: 60-2R or equal)

WARNINGS

The clamp should never be used as the sole support for the pipe, nor should it ever be used to lift the pipe.

Do not exceed pipe size range listed without first contacting the Mathey Dearman sales department.

Do not use any type of chain other than those listed below without first contacting Mathey Dearman sales department.

Use of chain not supplied with clamp by Mathey Dearman will void the warranty of the clamp.

Double Chain Clamp

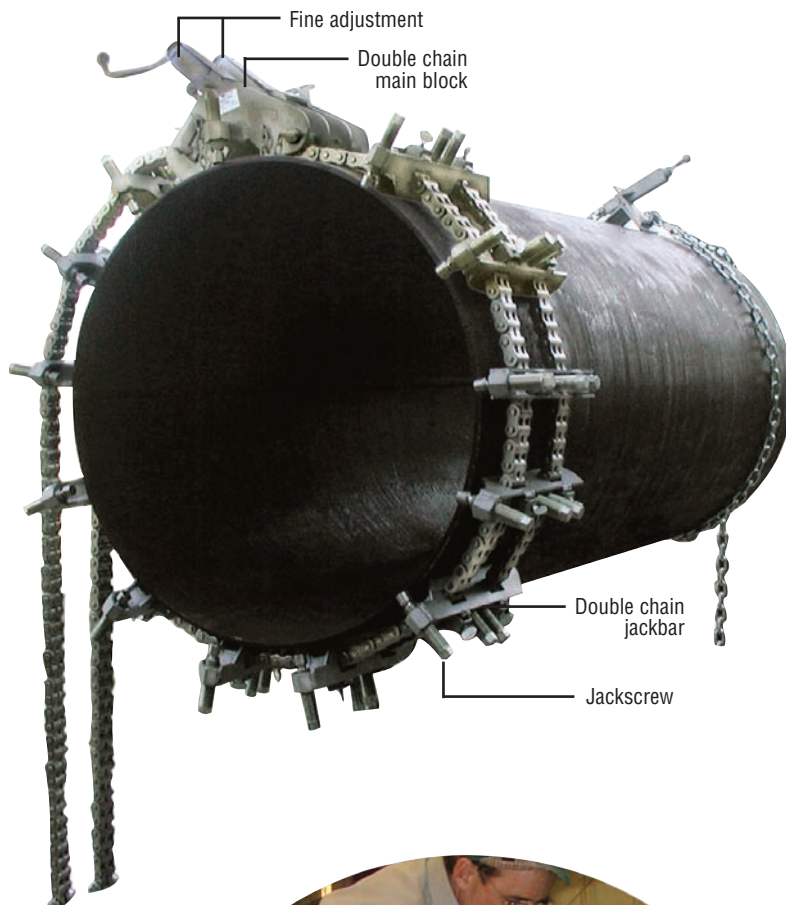
Double Chain Clamp - D251 Series

Double Chain Clamps include:

- Length of chain required for the pipe range
- Extra heavy-duty jackbars listed for the pipe range
- Main block
- Two (2) fine adjustments
- D251-1036, D251-1036SS, D251-1048, D251-1048SS, D251-1054 and D251-1054SS
Supplied with level and support device (larger clamps supplied with come-a-long)
- Jackscrew wrench
- Operating instructions

Optional:

- Carbon or stainless steel spacing screws (optional)



The **Double Chain Clamp** is a heavy-duty vessel clamp designed for alignment and reforming of pipes and vessels up to 20' (6M) with Schedule 80 wall thickness. Aligns Schedule 80 pipe and over when no reforming is required.

The extra heavy-duty jackbar and main block provide the brute strength to accomplish difficult reforming jobs. Models 10" to 36" thru 10" to 54" come with level and support device and all other models come with cable hoist. The Double Chain Clamp is available in steel and stainless steel models and is shipped in a wooden storage crate.

- **PRECISION ALIGNMENT** of large heavy wall pipe or vessels.
- **EXTREMELY TOUGH** jackbars form pipe to the desired shape.
- **ADAPTABLE**—Chain and jackbar can be added or removed for different diameters.
- **INDEPENDENT** pivoting of jackscrew pads for uneven surfaces.



Large pipe or tube shells as large as 20' (6096mm) can be aligned, reformed and welded without removal of the Double Chain Clamp, thereby saving time in the welding process.

Double Chain Clamp

Double Chain Clamp – Specifications

Part Number	Number of Main Blocks	Number of Jackbars	Aligning & Reforming	Pipe Size Range (in / mm)	Estimated Shipping Weight (lbs / kg)
D251-1036	1	9		10-36 / 254-914	220 / 100
D251-1036SS	1	9		10-48 / 254-914	220 / 100
D251-1048	1	12		10-48 / 254-1219	278 / 126
D251-1048SS	1	12		10-48 / 254-1219	278 / 126
D251-1054	1	14		10-54 / 254-1372	300 / 136
D251-1054SS	1	14		10-54 / 254-1372	300 / 136
D251-1060	1	16		10-60 / 254-1524	328 / 149
D251-1060SS	1	16		10-60 / 254-1524	328 / 149
D251-1072	1	20		10-72 / 254-1829	387 / 176
D251-1072SS	1	20		10-72 / 254-1829	387 / 176
D251-1084	1	24		10-84 / 254-2134	442 / 200
D251-1084SS	1	24		10-84 / 254-2134	442 / 200
D251-1096	2	28		10-96 / 254-2438	498 / 226
D251-1096SS	2	28		10-96 / 254-2438	498 / 226
D251-10108	2	32		10-108 / 254-2743	554 / 251
D251-10108SS	2	32		10-108 / 254-2743	554 / 251
D251-10120	2	36		10-120 / 254-3048	610 / 277
D251-10120SS	2	36		10-120 / 254-3048	610 / 277
D251-1011F	2	39		10-132 / 254-3353	660 / 299
D251-1011FSS	2	39		10-132 / 254-3353	660 / 299
D251-1012F	2	42		10-144 / 254-3715	710 / 322
D251-1012FSS	2	42		10-144 / 254-3715	710 / 322
D251-1014F	2	48		10-168 / 254-4267	810 / 367
D251-1014FSS	2	48		10-168 / 254-4267	810 / 367
D251-1016F	3	54		10-192 / 254-4877	910 / 410
D251-1016FSS	3	54		10-192 / 254-4877	910 / 410
D251-1018F	3	60		10-216 / 254-5486	1010 / 455
D251-1018FSS	3	60		10-216 / 254-5486	1010 / 455
D251-1020F	3	66		10-240 / 254-6096	1110 / 500
D251-1020FSS	3	66		10-240 / 254-6096	1110 / 500

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg per square centimeter).

SS - Indicates clamp is for stainless steel application.



Double chain jackbar

Heavy-duty double chain jackbars apply pressure where needed.

WARNINGS

The clamp should never be used as the sole support for the pipe, nor should it ever be used to lift the pipe.

Do not exceed pipe size range listed without first contacting the Mathey Dearman sales department.

Do not use any type of chain other than those listed without first contacting Mathey Dearman sales department.

Use of chain not supplied with clamp by Mathey Dearman will void the warranty of the clamp.

NOTE:

1. The jackbar of the standard Double Chain Clamp is made of carbon steel; therefore, this clamp can not be modified for stainless steel or other specialty alloy applications.

2. All double chain clamps with 16 or more jackbars include cable hoist.

3. Smaller clamps include level and support device.

Hydraulic Double Chain Clamp

Part No. D251



D251 Hydraulic closure mechanism

Optional:
Hydraulic flange spreader
kit available

Do you want a clamp with added strength?

The **Hydraulic Double Chain Clamp** has a power hydraulic tensioning mechanism incorporated into its design. The hydraulic cylinder of the hydraulic tensioning mechanism, which has a 5" (127mm) stroke, applies up to 10,000 lbs (4535kg) of tension to the standard Double Chain Clamp. Rapid and effortless tensioning can be applied to the Double Chain Clamp to close it on the pipe.

Hydraulic pressure is supplied to the cylinder by a hand pump with reservoir. The clamp is specifically designed to align pipe up to Schedule 120 and reform pipe to Schedule 80.

D251 Series Hydraulic Closure Mechanism

Model	Description	Estimated Shipping Weight (lbs / kg)
DD-580	Hydraulic closure mechanism for D251 Double Chain Clamp	43 / 20
D104-KIT	Hydraulic kit includes manual hydraulic pump, reservoir and hoses needed for operation	12 / 5

The hydraulic closure mechanism can be added to a previously purchased Double Chain Clamp.

Chain Clamp Accessories & Parts

Jackbars

All single and double jackbars and universal holder blocks are investment cast stainless steel.

Part Number	Original Chain Clamp	Original Chain Clamp Range (in / mm)	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range (in / mm)	Estimated Shipping Weight (lbs / kg)
Mini-Fit Screw Jackbar					
DXL-523	D230, D230-A	1-8 / 25-203 (Carbon Steel)	D231-LT	1-12 / 25-305 (Carbon Steel)	1 / .5
DXL-523S	D230SS, D230-ASS	1-8 / 25-203 (Carbon or Stainless Steel)	D231-LTSS	1-12 / 25-305 (Carbon or Stainless Steel)	1 / .5
Single Screw Jackbar					
DA-500S	D231, D231-SS	1-8 / 25-203 (Carbon or Stainless Steel)	D231-LT, D231-LTSS	4-20 / 102-508 (Carbon or Stainless Steel)	2 / 1
DB-500S	D232, D232SS	4-16 / 102-406 (Carbon or Stainless Steel)	D232-LT, D232-LTSS	6-36 / 152-914 (Carbon or Stainless Steel)	3 / 1.4
DC-500S	D233, D233SS, D234, D234SS	10-36 / 254-914 10-54 / 254-1372 (Carbon or Stainless Steel)			4 / 1.8
Double Screw Jackbar					
DA-600S	D250, D250SS	1-8 / 25-203 (Carbon or Stainless Steel)	D249-LT, D249-LTSS	4-20 / 102-508 (Carbon or Stainless Steel)	3 / 1.4
DB-600S	D249, D249SS	4-16 / 102-406 (Carbon or Stainless Steel)	D235-LT, D235-LTSS	6-36 / 152-914 (Carbon or Stainless Steel)	4 / 1.8
DC-600S	D235, D235SS, D236, D236SS	10-36 / 254-914 10-54 / 254-1372 (Carbon or Stainless Steel)			5 / 2.3
Universal Jackbar					
DA-800	D2250	1-8 / 25-203 (Carbon Steel)			1 / .5
DB-800	D2249	4-16 / 102-406 (Carbon Steel)			3 / 1.4
DC-800	D2235	10-36 / 254-914 (Carbon Steel)			4 / 1.8
Double Chain Jackbar					
DD-500		D251 Series Carbon Steel			8 / 3.6
DD-500S		D251 Series Stainless Steel			8 / 3.6
Add-On Jackbar					
DA-900		1 - 8 (25 - 204) Carbon Steel or Stainless Steel			3 / 1
DB-900		4-16 (102 - 406) Carbon Steel or Stainless Steel			3 / 1
DC-900		10 - 54 (254 - 1372) Carbon Steel or Stainless Steel			5 / 2
Jackbars					
DA-501	DA-500S, DB-500S	1 - 8 (25 - 204)	5/8" - 11NC x 3 1/4" lg.		.2 / .1
DA-701	DA-600S, DA-800, DA-900	4 - 16 (102 - 406)	5/8" - 11NC x 4" lg.		.25 / .11
DC-501	DC-500S, DC-600S, DC-800, DC-900, DD-500	10 - 54 (254 - 1372)	7/8" - 9NC x 4 1/2" lg.		.6 / .2
DXL-525	DXL-523		1/2" - 13	1-12 (25-305) Carbon Steel	.2 / .1
DXL-525S	DXL-523S		1/2" - 13	1-12 (25-305) Stainless Steel	.2 / .1



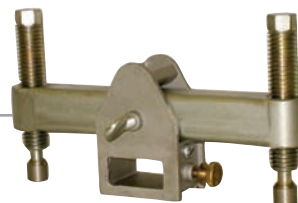
Mini-Fit single screw jackbar



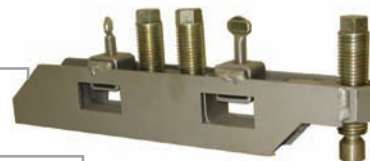
Single screw jackbar



Double screw jackbar



Universal jackbar



Double chain jackbar



Add-on jackbar



Chain Clamp Accessories & Parts (Continued)

Main Block - Fine Adjustment - Level and Support

Part Number	Single, Double and Universal Chain Clamp	Pipe Size Range (in / mm)	Estimated Shipping Weights (lbs / kg)
Main Block			
DA-100	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 / 25 - 203	3 / 1.4
DA-100LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 / 102-508	3 / 1.4
DB-100	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 / 102-406	7 / 3
DB-100LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 / 152 - 914	7 / 3
DC-100	D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS, D2235, D2235SS	10 - 36 / 254 - 914	13 / 6
DD-100	All Series 251 (Carbon Steel)	10' - 20' / 254 - 6096	25 / 11
DD-100S	All Series 251 (Carbon Steel)	10' - 20' / 254 - 6096	25 / 11
Fine Adjustment			
DA-200	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 / 25 - 203	.1 / 45
DA-200LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 / 102-508	.1 / 45
DB-200	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 / 102 - 406	3 / 1.4
DB-200LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 / 152 - 914	3 / 1.4
DC-200	D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS, D2235, D2235SS, D251 Series	10 - 36 / 254 - 914	4 / 1.8
Level and Support Device			
DA-400S	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 / 25 - 203	2 / 1
DA-400SLT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 / 102-508	2 / 1
DB-400S	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 / 102 - 406	5 / 2.3
DB-400SLT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 / 152 - 914	5 / 2.3
DC-400	D233, D234, D235, D236, D2235, D251 Series (carbon steel)	10 - 36 / 254 - 914	14 / 16.4
DC-400S	D233SS, D234SS, D235SS, D236SS, D2235SS, D251 Series (Stainless Steel)	10 - 36 / 254 - 914	14 / 5.4



The frame of the **Main Block** that contacts the pipe is made of stainless steel. The chain dog, located in the main block, contacts the roller of the chain and prevents the chain from becoming disengaged.



The **Fine Adjustment** engages in the main block and is used to tension the clamp on the pipe.



The **Level and Support Device** is used in conjunction with the chain clamp to support tees, elbows, and other fittings freeing the hands of the welder and reducing the risk of back injury.



The **Elbow Wrench** is furnished with the clamp for adjustment of the jackscrews and for attachment of the level and support device to the pipe or fitting.

Chain Clamp Accessories & Parts (Continued)

Spacing Screws

The **Spacing Screw** is used to obtain a precise weld gap between pipes or other fittings. Spacing screw assemblies are available for steel and stainless steel applications. When ordering spacing screws—one spacing screw should be ordered for each jackbar and one should be ordered for the main block.

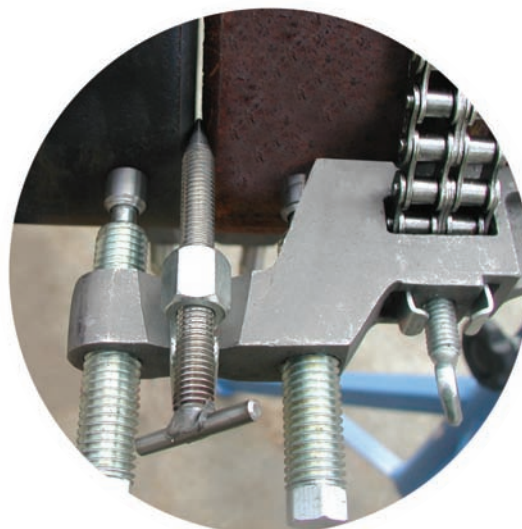
Part Number	Type	Single or Double Jackbar Chain Clamp
DA-570	Carbon Steel	D231, D249-LT, D232-LT, D250
DA-570S	Stainless Steel	D231SS, D249-LTSS, D232-LTSS, D250SS
DB-570	Carbon Steel	D232, D233-LT, D235-LT, D249
DB-570S	Stainless Steel	D232SS, D233-LTSS, D235-LT D249SS
DC-570	Carbon Steel	D233, D234, D235, D236
DC-570S	Stainless Steel	D233SS, D234SS, D235SS, D236SS

Spacing Screws Single and Double Chain Clamp Main Block and Universal Clamp Jackbar

Part Number	Type	Single and Double Main Block Universal Jackbar Chain Clamp
DA-870	Carbon Steel	D231, D232-LT, D249-LT, D250, D2250
DA-870S	Stainless Steel	D231SS, D232-LTSS, D249-LTSS, D250SS, D2250SS
DB-870	Carbon Steel	D232, D233-LT, D249, D235-LT, D2249
DB-870S	Stainless Steel	D232SS, D233-LTSS, D249SS, D235-LTSS, D2249SS
DC-870	Carbon Steel	D233, D234, D235, D236, D2235
DC-870S	Stainless Steel	D233SS, D234SS, D235SS, D236SS, D2235SS

Chain Clamp Storage Boxes

Part Number	Boxes For Models	Clamp Size (in / mm)	Dimensions (in / mm)
D861	D231, D231S	1-8" (25-203) Single Jackscrew	16 x 7 x 7.5 / 406 x 178 x 191
	D232-LT, D232-LTSS	4"-20" (102-508) Light Single Jackscrew	
D862	D232, D232SS, D249, D249SS,	4" -16" (102-406) Single and Double Jackscrew	29 x 10 x 13 3/4 / 737 x 2543 x 349
	D2235, D2235SS, D2249, D2249SS	4" -16" (102-406) and 10-36" (254-914) Universal Jackscrew	
	D233, D233S, D235, D235SS	10-36" (254-914) and Single and Double Jackscrew	
	D234, D234SS, D236, D236SS	10"-54" (254-1372) Single and Double Jackscrew	
	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6"-36" (152-914) Light Single and Double Jackscrew	
D863	D250, D250S,	1-8" (25-203) Double	20 x 8 1/2 x 8 3/4 / 508 x 216 x 222
	D2250, D2250SS	1-8" (25-203) Universal Jackscrew	
	D249-LT, D249-LTSS	4"-16" (104-406) Light Double	



The spacing screw, when mounted to the jackbar of the clamp, permits the welder to obtain and hold a precise weld gap while adjusting the pipe or fitting.



Main block (universal jackbar) spacing screw assembly

Jackbar spacing screw assembly

Storage Box

Durable chain clamp steel storage boxes are available in three (3) sizes. The storage boxes come standard with lifting handle(s), and lockable hasp with a powder coated finish.



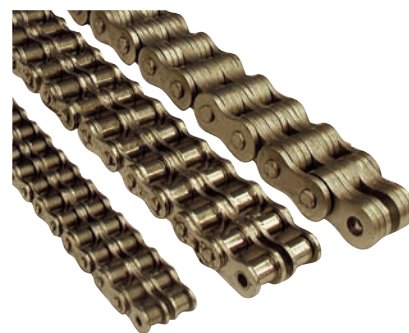
Chain Clamp Accessories & Parts (Continued)

Chain and Connecting Links

All carbon roller chain is nickel-plated. Use only chain and connecting links purchased from Mathey Dearman.

Chain and Connecting Links

Part Number	Original Chain Clamp	Standard Chain Clamp Range (in / mm)	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range (in / mm)
Chain				
DA-300	D230, D230-A, D231, D250, D2250	1-8 / 25-203 (Carbon Steel)	D-231LT, D249LT	4-20 / 102-508 (Carbon Steel)
DA-300S	D250SS, D2250SS, D230SS, D230-ASS, D231SS	1-8 / 25-203 (Stainless Steel)	D231-LTSS, D249-LTSS	4-20 / 102-508 (Stainless Steel)
DB-300	D232, D249, D2249	4-16 / 102-406 (Carbon Steel)	D232-LT, D235-LT	6-36 / 152-914 (Carbon Steel)
DB-300S	D2249SS, D232SS, D249SS	4-16 / 102-406 (Stainless Steel)	D232-LTSS, D235-LTSS	6-36 / 152-914 (Stainless Steel)
DC-300	D233, D234, D235, D236, D2235, D251-Series (Carbon Steel)	10-36 / 254-914 10-54 / 254-1372 (Carbon Steel)		
DC-300S	D233SS, D234SS, D235SS, D236SS, D2235SS, D251-Series (Stainless Steel)	10-36 / 254-914 10-54 / 254-1372 (Stainless Steel)		
Connecting Link				
DA-301	D230, D230-A, D231, D250, D2250, D2250SS, D213SS	1-8 / 25-203 (Carbon Steel)	D-231LT, D232-LT, D232LTSS, D249-LT	4-20 / 102-508 (Carbon Steel)
DA-301S	D230SS, D250SS	1-8 / 25-203 (Stainless Steel)	D231-LTSS, D249-LTSS	4-20 / 102-508 (Stainless Steel)
DB-301	D232, D233SS, D249SS, D2249SS	4-16 / 102-406 (Carbon Steel)	D232-LT, D233-LT, D235-LT	6-36 / 152-914 (Carbon Steel)
DB-301S	D232SS, D2249SS, D249SS	4-16 / 102-406 (Stainless Steel)	D235-LTSS	6-36 / 152-914 (Stainless Steel)
DC-301	D233, D234, D235, D236, D2235, D251-Series (Carbon Steel)	10-36 / 254-914 10-54 / 254-1372 (Carbon Steel)		
DC-301SS	D2235SS, D233SS, D234SS, D235SS, D236SS,	10-36 / 254-914 10-54 / 254-1372 (Stainless Steel)		



Three (3) different sizes of roller chain are used in the Mathey Dearman single and double jackscrew, universal and Dearman light chain clamps to insure the maximum amount of safety is provided for the welder. The roller chain is available in stainless steel and carbon steel.



Connecting links

How to determine length of chain to extend the range of a chain clamp.

- Step 1:** Customer has D249 [range: 4"-16" (102mm-405mm)]
Length of chain is: 60" / 1524mm
- Step 2:** Multiply the diameter of the pipe that you wish to align by 3.1416
(i.e.: 20" / 506mm pipe diameter x 3.1416) = 62.8" / 1595mm
- Step 3:** Subtract the length of chain noted on the D249 clamp used in Step 2.
$$\frac{60"}{2.8"} = 21.4$$

2.8" / .71mm
- Step 4:** Roundup the amount of chain needed to the next whole foot.
1' / 305mm of chain required

NOTE: A connecting link is needed to join chain ends together. A jackbar should be added for each foot of chain added to the chain clamp.

WARNINGS

The reforming capability of the chain clamp can be severely affected if the range of the chain is extended beyond the working range. Mathey Dearman will NOT WARRANTY OR ACCEPT LIABILITY for any clamp that is extended beyond the normal operating range of the clamp.

Use only chain purchased from Mathey Dearman as some manufacturers' roller chain can not be used with the Mathey Dearman chain clamp.

Use of chain not supplied by Mathey Dearman will void the warranty of the clamp.

Rim Clamps - For TOUGH REFORMING JOBS!

Rim Clamps include:

- Clamp frame
- Required number of jackscrews per pipe and clamp size
- Flip-Up jackbars for mating pipe
- Stabilizer bars
- Level and support device attachment point
- Clamp wrench
- Parts and operating manual

Jackscrews apply pressure on specific high points to precisely reform and align the pipe or shells. Ideal for applications that require 100% weld and grind without releasing clamping pressure to prohibit cracking of partially completed welds.

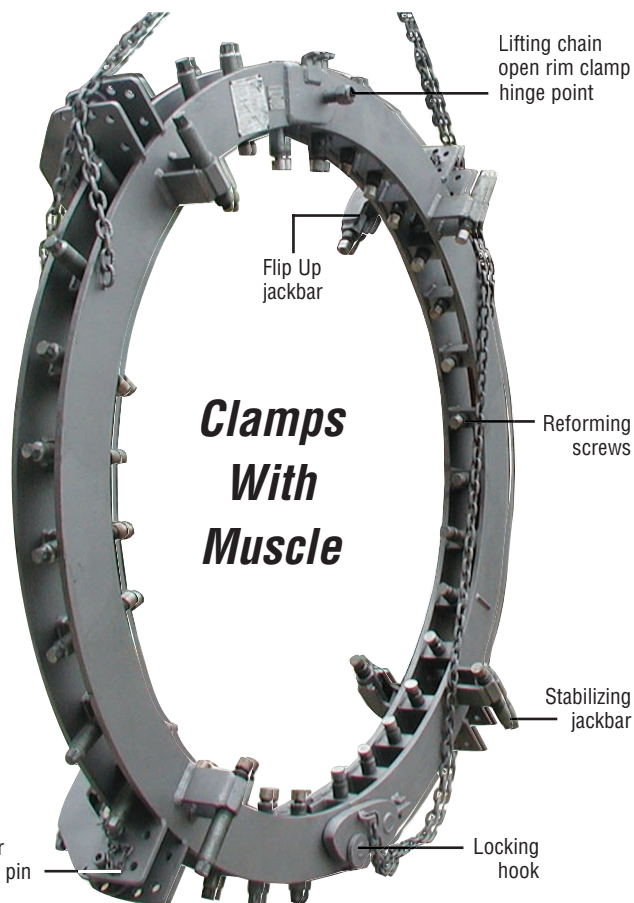
The clamp can also be used to round the pipe or shell on which it is placed. All surfaces of the Rim Clamp that contact the pipe are made of stainless steel so that this clamp can be used for nuclear and other similar applications.

The Clamp will reform 45,000psi tensile strength pipes up to Schedule 80, with out-of-round conditions up to 2" (51mm).

(Please refer to Commercial Pipe Sizes and Wall Thickness Chart - pg. 87.)



The 14" to 16" (356mm to 406mm) and larger Rim Clamp closes over the pipe automatically, minimizing risk of injury to the operator.



Clamps With Muscle

- **EXTREMELY ACCURATE** fit-up on large diameter pipe or shells.
- **Hi-Lo**—Handles out-of-round conditions up to 2" (51mm).
- **EASY ALIGNMENT AND REFORMING**—Pressure can be applied to the high point of the pipe or vessel to reform it to the required shape.
- **VERSATILE**—The clamp can be used for steel or stainless steel applications.

Clamp Type	Pipe Tensile Strength		Material	Pipe Diameter				
	PSI	Mpa		4" - 12"	14" - 24"	32" - 48"	50" - 60"	62" - 72"
STD	45,000	310	X45	1/2"	3/4"	1"	1 1/8"	1 1/4"
Pipe Wall Thickness								

All calculations based on a temperature of 72°F (22°C).

WARNING: Contact Mathey Dearman when pipes are clad with materials such as Inconel or Titanium. As temperature decreases below 0°F (-18°C), the ability of the clamp to reform the pipe wall listed will decrease sharply.

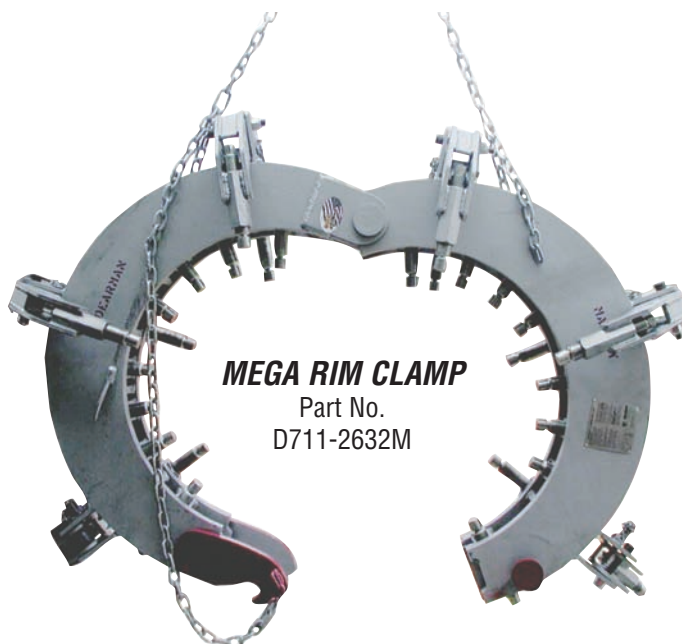
Mega Rim Clamp— High Tensile Strength Reforming

The Mega Rim Clamp aligns and reforms high tensile strength X65, X70 and X80 pipes with wall thicknesses up to 7/8" (22mm) (see chart below for tensile strengths). The clamp reforms pipe out-of-round condition up to 2" (51mm), gaining its strength from heavy-duty oval shaped side plates, latching mechanism, and flip-up jackbars for mating pipes.

The hinged flip-up jackbars, placed with precision on the clamp, can be rotated away from the primary pipe for insertion of the mating pipe, valve or fitting to facilitate welding and grinding. The independent pivoting pads of the jackscrews allow for uneven surfaces on the pipe. To avoid risk of contamination, all surfaces of the Mega Rim Clamp that come in contact with the pipe are made of stainless steel.



The jackbar rotates out of position for alignment, welding and grinding without removal of the clamp.



- **EXTREME REFORMING CAPABILITY**—Reforms high tensile strength pipes.
- **"Hi-Lo"**—Can be used on pipe out-of-round condition up to a 2" (51mm) with out-of-round condition.
- **VERSATILE**—Engineered based on actual customer applications.

Please provide us with the following information in order to specify the Mega Rim Clamp for your application.

1. Pipe diameter (inches or millimeters) _____
2. Pipe wall thickness (inches or millimeters) _____
3. Pipe tensile strength or type material _____
4. Horizontal or vertical application _____
5. Ambient temperature _____

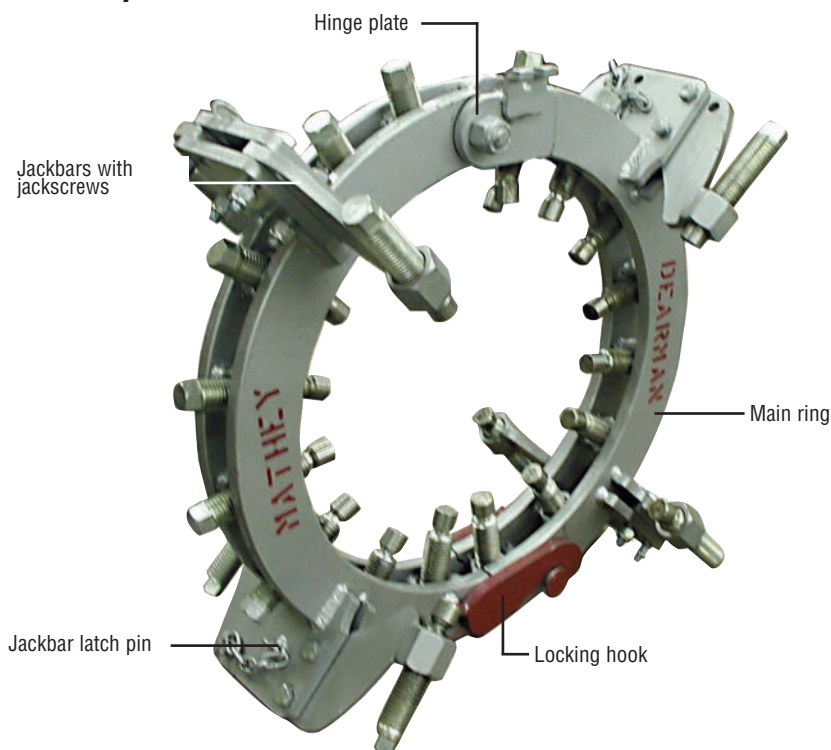
MEGA RIM CLAMP

Clamp Type	Pipe Tensile Strength		Material	Pipe Diameter				
	PSI	Mpa		4" - 12"	14" - 24"	32" - 48"	50" - 60"	62" - 72"
MEGA	45,000	310	X45	1/2"	3/4"	1 1/8"	1 1/4"	1 3/8"
MEGA	65,000	448	X65	7/16"	5/8"	1"	1 1/8"	1 3/8"
MEGA	70,000	482	X70	3/8"	1/2"	7/8"	1"	1 1/4"
MEGA	80,000	551	X80	3/8"	1/2"	3/4"	7/8"	1 1/8"
Pipe Wall Thickness								

All calculations based on a temperature of 72°F (2°C).

WARNING: Contact Mathey Dearman with pipes clad with materials such as Inconel or Titanium. As temperature decreases below 0°F (-18°C), the ability of the clamp to reform the pipe wall listed will decrease sharply.

Accessories for Rim Clamp and Mega Rim Clamp



Assembly / Parts Description	Rim Clamp Size (in / mm)
Jackbars	
DR-300	4 - 14 / 102 - 356
DR-700	14 - 72 / 356 - 1829
Jackscrews	
DC-501	4 - 14 / 102 - 356
DR-500	14 - 72 / 356 - 1829
Wrenches	
D900-002 3/4" / 19mm	4 - 14 / 102 - 356
D900-003M 7/8" / 22.2mm	14 - 72 / 356 - 1829
Level and Support Device	
DA-400S*	4 - 8 / 102 - 203
DB-400S*	4 - 20 / 102 - 508
DC-400	18 - 72 / 457-1829
DC-400S*	18 - 72 / 457 - 1829

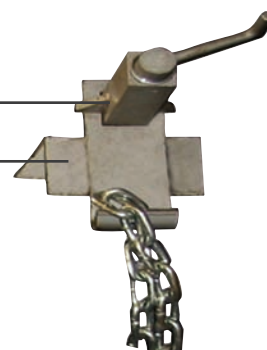
*Stainless steel

Hold Down Clamp



Fine adjustment

Hold down clamp



Hold Down Clamp is being installed to stop pipe from twisting during the installation of a fitting.

Hold Down Clamps safely secure the pipe to a jackstand or table for the fit-up of tees, elbows, flanges and other fittings.

For some applications the Hold Down Clamp is used in conjunction with the level and support device to hold the pipe or fitting in place during the alignment and welding process.

Light weight, easy to install—the D244 Hold Down Clamp has a range of 2"-16" (51-406mm) with an 800 lb working load, and the D245 Hold Down Clamp has a range of 10"-48" (254mm-1219mm) with a 1,300 lb working load.

The crank shaft mechanism takes up the slack in the chain to hold the pipe safely and securely with the chain being placed at the base of the V-Head of the jackstand, and not through the legs.

Part Number	Pipe Diameter (in / mm)
D244	2-16 / 51-406
D245	10-48 / 254-1219



The Hold Down Clamp holds the pipe in position for cutting or fit-up of pipe or fittings such as flanges, tees, elbows or valves.

Cage Clamps



In the field, rapid alignment can be achieved with the hand lever cage clamp.

Cage Clamps are available in hand lever, ratchet, and hydraulic model in either a tack or no-tack types. Cage clamps are available in several types and models for pipes 2" to 60" (51mm to 1524mm).

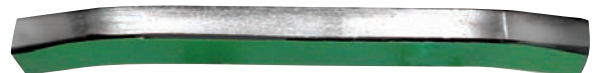
The cage clamp is not designed to reform the pipe. Each size clamp can be used for one diameter of pipe only. If the O.D. of the pipe varies more than $\pm 3/16$ from the clamp diameter, the pipes will not align accurately.

- **QUICK**—The cage clamp is the way to go when aligning only one (1) pipe.
- **EFFICIENCY**—The cage clamp works efficiently for aligning the pipe when there is no reforming required.

Models of Cage Clamp Cross Bars



Straight cross bars of the tack-type clamp have flared ends so pipes can be moved easily into position and clamped. When the pipe has been tack welded, the clamp is removed from the pipe and the weld is completed.



Tack and no-tack cross bars are available in stainless steel for stainless and other specialty applications.



No-tack cross bars are arched to permit a full circle weld to be completed without removal of the clamp. The no-tack clamp is used to make the welding more efficient and to insure a quality weld.



Cage Clamps

Hand-Lever Cage Clamp

Hand Lever Tack Model	Hand Lever No-Tack Model	Pipe Size Range (in / mm)
01.0500.001	-----	2 / 51
01.0500.002	-----	3 / 76
01.0500.003	01.0500.N03	3.5 / 89
01.0500.004	01.0500.N04	4 / 102
01.0500.005	01.0500.N05	5 / 127
01.0500.006	01.0500.N06	6 / 152
01.0500.008	01.0500.N08	8 / 203
01.0500.010	01.0500.N10	10 / 254
01.0500.012	01.0500.N12	12 / 305
01.0500.014	01.0500.N14	14 / 356
01.0500.016	01.0500.N16	16 / 406
01.0500.018	01.0500.N18	18 / 457
01.0500.020	01.0500.N20	20 / 508
01.0500.022	01.0500.N22	22 / 559
01.0500.024	01.0500.N24	24 / 610
01.0500.026	01.0500.N26	26 / 660
01.0500.028	01.0500.N28	28 / 711
01.0500.030	01.0500.N30	30 / 762
01.0500.032	01.0500.N32	32 / 812
01.0500.034	01.0500.N34	34 / 864
01.0500.036	01.0500.N36	36 / 914
01.0500.038	01.0500.N38	38 / 965
01.0500.040	01.0500.N40	40 / 1016
01.0500.042	01.0500.N42	42 / 1067
01.0500.048	01.0500.N48	48 / 1219
01.0500.054	01.0500.N54	54 / 1372
01.0500.060	01.0500.N60	60 / 1524

Clamps with stainless steel contact point or for odd-size pipe available on request.



Cage Clamps

Ratchet Cage Clamp



Ratchet handle
Part No.: 01.0500.R01
(Handle must be ordered separately)

Ratchet Cage Clamp

The **Ratchet Cage Clamp** provides the extra force needed to align large pipe diameters with its ratchet closure mechanism. The clamp is available for 14" to 60" (356mm to 1524mm) pipe. A special 1" ratchet wrench fits all clamp sizes.



Pipes, regardless of size, can be effortlessly aligned for welding with a Ratchet Cage Clamp.

Ratchet Tack Model	Ratchet No-Tack Model	Pipe Size Range (in / mm)
01.0500.R06	-	6 / 152
01.0500.R08	-	8 / 203
01.0500.R10	-	10 / 254
01.0500.R12	01.0500.RN12	12 / 305
01.0500.R14	01.0500.RN14	14 / 356
01.0500.R16	01.0500.RN16	16 / 406
01.0500.R18	01.0500.RN18	18 / 457
01.0500.R20	01.0500.RN20	20 / 508
01.0500.R22	01.0500.RN22	22 / 559
01.0500.R24	01.0500.RN24	24 / 610
01.0500.R26	01.0500.RN26	26 / 660
01.0500.R28	01.0500.RN28	28 / 711
01.0500.R30	01.0500.RN30	30 / 762
01.0500.R32	01.0500.RN32	32 / 812
01.0500.R34	01.0500.RN34	34 / 864
01.0500.R36	01.0500.RN36	36 / 914
01.0500.R38	01.0500.RN38	38 / 965
01.0500.R40	01.0500.RN40	40 / 1016
01.0500.R42	01.0500.RN42	42 / 1067
01.0500.R48	01.0500.RN48	48 / 1219
01.0500.R54	01.0500.RN54	54 / 1372
01.0500.R60	01.0500.RN60	60 / 1524

Cage Clamp

Hydraulic Cage Clamp

The **Hydraulic Cage Clamp** produces the extra strength necessary for aligning large pipe diameters. Pipes can be effortlessly aligned due to the design of the Hydraulic Closure

Mechanism. The hydraulic closure mechanism also permits the rapid release of the clamp from the pipe. The clamp is available for 16" to 60" (406mm to 1524mm) pipe.

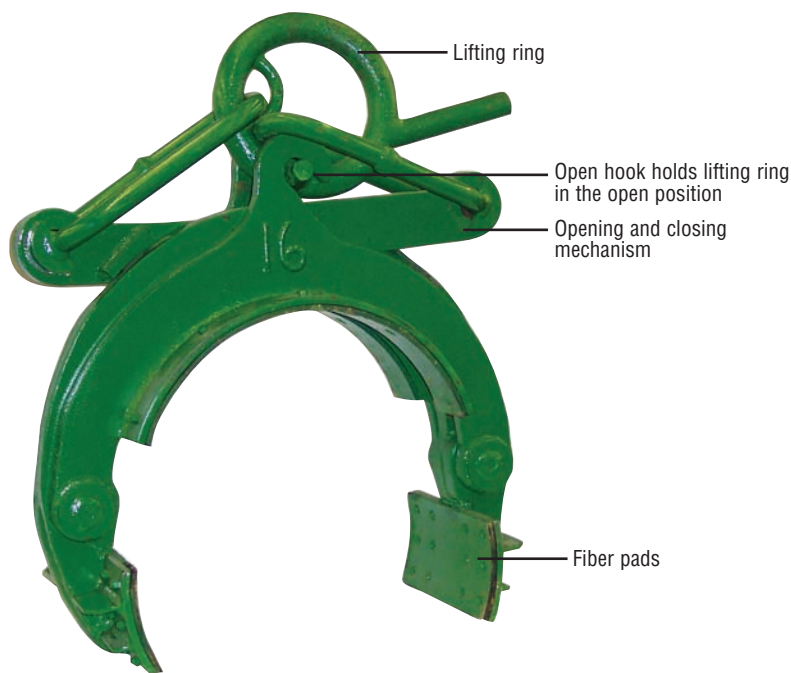


Hydraulic Cage Clamps permit rapid pipe alignment and quick release of the clamp from the pipe after welding.



Hydraulic Tack Model	Hydraulic No-Tack Model	Pipe Size Range (in / mm)
01.0500.H16	01.0500.HN16	16 / 406
01.0500.H18	01.0500.HN18	18 / 457
01.0500.H20	01.0500.HN20	20 / 508
01.0500.H22	01.0500.HN22	22 / 559
01.0500.H24	01.0500.HN24	24 / 610
01.0500.H26	01.0500.HN26	26 / 660
01.0500.H28	01.0500.HN28	28 / 711
01.0500.H30	01.0500.HN30	30 / 762
01.0500.H32	01.0500.HN32	32 / 813
01.0500.H34	01.0500.HN34	34 / 864
01.0500.H36	01.0500.HN36	36 / 914
01.0500.H38	01.0500.HN38	38 / 965
01.0500.H40	01.0500.HN40	40 / 1016
01.0500.H42	01.0500.HN42	42 / 1067
01.0500.H48	01.0500.HN48	48 / 1219
01.0500.H54	01.0500.HN54	54 / 1372
01.0500.H60	01.0500.HN60	60 / 1524
01.0500.H00	01.0500.H00	Hydraulic Jack

Pipe Lifting Tong



The **Automatic Release Pipe Lifting Tong** conveniently grasps the pipe to move it into the trench or within the pipe yard. The lifting ring closes the clamp securely. The pads of the pipe tong are made of rubber and cotton to

avoid contamination of stainless and other specialty alloys. The tongs are available for 2" to 36" (51mm to 914mm) steel, stainless steel and other specialty alloy pipes and fittings.



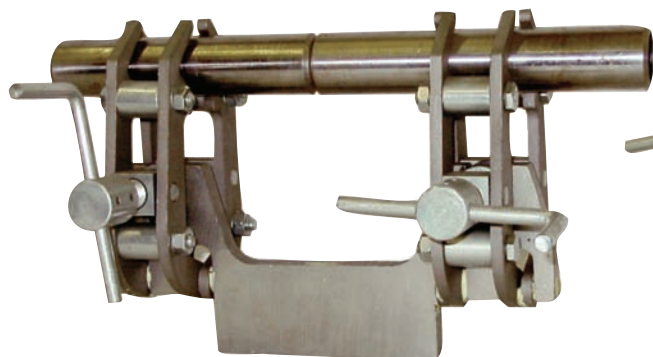
The fiber pad of the automatic pipe lifting tong allows the pipe to be firmly grasped, safely lifted and lowered into the trench.

Model Number	Pipe Size (in / mm)	Max. Capacity (lbs / kg)
01.0788.002	2 / 51	2000 / 900
01.0788.003	3 / 76	2000 / 900
01.0788.004	4 / 102	2500 / 1125
01.0788.006	6 / 152	3000 / 1350
01.0788.008	8 / 203	3500 / 1575
01.0788.010	10 / 254	4000 / 1800
01.0788.012	12 / 305	4000 / 1800
01.0788.014	14 / 356	4000 / 1800
01.0788.016	16 / 406	4000 / 1800
01.0788.018	18 / 457	4500 / 2025
01.0788.020	20 / 508	5000 / 2250
01.0788.022	22 / 559	5000 / 2250
01.0788.024	24 / 610	5000 / 2250
01.0788.026	26 / 660	5500 / 2475
01.0788.030	30 / 762	6000 / 2700
01.0788.032	32 / 813	6500 / 2925
01.0788.034	34 / 864	7500 / 3375
01.0788.036	36 / 914	10000 / 4500

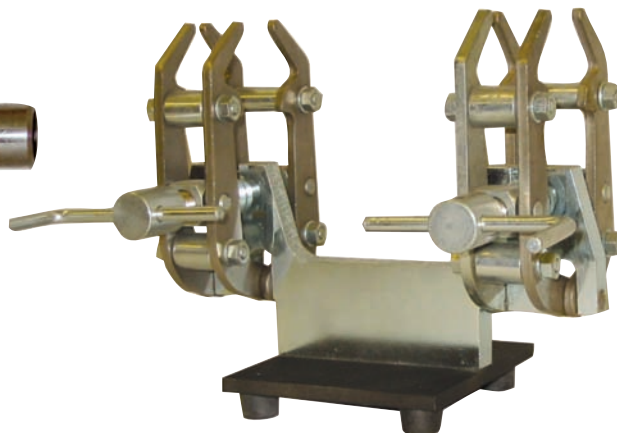
Small Diameter Clamps

Accu-Fit Clamp

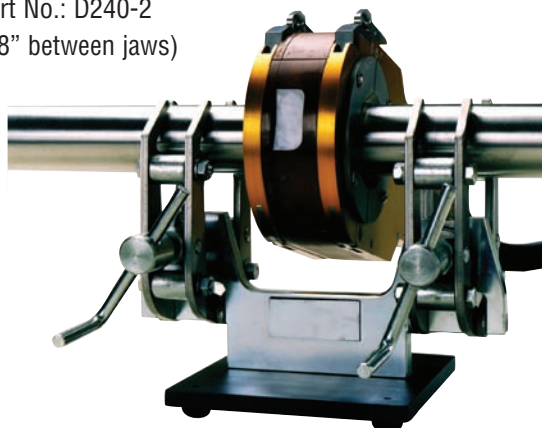
CE Approved



Accu-Fit aligning pipe
Part No.: D240-2
(4 7/8" between jaws)



Accu-Fit
Part No.: D240
(2 7/8" between jaws)
(shown with Accu-fit Stand
Part No.: D240-ST)

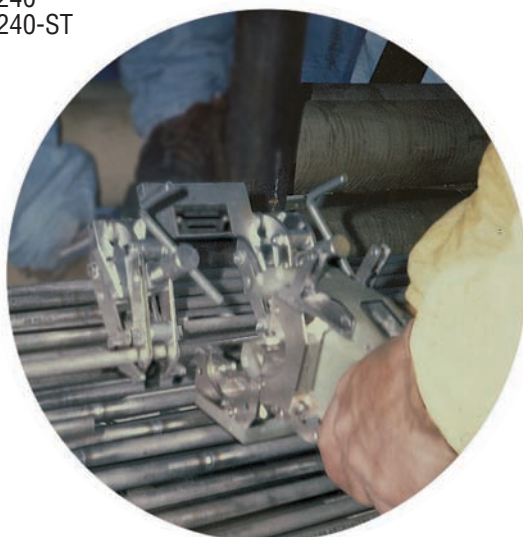


Orbital welder on Accu-Fit
with Accu-Fit stand
Part No.: D240
Part No.: D240-ST

No clamp makes a cleaner and more precise alignment of small diameter thin-wall pipes and tubes than the **Accu-Fit Clamp**. Made of high-purity stainless steel, the clamp aligns thin wall tubes and fittings so that the welder can complete flawless welds.

The jaws of the clamp work independently of each other so pipes or tubes can be aligned concentrically to each other regardless of diameter. The clamp offers sufficient clearance for most orbital-welding heads. The clamp is ideal for GTAW welding; also useful for GMAW and other types of welding.

- ACCURATELY ALIGNS pipes for orbital welding.
- CLEARANCE between jaws for most orbital welders.
- CONTAMINATION—High-purity stainless steel for the alignment of stainless steel and other specialty alloys.

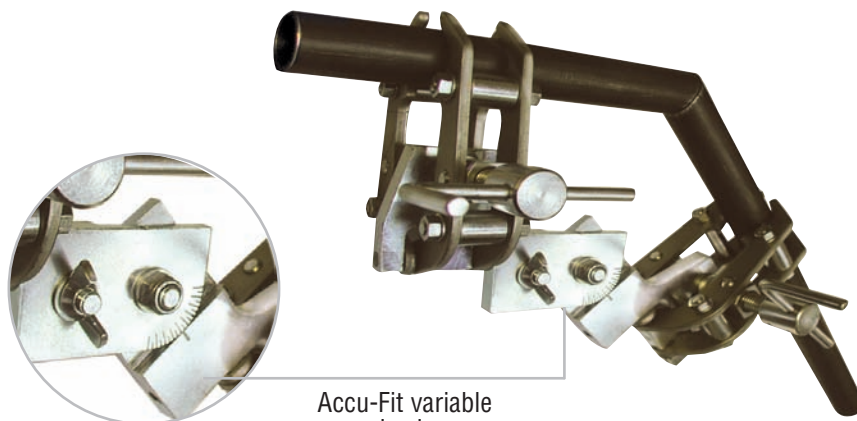


The Accu-Fit Clamp is great for holding the inside diameters of stainless steel tubes in alignment for orbital welding in a chemical or food processing plant.

Small Diameter Clamps

Angler Clamp

CE Approved



Accu-Fit variable
angle clamp
Part No.: D240-RA

Angler has all of the sensational features of the **Accu-Fit** plus the ability to align small diameter thin wall pipe and tubes at angles up to 90 degrees. Degree indicator, located on the base of the clamp, is graduated in 5 degree increments. The Angler aligns thin wall tubes and fittings 3/8" to 2 3/4" (9 to 70mm) in diameter.

The Accu-Fit stand may be used to stabilize the clamp when the angle of clamping is set on zero (0).

NOTE: To insure accurate aligning, always check with a Mathey Dearman Protractor. (See page 78.)

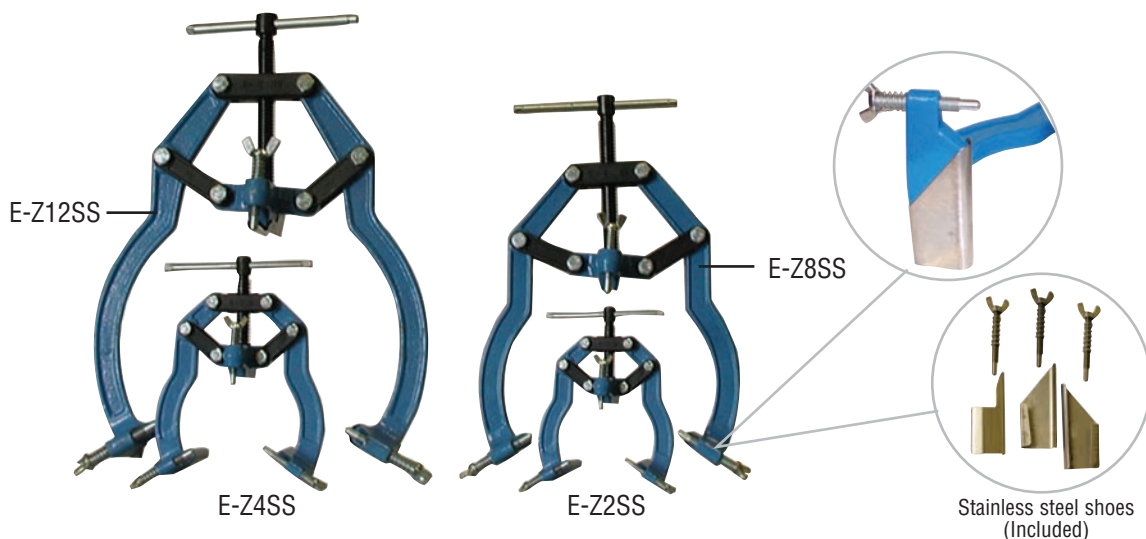


The Accu-Fit Angler allows tubing to be aligned and held in position for welding at any angle up to 90 degrees included.

Part Number	Pipe Size Range (in / mm)	Distance between Jaws (in / mm)	Distance from Base to Center of Jaws (in / mm)
D240 (Stainless Steel)	3/8-2 3/4 / 9.5-70	2 7/8 / 73	3 9/16 / 90.5
D240-RA (Stainless Steel)	3/8-2 3/4 / 9.5-70	2 7/8 / 73	3 9/16 / 90.5
D240-2 (Stainless Steel)	2-4 1/2 / 51-114	4 7/8 / 121	5 1/4 / 133
Accu-Fit Stands			
D240-ST	Stand for D240		
D240-2-ST	Stand for D240-2		

Small Diameter Clamps

EZ-Fit Portable Clamps



EZ

-Fit clamps were specifically designed for the welder who needs to align but not reform the pipe. The clamp is ideal for a wide range of small diameter pipe and tubing applications.

The precision-cast alloy steel clamps are designed to not flex when working on larger diameter pipe. Great for the critical alignment of pipe to pipe, pipe to elbow or pipe to tee. Stainless steel shoes and thumb screws (included with clamp) eliminate contamination risk during fit-up of stainless steel and other special alloy pipes and fittings.

- **FAST EASY SET-UP**—Clamp can be slid onto the end of the pipe and the handle turned for fast easy alignment.
- **NO TRAINING**—Clamp requires no training to operate.
- **ADAPTABLE**—Clamp can be used on stainless steel or specialty alloy pipe or tubing.
- **“Hi-Lo”**—The wing screws are turned in or out to adjust pipe alignment.

Part Number	Pipe Size Range (in / mm)
E-Z2SS	1-2.5 / 25-64
E-Z4SS	2.5-4.5 / 64-114
E-Z8SS	5-8 / 127-203
E-Z12SS	9-12 / 229-305



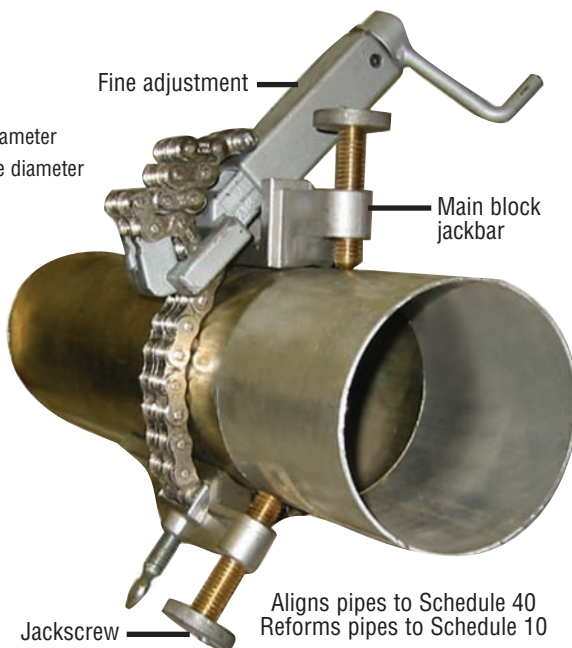
The E-Z Fit Clamp can be used to hold fittings in position for welding.

Small Diameter Clamps

Mini-Fit Chain Clamp

Mini-Fit Chain Clamps include:

- Length of chain required for the pipe diameter
- Single screw jackbars listed for the pipe diameter
- Jackbar main block
- Operating manual



Mini-Fit single screw jackbar
The end of the jackscrew is round to reduce the risk of marring the pipe.

The **Mini-Fit** is an excellent tool for aligning random lots of small tubes, pipes and fittings up to Schedule 40. The clamp is extremely lightweight, easy to set up and adjust, and is small enough to fit in the welder's toolbox, requiring no additional tools for operation.

This ingenious adaptation of our patented chain clamp design is perfect for light-duty applications. The Mini-Fit is tough enough to align 3/4" to 8" (19mm to 203mm) carbon or stainless steel pipes with a wall thickness up to Schedule 40 and will reform Schedule 10 pipe wall.

- **LIGHTWEIGHT** adaptation of standard chain clamp is perfect for light-duty applications.
- **ECONOMICAL**—Has the range of seven (7) cage clamps.
- **ACCURATELY** aligns any pipe or tube.
- Clamps available in steel, stainless steel and specialty alloys.
- Depending on pipe size, the DA-800 add-on jackbar can be added when additional pressure needs to be applied.

Model	Pipe Size Range (in / mm)	Number of Jackbars	Reforms Pipe to Schedule*	Aligns Pipe to Schedule
D230	3/4 - 8 / 19 -203	2	10	40
D230-SS	3/4 - 8 / 19 -204	2	10	40

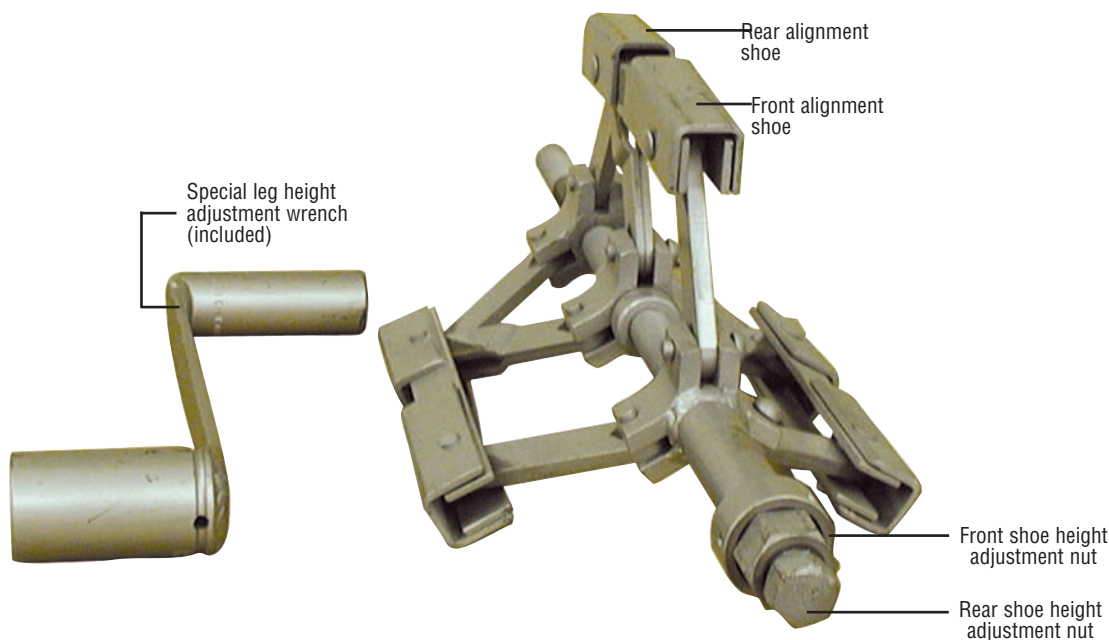
*Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3168 kg force per square centimeter).

SS - Indicates clamp is for stainless steel application.



The Mini-Fit Clamp, a miniature version of the Dearman Classic Clamp, is small enough to fit in the welder's tool box.

Internal Flange Alignment Tool



The **Internal Flange Alignment Tool** quickly and accurately aligns the ID of the flange to the ID of the pipe. The ID of the flange can vary $\pm 1/8"$ (3mm) to the ID of the pipe and still give perfect alignment.

- **ACCURATE**—Eliminates guess work when internally aligning flange.
- **RAPID ALIGNMENT**—Flanges can be aligned and squared in two minutes.
- **SAVES TIME AND MONEY**—Alignment can be done by one person regardless of flange size.

The Internal Flange Alignment Tool is designed to align 150 and 300 pound flanges. The tool is used for the alignment of the flange and should never be used as the sole support of the flange.

Part Number	Pipe Size (in / mm)
Carbon Steel	
D325	4 - 6 / 102 - 152
D326	6 - 8 / 152 - 203
D327	8 - 14 / 203 - 356
D328	16 - 24 / 406 - 610
Stainless Steel	
D325SS	4 - 6 / 102 - 152
D326SS	6 - 8 / 152 - 203
D327SS	8 - 14 / 203 - 356
D328SS	16 - 24 / 406 - 610



The 8" (203mm) Internal Flange Alignment centers the ID of the 8" (203mm) pipe to the ID of the flange for tack welding.

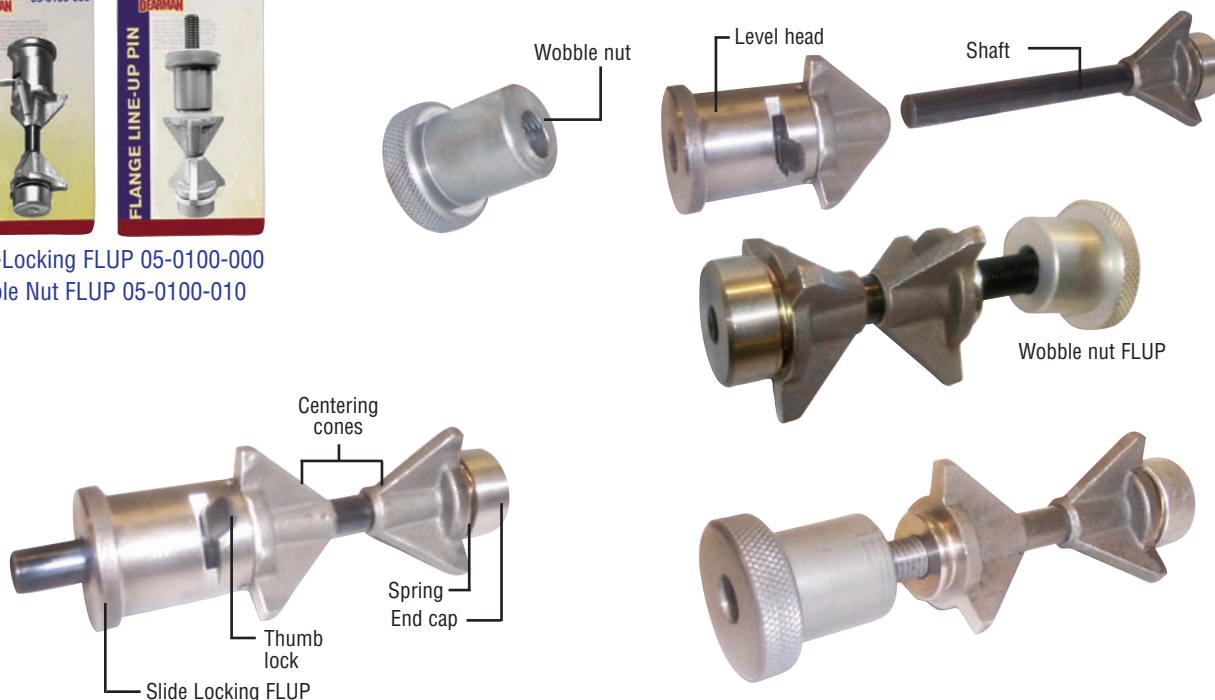
Flange Alignment Tools

Flange Line Up Pins – “FLUPs”



Slide-Locking FLUP 05-0100-000

Wobble Nut FLUP 05-0100-010



Stainless Steel Flange Line Up Pins

FLUPs aid the welder in checking or obtaining critical alignment of flange to the pipe. The Mathey Dearman Aligning Pins are multi-purpose to rapidly align carbon steel and stainless steel. Additionally, the spring and end cap allow for expansion during welding.

A simple push of the “Thumb-Lock” allows the flange pin to quickly release itself from the flange.

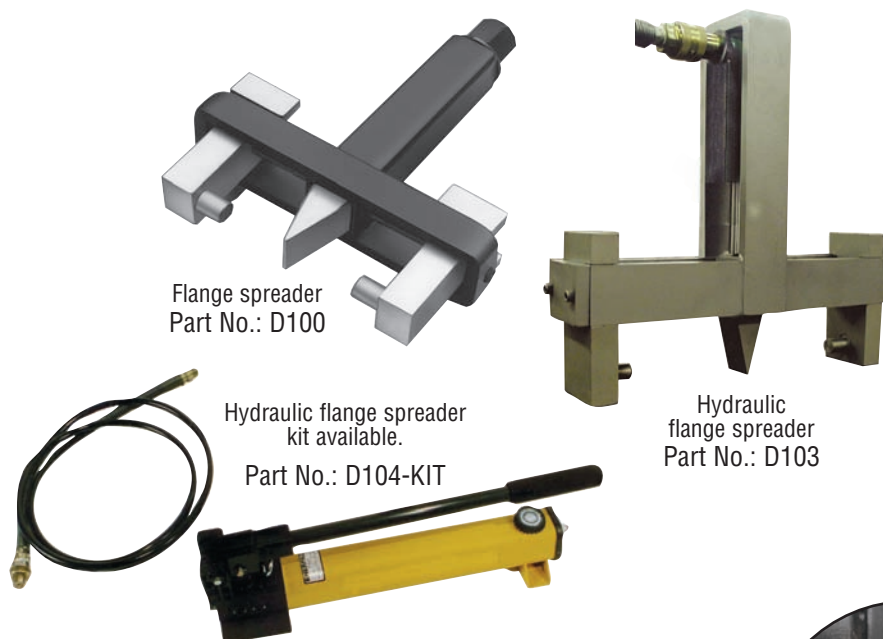
In the Wobble Nut FLUP variation, the FLUP is unscrewed 3/4 turn, tilted and released from the flange in seconds.



Quick precise flange to pipe alignment can be obtained with the stainless steel Flange Line Up Pins, which saves valuable fit-up time, eliminating costly rework due to improper alignment.

Part Number	Model / Assembly Description	Flange Hole Diameter Range
05.0100.000	Slide-Lock Locking	5/8 - 1 7/8 / 16 - 47
05.0100.010	Wobble-Nut Flup	5/8 - 1 7/8 / 16 - 47

Flange Spreader



Flange spreader
Part No.: D100

Hydraulic flange spreader
kit available.

Part No.: D104-KIT

Hydraulic
flange spreader
Part No.: D103

A pair of **Flange Spreaders** are used to gently separate flanges for the replacement of the flange gasket or to reapply sealant on the flange face.

The spreader, which attaches to the flange bolt hole, spreads the flange faces without the risk of damage to the flange sealing surfaces. The wedge action spreads the gap between flanges up to 1 1/4" (32mm) and 100 ft-pounds of torque applied to the Flange Spreader yield up to 12,000 lbs of spreading force.

Hydraulic Flange Spreaders are available for 2"-36" (51-914mm) 150-600 pound (68-272 kg) flanges. The Hydraulic Kit, attached to the Hydraulic Flange Spreader, effortlessly separates the flanges.

- **NO RISK**—The Flange Spreader greatly reduces the risk of damage to the flange face.
- **SAFETY**—Eliminates the need for wedges or hammers.

Part Number	Style	Flange Size (in / mm)	Flange Rating (PSI)
D100	Mechanical	2-12 / 51-305	Up to 300
D103	Hydraulic	2-12 / 51-305	Up to 300
D101	Hydraulic	12-24 / 305-610	150 - 600
D102	Hydraulic	26-36 / 660-914	150 - 600
D104-KIT	Hydraulic Kit includes pump with reservoir, hoses and quick disconnects.		

NOTE: Flange Spreaders are sold individually. Most applications require two (2) spreaders.

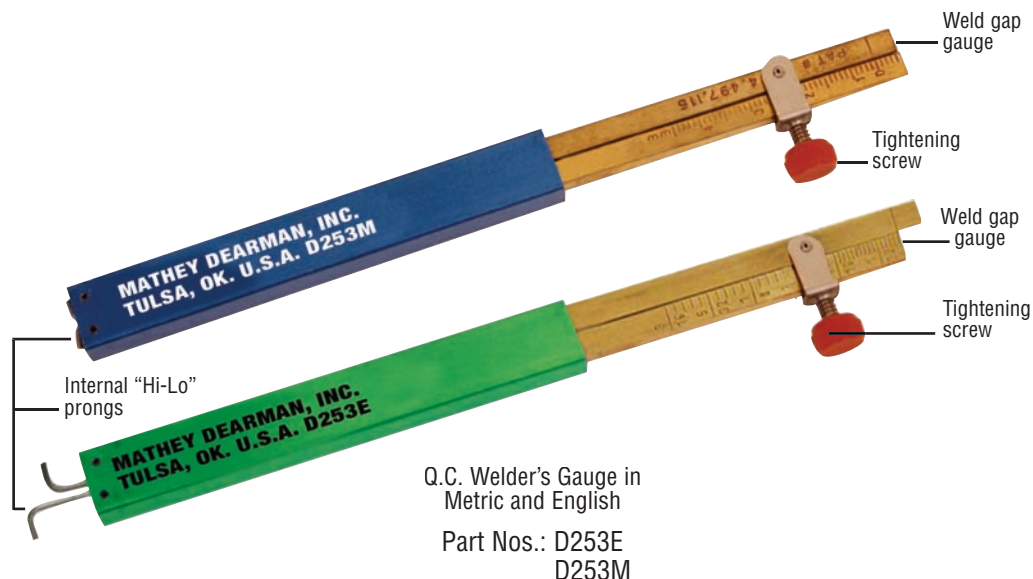


A pair of Flange Spreaders swiftly separates the flanges up to 1 1/4" (32mm) apart without damage to the flange face.

Quality Control (Q.C.) Welder's Gauge



Part Nos.: D253E
D253M



The **Q.C. Welder's Gauge** rapidly and accurately measures pipe "Hi-Lo" and plate mismatch before and after welding to minimize weld rejections.

The gauge is available in both English and Metric models.

Part Number	Description
D253E	English Q.C. Welder's Gauge
D253M	Metric Q.C. Welder's Gauge
BOX	
D253E-BOX	BOX - English
D253M-BOX	BOX - Metric
Packaged - ten (10) per box	



Purchase singly, or in boxes of ten (10) each.



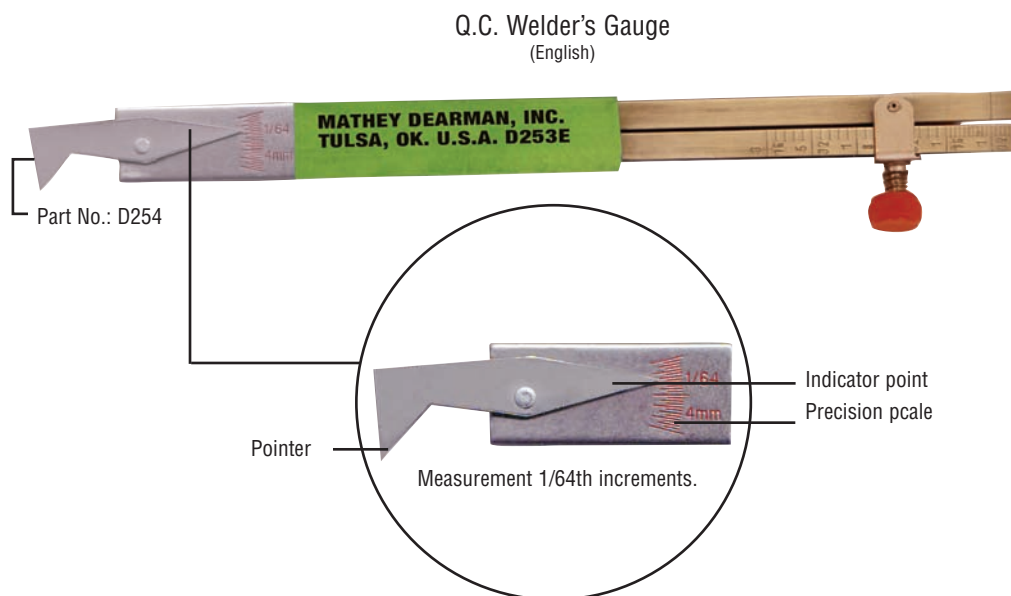
Pipe to pipe, pipe to flange or pipe to elbow "Hi-Lo" and weld gap can be accurately checked and adjusted to avoid rejection of the weld joint.

Pit Depth Gauge

For use with the Quality Control
(Q.C.) Welder's Gauge



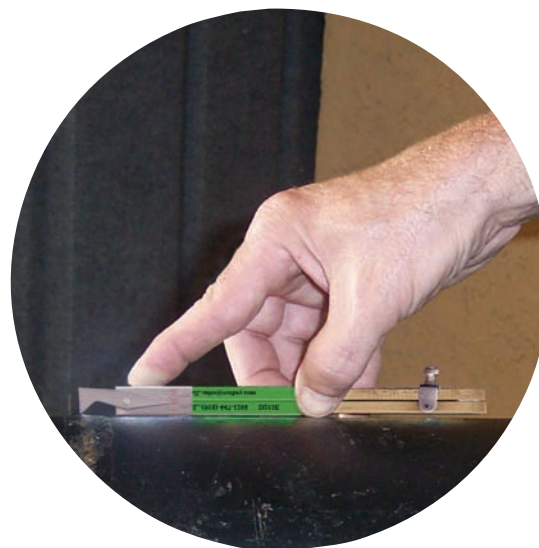
Part No.: D254



The **Pit Depth Gauge** measures depth of pitting, weld undercut, pipe outside diameter "Hi-Lo", weld height.

The stainless steel pit depth gauge mounts on the end of the Q.C. Welder's Gauge housing and reads in both English and Metric dimensions. The Pit Depth Gauge is sold separately from the Quality Control (Q.C.) Welder's Gauge.

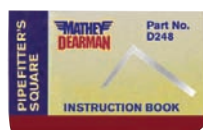
- **PRECISE**—Measurement as small as 1/64" (.4mm) can be taken with gauge.
- **EASY TO USE**—Simply slide the Pit Depth Gauge over the Q.C. Gauge and take a reading.



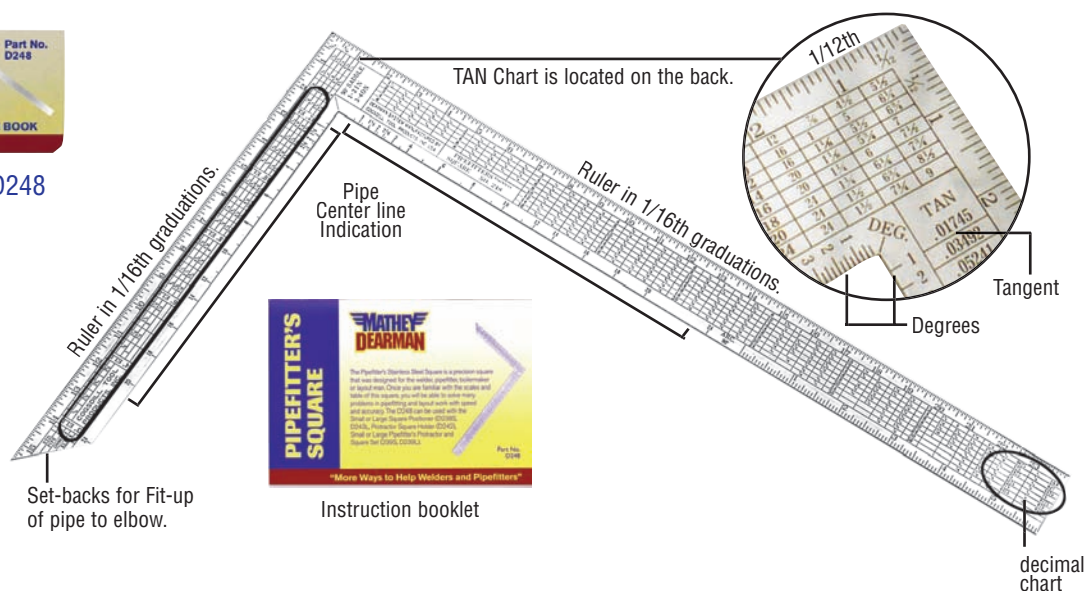
The Pit Depth Gauge can be used to check weld undercut and misalignment of plate to plate or pipe to pipe.

Part Number	Description
D254	Pit Depth Gauge

Pipe Fitter's Square



Part No.: D248



The **Stainless Steel Pipe Fitter's Square** is a precision square that is designed specifically for the pipe fitter, boilermaker, welder or layout person. Once you are familiar with the scales and tables of this square, you will be able to solve many of the complex problems encountered during pipe fit-up and layout work with speed and accuracy.

Part Number	Description	Blade Length (St / Lg) (in / mm)
D248	Pipefitter's Square	15 1/2-24 / 394-610mm x 1/8 Thick / 3mm Thick

Pipe Fitter's Square may be used to:

- Check the squareness of one surface to another.
- Find pipe center line.
- Determine the flange bolt length and diameter.
- Find the number of bolt holes in a flange.
- Measure center to end dimensions of pipe elbows and tees.
- Find the through hub length of a flange.
- Determine the outside diameter of a weld neck flange.
- Determine arc length for a given radius.
- Measure angles off horizontal or vertical plane with level.
- Measure in 12ths or 16ths of an inch.
- Solve triangles or offsets.
- Find decimal equivalent.
- Layout a variety of weld joint configurations.



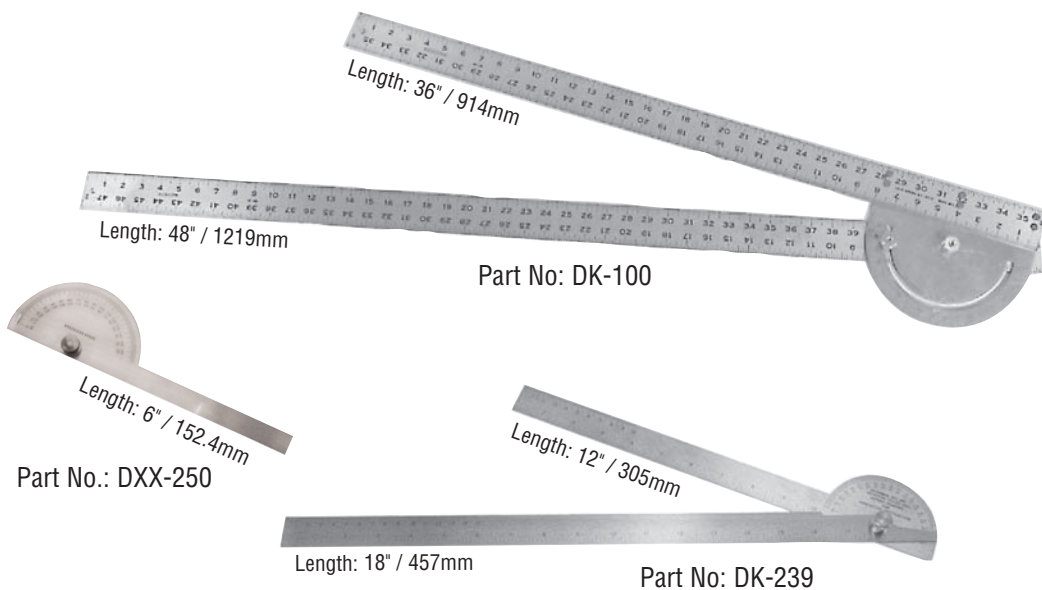
The Pipe Fitter's Square can be used to make a variety of joint configurations, such as miters, tees and diagonal joints.

Protractors



Small DK-239

Mini DXX-250



Mathey Dearman **Protractors** are used to determine or set bevels, transfer angles, and measure the squareness of one surface to another.

The Mini (DXX-250) and Small (DK-239) Protractors are made from stainless steel and the Large Protractor (DK-100) is made from aluminum. The blade of the Protractor can be locked in place at a particular angle. The Protractor head has a double graduation from 0°- 180° in opposite directions.

Part Number	Description
DXX-250	Mini Stainless Steel Protractor
DK-239	Small Stainless Steel Protractor
DK-100	Large Aluminum Protractor

Accuracy: $\pm 1^\circ$



The Mini Protractor can be used for a variety of applications including measuring the torch bevel angle and measuring degree of bevel (as shown).



The Small Protractor is an excellent tool for sheet metal layout, checking squareness of pipe ends up to 17" (432mm) diameter and can be used to check smaller pipe miter angles 0° to 90°.

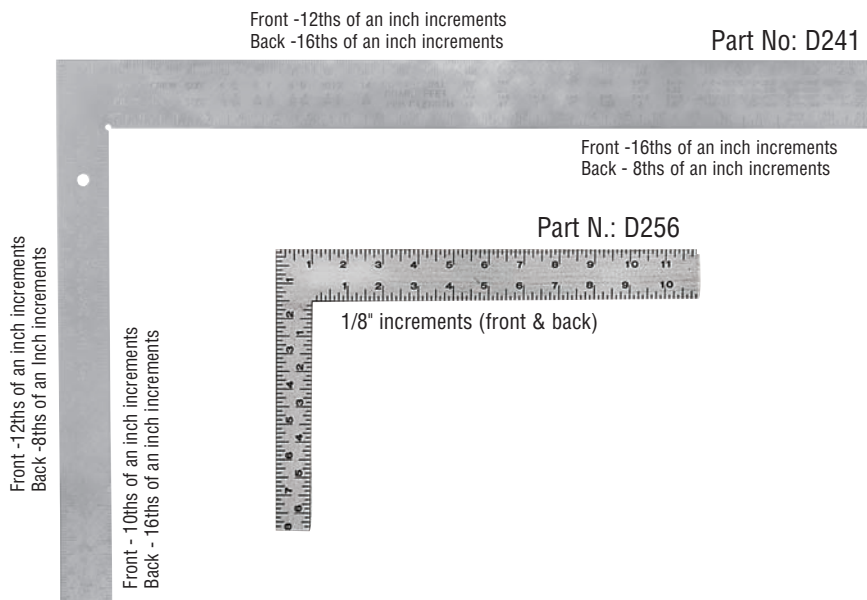


The Large Protractor will measure squareness of pipe ends up to 40" (1016mm) diameter or can be used to check large pipe miter angles up to 180°.

Framing Square



D256 (Small)
Stainless Steel



The **Small Stainless Steel and Large Aluminum Framing Squares** are used to measure angles or squareness of one point to another, and to find pipe center line. When used with a level, the squares will measure drops in inches per foot to determine degrees of slope. The Small Framing Square is in 1/8" increments and the Large Framing Square is in 1/8", 1/10", 1/12" and 1/16" increments.

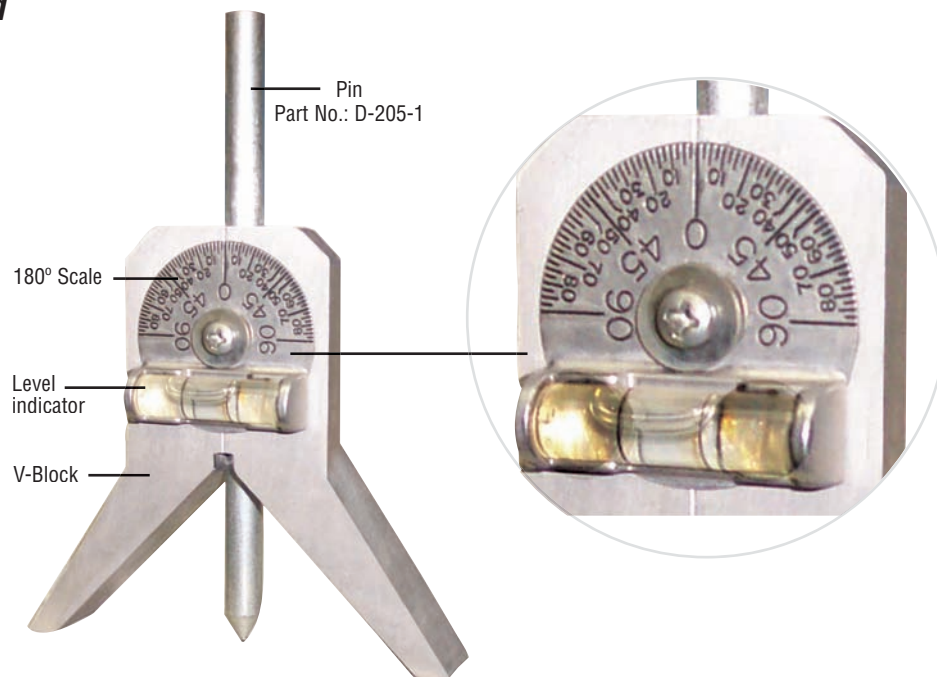
The Small Framing Square (D256) and Large Framing Square (D241) can be used with the Small Square Positioner (D238S).

Part Number	Description	Blade Length (St/Lg) (in / mm)
D256	Small Stainless Steel Frame Square	8-12 x 1/16 Thick / 203-305mm x 1.6mm Thick
D241	Large Aluminum Frame Square	16-24 x 1/8 Thick / 406-610mm x 3mm Thick



The D241 Large Framing Square and D256 Small Framing Square can be used to check squareness of pipes, flanges, and fittings.

Centering Head



The **Centering Head** provides a quick and accurate means of establishing pipe center line, locating points on tanks or pipes, measuring slope, establishing angles, and laying keyways. The dial face is stamped in 2 1/2° increments.

The Centering Head tool can be used to measure and mark different points around the pipe, flange or fitting.

- **TRUE**—center line can be marked on both ends of the pipe.
- **REFERENCE**—points can be marked at various degrees around the pipe.
- **DECLIVITY or INCLINATION**—Can be used to measure degrees of upward or downward slope of pipe or plate.

Centering Head

Part Number	Description
D205	Standard model, pipe 1/2in / 13mm and larger

Centering Head Parts

Part Number	Description
D205-1	Pin Standard Model
D205-DIAL	Degree Indicator Dial



Can be used to measure top dead center.



Can be used to measure angles in relationship to top dead center.

Spacing Wedges



Part Nos.: D271 (Large)
D272 (Medium)
D273 (Pocket Wedge)

Small
Pocket Wedge

The combination of **Spacing Wedges** and Mathey Dearman chain clamps or cage clamps enable better fit-up of pipe ends. The Wedges are used to give a precise weld gap. Move the pipe ends together, mount and tighten the chain clamp or cage lamp and spread the gap to the desired width using the Spacing Wedge.

The wedge portion of the Spacing Wedge is hardened so it will not bend or mushroom like home-made wedges. The upper part of the Wedge is soft so that it will not splinter.

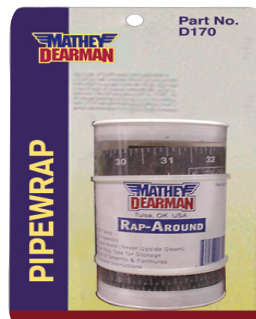
Case hardened to a depth of .010" (.25mm).

Part Number	Description
D271	Spacing Wedge, 8" x 1 1/2" x 1/4" (203mm x 38mm x 6.4mm)
D272	Spacing Wedge, 3 1/2" x 1 1/2" x 1/4" (89mm x 38mm x 6.4mm)
D273	Spacing Wedge, 2 2/3" x 1 1/2" x 1/4" (60mm x 29mm x 6.4mm)
BOX	
BOX - English	D253E-BOX
Packaged - ten (10) per box	



Weld gap can be quickly set using the Spacing Wedge.

Pipe Wrap



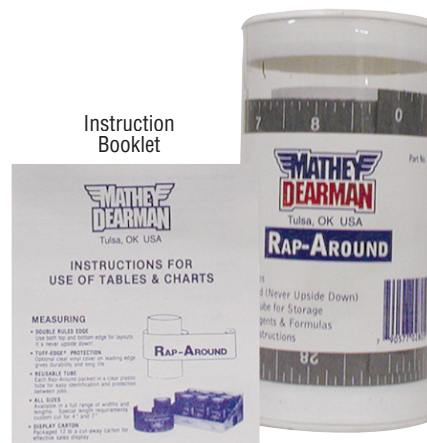
Part No.: D170 (Large)

The Mathey Dearman **Pipe Wrap** has a double-ruled edge so it is never upside down or backwards. The Wrap can be used as a straight edge to make straight lines around the pipe and to mark angles to create pipe elbows. The Pipe Wrap is made of a highly abrasive-resistant material to resist the wear and tear of everyday use.

The Wrap includes:

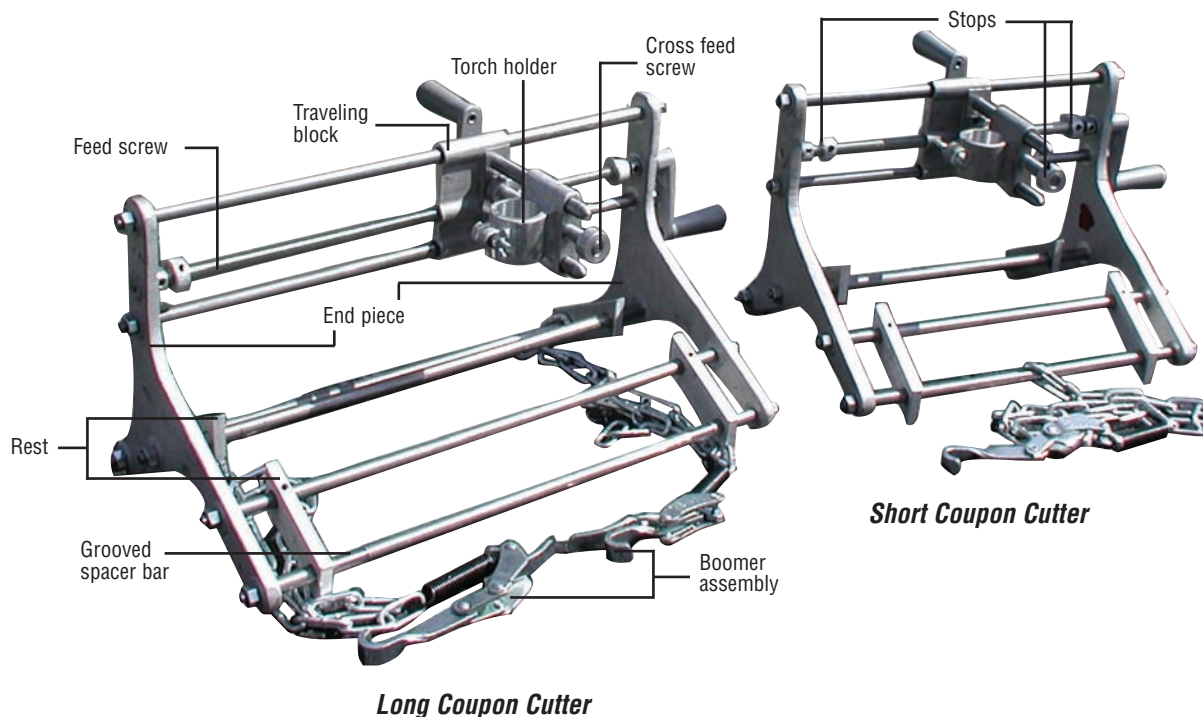
- Table of tangents and straight edge
- Instructions for cutting elbows
- Sides marked in 1/8" (3.2mm) Increments to 36" (914mm)
- Instruction for finding the length of an elbow.
- 45° angle chart
- Degree markings
- Available in 4", 5" and 7" widths

Pipe Size (in / mm)	Size	Part Number	Description
3-15 / 76-381	Medium	D160	Wrap, Width 4" x 4' / 102mm x 1219mm
3-22 / 76-559	Large	D170	Wrap, Width 4" x 6' / 102mm x 1829mm
3-26 / 76-660	Extra Large	D177	Wrap, Width 4" x 7' / 102mm x 2134mm
Pipe Size (in / mm)		Part Number	Description (by increments)
Pipe size to be specified		D184	4" / 102mm Width x Length Desired Sold in 1' / 305mm Increments
Pipe size to be specified		D185	5" / 127mm Width x Length Desired Sold in 1' / 305mm Increments
Pipe size to be specified		D187	7" / 178mm Width x Length Desired Sold in 1' / 305mm Increments



The Pipe Wrap is an excellent tool for aligning the MagnaCut XM and CGM Guide Strips on pipe diameter over 18" (457mm) to insure a square cut.

Coupon Cutter



The **Coupon Cutter** makes the cutting of weld test coupons quick and easy. This efficient tool can be used for any procedure requiring removal of a section of the pipe wall on pipe sizes 4" (102mm) and larger. A boomer assembly (included) for up to 12" pipe is used to rapidly fasten the machine to the pipe. A boomer is usually not needed on pipes above 12" (305mm).

- **COUPONS**—Can be used to cut test coupons for API, ASME and AWS welder certification.
- **TESTING**—Makes coupons to test filler hardness to parent material or for bend testing.
- **PRECISE**—By adjusting the stops the coupon cutter will cut the same size testing coupon time after time.

Part Number	Item/ Assembly Description	Cuts Coupons (in / mm)
03.0300.S00	Coupon Cutter (short)	2 x 9 / 51 x 229
03.0300.L00	Coupon Cutter (long)	2 x 13 / 51 x 330



An excellent tool for making coupons for bend test, tensile test, and hardness tests.

WELDING ELECTRODE AND FLUX OVENS

Mathey Dearman offers eight (8) models of welding ovens, which can be used for reconditioning, rebaking or holding of electrodes or flux with capacities ranging from 18lbs. (8kg) to 1650lbs (750kg).



P8 Series

18lbs (8kg) of 18"
(45.7cm) Electrodes



P15 Series

35lbs (15kg) of 18"
(45.7cm) Electrodes



Model C
Rebaking Oven

C3 550lbs (250kg)
C6 1100lbs (500kg)
C9 1650lbs (750kg)



Flux Hopper Oven
N120 265lbs (120kg)
N240 530lbs (240kg)



MEC/2
990lbs (450kg) of 18"
(45.7cm) Electrodes

Mathey Dearman Welding Ovens - Basic Specifications

Model	Type	Capacity		Available Voltages	Available Temperature	Other Features Available
		lbs	kg			
P8	Holding	18	8	120, 240	Fixed, Adjustable with thermometer	
P15	Holding	35	15.9	120, 240	Fixed, Adjustable with thermometer	
C3	Rebaking	550	250	240	Adjustable	
C6	Rebaking	1100	500	440	Adjustable	
C9	Rebaking	1650	750	440	Adjustable	
MEC 2	Holding	990	450	240	Adjustable	
N120	Flux	265	120	240	Adjustable	
N240	Flux	530	240	440	Adjustable	

DID YOU KNOW?

Mathey Dearman products are used in these and other applications

MATHEY DEARMAN is always working to improve its products and develop new ones. Got a unique application? Let us know!

If it's your job to prepare pipe for welding, call Mathey Dearman. We are the world's foremost authority on cutting, beveling, clamping, and aligning pipe on

any kind of project, anywhere in the world. With our products, and our advice, your pipe connection will be so good, that whatever's in it will stay there.

- Pipelines
- Oil field skids
- Offshore drilling platforms
- Piping in food processing plants
- Piping in pulp & paper plants
- Piping in microprocessor plants
- Chilling towers
- Water lines
- Refineries
- Tank farms
- Chemical & Petrochemical plants
- Nuclear, fossil fuel, & hydro-electric power plants
- Water & sewage treatment plants
- Steel mills & foundries
- Piping in the mining industry
- Fire sprinkler systems
- Covered walkways
- Military installations
- Highway & bridge construction
- Grain elevators
- HVAC systems
- Foundations of large buildings
- Piping in ships & submarines
- Barge construction
- Pipe bumpers
- Pipe fencing
- Hand rails
- Environmental protection equipment
- Fluid headers
- Berths & dry docks
- Boiler equipment
- Demolition work

WANT TO INCREASE WALK-IN SALES?



The *Point of Display* is designed to accomplish that for you. Simply select the Mathey products that you think your customer is most likely to buy (we'll help you with that!). If some of the items don't sell, contact Mathey Dearman within **90 DAYS** of purchase and we'll exchange them for other items.

COMMERCIAL PIPE SIZES AND WALL THICKNESS

Pipe Size In Inches	O.D. In Inches	Nominal Wall Thickness For								
		Sched. 10	Sched. 20	Sched. 40	Extra Strong	Sched. 80	Sched. 120	Sched. 140	Sched. 160	XX Strong
1/8	0.405	-	-	0.068	0.095	0.095	-	-	-	-
1/4	0.540	-	-	0.088	0.119	0.119	-	-	-	-
3/8	0.675	-	-	0.091	0.126	0.126	-	-	-	-
1/2	0.840	-	-	0.109	0.147	0.147	-	-	0.188	0.294
3/4	1.050	-	-	0.113	0.154	0.154	-	-	0.219	0.308
1	1.315	-	-	0.133	0.179	0.179	-	-	0.250	0.358
1 1/4	1.660	-	-	0.140	0.191	0.191	-	-	0.250	0.382
1 1/2	1.900	-	-	0.145	0.200	0.200	-	-	0.281	0.400
2	2.375	-	-	0.154	0.218	0.218	-	-	0.344	0.436
2 1/2	2.875	-	-	0.203	0.276	0.276	-	-	0.375	0.552
3	3.5	-	-	0.216	0.300	0.300	-	-	0.438	0.600
3 1/2	4.0	-	-	0.226	0.318	0.318	-	-	-	-
4	4.5	-	-	0.237	0.337	0.337	0.438	-	0.531	0.064
4 1/2	5.0	-	-	-	0.355	-	-	-	-	0.710
5	5.563	-	-	0.258	0.375	0.375	0.500	-	0.625	0.750
6	6.625	-	-	0.280	0.432	0.432	0.562	-	0.719	0.864
7	7.625	-	-	-	0.500	-	-	-	-	0.875
8	8.625	-	0.250	0.322	0.500	0.500	0.719	0.812	0.096	0.875
9	9.625	-	-	-	0.500	-	-	-	-	-
10	10.75	-	0.250	0.365	0.500	0.594	0.844	1.000	1.125	1.000
11	11.75	-	-	-	0.500	-	-	-	-	-
12	12.755	-	0.250	0.046	0.500	0.688	1.000	1.125	1.312	1.000
14 O.D.	14.0	0.250	0.312	0.438	0.500	0.750	1.094	1.250	1.406	-
16 O.D.	16.0	0.250	0.312	0.500	0.500	0.844	1.219	1.438	1.594	-
18 O.D.	18.0	0.250	0.312	0.562	0.500	0.938	1.375	1.562	1.781	-
20 O.D.	20.0	0.250	0.375	0.594	0.500	1.031	1.500	1.750	1.969	-
22 O.D.	22.0	0.250	0.375	-	0.500	1.125	1.625	1.875	2.125	-
24 O.D.	24.0	0.250	0.375	0.688	0.500	1.218	1.812	2.062	2.344	-
26 O.D.	26.0	0.312	0.500	-	0.500	-	-	-	-	-
28 O.D.	28.0	0.312	0.500	-	0.500	-	-	-	-	-
30 O.D.	30.0	0.312	0.500	-	0.500	-	-	-	-	-
32 O.D.	32.0	0.312	0.500	0.688	0.500	-	-	-	-	-
34 O.D.	34.0	0.312	0.500	0.688	0.500	-	-	-	-	-
36 O.D.	36.0	0.312	0.500	0.750	0.500	-	-	-	-	-
42 O.D.	42.0	0.312	-	-	0.500	-	-	-	-	-
48 O.D.	48.0	-	-	-	0.500	-	-	-	-	-

Mathey Dearman, Inc. and C.I.A. Mathey, Inc. Warranty and Terms and Conditions of Sale

(LIMITED WARRANTY) Subject to the provisions contained herein, if any merchandise sold hereunder (except merchandise manufactured by other persons or firms) by Mathey Dearman, Inc. ("Mathey Dearman") or C.I.A. Mathey, s.r.l. ("CIA Mathey"), (either of which may be the seller of the merchandise, and either of which may be referred to herein as the "Company") is not within customarily accepted tolerances of the specifications shown on the order, or is defective due to workmanship or material; AND if such merchandise is returned at the customer's expense and risk to the Company's manufacturing facility (or at the Company's option, is returned to an alternate repair facility authorized by the Company) within ninety (90) days after the Company's date of shipment thereof (the "Warranty Period"), the Company will, at its option, replace or repair the merchandise. The Warranty shall not apply to merchandise that has been altered or in any way modified by any party other than the Company, NOR to merchandise that has been improperly installed, operated, or handled based upon industry standards, NOR to merchandise for which the customer has not provided reasonable and customary maintenance, NOR for merchandise that has been used or operated in a way not in accordance with the instructions in the Company's Operating Manual. In addition, this warranty is subject to the following conditions: (A) the customer must promptly notify the Company in writing of any claim under this agreement, setting forth in detail any claimed defects, and (B) the Company must be afforded a reasonable opportunity to examine the merchandise and to investigate and verify the claimed defect at the Company's manufacturing facility or at an authorized repair facility. The Company shall not be, in any event, liable for damages beyond the price paid by the customer for said defective merchandise.

THE COMPANY SHALL NOT BE LIABLE TO CUSTOMER UNDER ANY CONDITION OR CIRCUMSTANCES FOR CONSEQUENTIAL, INCIDENTAL, INDIRECT, PUNITIVE, OR EXEMPLARY DAMAGES. This agreement does not obligate the Company to bear any transportation charges in connection with the replacement or the repair of said defective merchandise. As to any item manufactured by other, third-party persons or firms, but sold by the Company, the Company agrees to present a request for credit, replacement, or repair to such manufacturer. The customer agrees that the liability of the Company shall not exceed the value of any adjustment offered by such manufacturer. **THE ABOVE AGREEMENT IS IN LIEU OF ALL WARRANTIES, EXPRESSED OR IMPLIED, AND IT IS UNDERSTOOD THAT THERE IS NO EXPRESSED OR IMPLIED WARRANTY BY THE COMPANY AS TO THE MERCHANDISE'S FITNESS FOR A PARTICULAR PURPOSE, NOR ITS MERCHANTABILITY, CAPACITY, OR EFFICIENCY, AND THAT THERE ARE NO EXPRESSED OR IMPLIED WARRANTIES, EITHER ORAL OR WRITTEN, MADE IN CONNECTION WITH ANY SALE BY THE COMPANY OTHER THAN AS EXPRESSED HEREIN.**

No modification or addition to this agreement, either before or after the contract of sale, shall be made except on written authority of an authorized agent or officer of the Company.

The Company shall have no liability for warranty claims if the merchandise has been abused, misused, vandalized, or operated in any way not in accordance with its specifications after delivery to the customer. The Company shall also have no liability for Warranty claims if the merchandise is from the Company's CGM Pipe Cutting and Beveling product line and has been used in any manner not in compliance with the published "Conditions of Use", as applicable.

Force Majeure

The Company shall not be liable for any delay in shipments or impairment of the performance of products resulting in total or in part from Acts of God, labor disruptions, laws, inability to procure product, shortages of supplies or raw materials, civil war or other act of hostility, acts of terrorism, civil unrest, or any other circumstances beyond the reasonable control of the Company.

Quotations

Quotations will be honored up to but not beyond 30 days from issuance unless stated otherwise in writing by the Company. Quotations on large orders

Technical Support

The Company's technical sales staff is available to assist Customers in their search for solutions. Please contact Mathey Dearman's Sales Department at (800) 725-7311 or (918) 447-1288.

Catalog and Literature Errors

All information in the Company's literature has been carefully checked for accuracy. Errors and omissions occasionally occur and therefore are subject to correction and/or change at the Company's convenience.

Terms and Billing Options

For an approved open account, terms are Net 30 days from date of invoice. In addition to credit accounts, we accept cash, C.O.D., wire transfer, letter of credit confirmed on a U.S. Bank, and the following credit cards: Visa, MasterCard, American Express.

Cancellation

Any cancellation of orders must be approved by the Company prior to issuance of a credit, and may be subject to restocking and/or other charges.

Sales Tax

Sales tax is the responsibility of the customer unless a valid exemption certificate is on file with the Company prior to the placement of an order.

Freight Policy

Unless otherwise stated, freight and shipping fees will be charged on shipments to a customer's place of business anywhere in the contiguous United States. Unless the customer states a preferred carrier, the Company retains the right to choose the carrier. Other terms apply to any shipping locations outside the contiguous United States. Any extra charges incurred for additional services and special handling by the customer's designated carrier must be paid by the customer. Title and risk of loss will pass to the customer upon tender of the shipment to the carrier. If the product is damaged in transit, the customer must file the claim with the carrier. If consignee is responsible for the freight, do not return the damaged product to the Company without filing the freight claim.

Minimum Order Policy - \$50.00 NET for all Mathey Dearman, Inc. Customers.

Warranty (Continued.)

Returns and Warranty Policy

1. Returns

- a. To return products for credit or warranty repair, the customer must first contact Mathey Dearman Inc. at (918) 447-1288 to obtain a Return Goods Authorization (RGA) Number. No returns will be accepted without this RGA number.
- b. Please print the RGA number on the outside of the box and include a copy of the original invoice or packing list in the box with the returned merchandise. The merchandise must be packed properly so as to avoid damage in shipment. Any damages during return shipment due to improper packing will be the responsibility of the shipper. Unless otherwise stated by the Company, merchandise returned for credit may be subject to a restocking charge.
- c. When returning products for credit or warranty repair to Mathey Dearman, Inc. or C.I.A. Mathey, Inc. merchandise is to be shipped to one of the following based on the location of the original purchase:

Mathey Dearman, Inc.
Attn: Returns & Repair Department
4344 South Maybelle Ave.
Tulsa, OK 74107

C.I.A. Mathey, Inc.
Via Isonzo, 26
20050 San Damiano di Brughiero
Milan, Italy

- d. Merchandise must be returned freight/postage prepaid. Mathey Dearman will not accept C.O.D. shipments.
- e. Merchandise must be returned within 14 days of issuance of RGA number.
- f. The Company will not accept product returned for credit which has been painted, etched or altered.
- g. Items Ordered in excess or in error by customer will also be accepted for credit if above requirements for packing and shipping are met, and if:
 - i. Merchandise is normal stock items, i.e., not special-order items;
 - ii. Merchandise is returned to the Company in as-new condition and in its original packaging;
 - iii. Conditions in 1 (a) through 1 (f) are met.

2. Credit for claims of short-shipments

- a. Customer must contact Mathey Dearman sales department to file a claim at (800) 725-7311 or (918) 447-1288, or sales@mathey.com.
- b. Claim must be filed within seven (7) days of receipt of merchandise.

3. Credit for claims of merchandise damaged in shipment

- a. If customer paid freight for original shipment, claim must be filed with freight carrier.
- b. If Mathey Dearman paid freight for original shipment, customer should contact Mathey Dearman sales department to file a claim at (800) 725-7311 or (918) 447-1288, or sales@mathey.com, and to receive a Returned Goods Authorization (RGA) number.

Repairs (non-warranty)

Prompt tool repair by in-house technicians as well as Authorized Repair Centers assures maximum service life and highest value. The Company's experienced repair team inspects and evaluates all tools sent in for repair to determine required parts and service for repair. The Company's Sales Department will then quote prices and delivery date prior to the repair work being initiated. Please contact Mathey Dearman's sales department at (800) 725-7311 or (918) 447-1288 for the nearest Authorized Repair Center to your location. If you wish to return your product to the Company for repair, please enclose in the carton or crate your address, phone number and a brief description of what is wrong with the tool and how it is being used.

Custom Tool Design

The Company's sales and engineering teams offer custom tool design and manufacturing to meet every facet of a customer's cutting, aligning, reforming and fit-up requirements. We will develop engineering solutions for your piping, tubing, or pressure vessel special applications or problems. If you need a way to do the job more accurately and safely in a shorter period of time, while keeping your overall costs to a minimum, contact Mathey Dearman's sales department at (800) 725-7311 or (918) 447-1288.

Miscellaneous

The laws of the State of Oklahoma, USA shall apply to the interpretation and enforcement of this Agreement. By placing the order, the customer agrees that any legal proceedings to interpret or enforce the provisions of this Agreement shall be brought exclusively in the State Courts of the State of Oklahoma or the U.S. District Court for the Northern District of Oklahoma. If any legal proceeding is instituted to interpret or enforce the provisions of this Agreement, the prevailing party in such proceedings shall be entitled to recover its reasonable attorney fees from the other party. This Agreement contains the entire agreement between the Company and the customer respecting the matters discussed herein, and no provision may be modified without the express written consent of the Company. If any provision contained in any document presented now or hereafter by the customer to the Company is inconsistent with, or contradictory to, any provision contained in this Agreement, the provision in this Agreement shall control unless the Company issues a written statement specifically agreeing to the application of the customer's provision. Acceptance of a customer's order or response to a customer's bid shall not be deemed, by itself, to be such consent.

WHERE THERE'S PIPE, THERE'S MATHEY

MATHEY DEARMAN, INC.
4344 Maybelle Avenue
TULSA, OK USA 74107

Ph: 918 447-1288
Toll Free: (800) 725-7311
Fax: 918 447-0188



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Sold Exclusively Through Welding and Industrial Distributors and Suppliers.