

**ACCESSORY PENDULUM WEAVER FOR MECHANIZED
GMAW WELDING ORDERING SPECIFICATIONS**

DOCUMENT # 6222-3340 — Clin 0001

1. Must be fully interface and be fully integratable with current carriage/drive unit inventory and weaver control modules without modification or alteration
2. Must have on/off switch for contactor
3. Must have separate controls for right/left dwell times
4. Must be capable of setting and maintaining weave weld parameters
5. Must be capable of setting and maintaining exact weaver start and stop points
6. Must be capable of setting and maintaining center of weld position

ACCESSORY WEAVER CONTROL MODULE FOR MEDCHANIZED GMAW WELDING

DOCUMENT # 6222-3341 — Clin 0002

1. Must be fully interface and be fully integratable with current carriage/drive unit and accessory Pendulum Weavers in inventory without modification or alteration
2. Control module must control carriage/drive unit and Weaver (Pendulum or Linear) functions
3. Must offer at least three weave weld patterns and a non-weave stringer bead selection
4. Weave speed must be controllable with a range of 0" to at least 90" per minute
5. Must have a controllable weave width range minimum of 1/8" to at least 1-3/4" wide
6. Must be able to control left/right dwell times
7. Must be steerable within 4" range (2" either side of weld center)
8. Must be able to control carriage/drive direction (forward or reverse neutral)
9. Must have digital settings readout

ON/OFF HIGH STRENGTH—HIGH HEAT GUIDE RAIL MAGNET ATTACHING ASSEMBLIES

DOCUMENT # 6222-3342 - Clin 0003

- 1. Rare Earth magnet guide rail attaching assemblies must interface and be fully compatible with current inventory of High-flex mechanized GMAW guide rail**
- 2. Rare Earth magnet attaching assemblies must be able to be put into service without requiring any alteration or modification**
- 3. Magnet attaching assemblies will be used on heated weldments---must be able to maintain 230 lb. holding power at up to 350 degrees Fahrenheit**
- 4. Magnet assemblies must have high heat, high strength rare earth magnets with at least 230 lbs holding power**
- 5. Rare Earth magnets must be engaged and disconnected by on/off style switch**

HIGH FLEX MECHANIZED WELDING GUIDE RAIL

ORDERING SPECIFICATIONS

DOCUMENT # 6222-3343 - Clin 0004

1. Must be compatible and fully interface with existing inventory of mechanized flexible guide rails, carriages, attaching magnet assemblies, and drive units
2. Rail mounting method shall be high heat, high strength rare earth magnets
3. Rail shall be made of tempered stainless steel
4. Rail flex minimum operational radius shall be at least as small as 3'
5. Guide rail track sections shall be at least 4.5' in length