

**YOUR RELIABLE
PARTNERS
FOR CUTTING,
WELDING,
POSITIONING
AND AUTOMATION**



Company Profile

The KISTLER Machine Company is a long established family business engaged in engineering and manufacturing of welding positioning and cutting systems for the welding trade, especially for pipe welding and cutting.

The KISTLER Machine Co. was founded back in 1966 by senior engineer Roland Kistler.

Nowadays, the company is run by his son, engineer Alexander Kistler.

In order to serve the customer s need best, KISTLER will not only supply a large range of standard equipment (such as positioners, turning rolls, manipulators etc) but also design and manufacture automation equipment according to customer s specific needs. Please contact us, the special is our standard



PIPE ROTATORS WITH CLAMPING ROLLER SYSTEM (patented) U Range - Models U 150, U 500, U 1000

The welding device especially designed for pipe welding

Description:

For clamping, rotation and tilting of pipes with round profiles in manual or automatic welding, mainly in the field of pipe construction (prefabrication and assembly on site) as well as in the manufacture of plant.

Technical Data:

- rotary speed infinitely 0-130 cm/min
- Pipe range with clamped pipe: 20-800mm incl. Component flange
- Max. Load: 150kg - 2000kg
- Special models and accessories are available on request

Welding Positioners - R-Range

Description:

On all models, the rotation speed is infinitely variable.

The drives for turning of the faceplate and tilting as well as the electrical control are located in protective housings. Load from 50kg – 10000kg



Technical Data	Length (mm)	Width (mm)	Height (mm)	Max. Load (kg)
R 50	350	250	415	50
R 100	450	300	465	100
R 300	700	700	900	300
R 500	860	700	930	500
R 750	1140	770	1000	750
R 1500	1500	1105	1145	1500
R 3000	1700	1180	1180	3000
R 5000	1900	1300	1220	5000
R 7500	2400	1600	1600	7500
R 10000	2650	1700	1680	10000

POSITIONERS OF THE HP-RANGE

Description:

Positioners of the HP-range are used for welding, grinding and positioning purposes. Apart from the turning drive of the faceplate, this range of positioners provides hydraulic tilting of the faceplate and hydraulic lifting. Infinitely variable workpiece positioning ensures ideal ergonomic and economic working positions.



Technical Data	Rotating torque Nm	Tilting torque Nm	Length (mm)	Width (mm)	Height (mm)	Nom. Load (kg)
HP 3000	2000	7500	2000	1200	800-1500	3000
HP 5000	5000	10000	2300	1600	800-1500	5000
HP 7500	8000	14000	2600	2000	1000-1700	7500
HP 10000	12000	30000	3000	2000	1000-2000	10000
HP 15000	15000	65000	3000	2000	1200-2100	15000
HP 20000	20000	100000	4000	2300	1200-2100	20000
HP 250000	30000	175000	4200	2500	1300-2300	25000
HP 30000	40000	250000	4200	2500	1300-2300	30000



POSITIONERS OF THE L-RANGE

Description:

The Positioners of the L-range are used for welding, grinding and positioning purposes. Apart from the motorized turning drive of the faceplate, this range of positioners provides electric tilting and hydraulic lifting.

Infinitely variable workpiece positioning ensures ideal ergonomic and economic working positions.

Type	Load capacity	Rotation torque	Max. swing radius	Faceplate-tilting axis	Faceplate height	Faceplate diameter	Lifting stroke	Tilting angle	Total width	Frame width	Frame length	Height	Slots for	Earth return
	(kg)	(kgm)	(mm)	F	G	E	H	K	A	B	C	D		(Amp.)
L 500	500	75	750	100	400	500	750	+/- 180	1500	800	1100	2000	M16	300
L 1000	1000	150	750	150	500	800	750	+/- 180	1800	1000	1200	2500	M16	300
L 1500	1500	225	1250	150	600	1200	1000	+/- 180	2600	1200	1400	3000	M16	300
L 2000	2000	300	1250	150	700	1200	1000	+/- 180	2800	1350	1800	3200	M16	600
L 5000	5000	750	1250	150	800	1300	1200	+/- 180	3000	1500	2000	3800	M16	600
L 10000	10000	1500	1500	200	900	1300	1500	+/- 180	3200	1650	2500	4300	M16	600
L 15000	15000	2250	1500	250	1000	1500	1500	+/- 180	3600	1800	3000	4400	M20	600
L 20000	20000	3000	2000	300	1100	1500	1500	+/- 180	4000	2000	3400	4800	M20	600
L 30000	30000	4500	2000	400	1200	2000	1500	+/- 180	4500	2500	3800	4800	M24	600
L 40000	40000	6000	2000	500	1300	2000	1500	+/- 180	5000	3000	4600	5200	M30	600

Pipe Cutting Machines of the SCM Range

Description:

The SCM machines are equipped with two PLC-controlled axis which enables the machine to cut pipes in conjunction with a plasma or oxy-fuel torch.

The work piece is clamped by a driven chuck (axis 1), then the torch is moved over the pipe (axis 2). Optional, a third controlled axis can be added to enable the machine to bevel end cuts (straight, miter and branches).

All programming is menu-driven, the machine is therefore easy to operate.



Technical Data	Workpiece diameter (mm)	Torch stroke (mm)	Through Hole (mm)	Cutting Speed (mm)
SCM 300	25-300	500	100	2000
SCM 400	25-400	1000	150	2000
SCM 630	25-630	1500	200	2000

CNC-CONTROLLED PIPE CUTTING MACHINE OF THE RSM-RANGE

• practical • robust • cost-effective

Application:

This appliance is used for the exact cutting, or rather, cutting out of all adaptations and penetrations occurring in pipeline construction. Cutting procedure either oxyacetylene or plasma. Clamping range from 20 mm up to 1200 mm, with five CNC-controlled axes.



Technical Data	Workpiece diameter (mm)	Work piece length (mm)
RSM 400	20-400	3000 / 6000 / 12000
RSM 630	20-630	6000 / 12000
RSM 1200	25-1200	6000 / 12000

Manual chucks of the MC Range



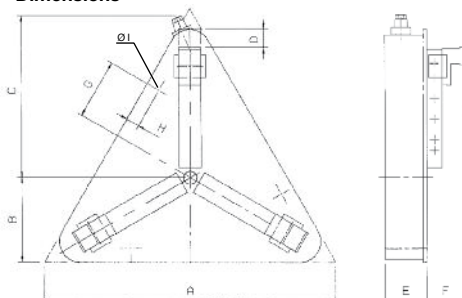
Application:

Manual chucks of the MC series are used for clamping of work-pieces for welding processes.

Description:

The MC series manual chucks are designed for heavy duty purposes and have a completely closed housing, therefore this equipment is especially useful for the welding industry. Features include single point cam operation of the jaws and adjustable quick change reversible jaws. Standard delivery includes steel jaws, hardened jaws are also available.

Dimensions

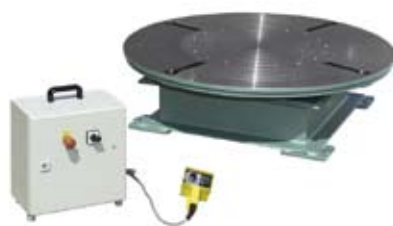


Model	Clamping diameter		A	B	C	D	E	F	G	H	I
	Max.	Min.									
MC 400	400	30	450	160	240	35,5	65	60	90	120	13
MC 700	700	40	770	225	425	62,5	114	100	160	36	17
MC 1000	1000	50	1110	320	610	90	160	140	230	52	21

Turntables of the H Range

General description:

Positioners of the H-range are used for welding, grinding and positioning purposes. Infinitely variable turning speed, achieved by an inverter controlled motor gearbox allow ideal possibilities for welding and positioning. Large bearings ensure stability and smooth movement.



Technical Data	Capacity (kg)	Face Plate Dia. (mm)	Turning Speed (rpm)
H 1000	1000	1000	0-2
H 2000	2000	1100	0-2
H 5000	5000	1200	0-1,5
H 10000	10000	1300	0-1

COMPANY PROFILE

The Bode company was founded as F. Bode & Son Ltd in 1938 and is based in England.

The company initially was heavily committed to the war effort but also became involved in welding. Later the business developed into general engineering carrying sub-contract work for local companies. The company developed during the 1950s a range of Welding Positioners specifically designed to improve the welding of steel fabrications.

The company invented and held the patent for many years for the Rotating Positioner and the Self-Aligning Rotator. The company has manufactured over 35,000 machines, which are in use with fabrication companies in every part of the world. The Bode name has become synonymous with positioning equipment, the products having proved themselves to be indispensable in the fabrication process.

The main spread of sales has been in the industrialized countries in Europe, with distributors marketing the range of positioners in the Middle East, South East Asia, India and several of the South American countries.

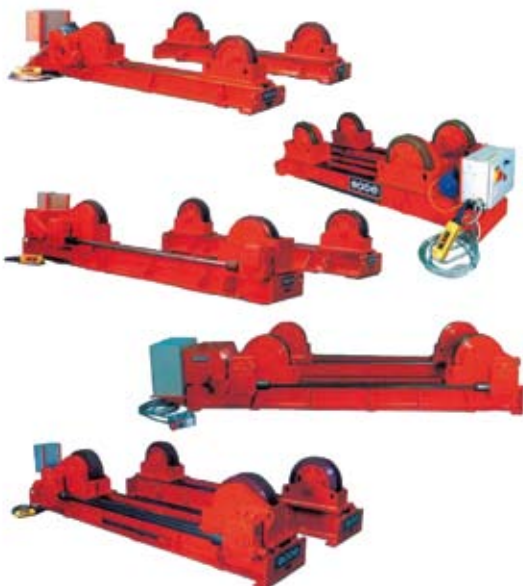
The Bode portfolio of positioning equipment is probably the most comprehensive of any manufacturer in the world and the range of machines extends to over 2000 models.

In addition to the standard range of models, the company designs and manufactures custom built special purpose welding machinery, which meets the specific needs of the customer.

Principle customers are involved in steel fabrication, but equipment is also supplied to fabricators in copper, aluminium and alloy steels. The customer base extends to the following industries:

- Aerospace
- Dairy Foods
- Mining
- Brewery
- Petrochemical
- Railway Industries
- Defense
- Wind mill Tower Systems
- Truck / Trailer Manufacturing
- Automobile Industry
- Nuclear Power / Power Generation
- Shipbuilding
- Offshore Oil & Gas Industries
- Construction

The Bode equipment is manufactured to the highest quality in design and engineering and we have a dedicated design team capable of producing turnkey solutions to meet the demands of our customers both from a handling perspective and final weld solution.



BODE CONVENTIONAL ROTATORS

- Load capacities from 1 ton up to 1400 tons
- Capable of handling vessels in all diameters
Manual adjustment of rollers across frames.
- Robust all-steel welded construction.
- Variable speed rotation through inverter control.
- Tachometer speed indicator (optional).
- Anti-Creep fitted to Idler Section (optional).



BODE PATENTED SELF-ALIGNING ROTATORS

- Load capacities from 3 ton up to 600 tons
- Instantly self-aligning to the workpiece.
- Robust all-steel welded construction.
- Clutches incorporated in top rollers of Drive Section to prevent damage to transmission when loading.
- Variable speed rotation through inverter control.
- Tachometer speed indicator (optional).
- Anti-Creep fitted to Idler Section (optional).



Bode Conventional Positioners Light – Medium - Heavy

With decades of engineering expertise and design skills, today's Bode positioners are second-to-none, handling workpieces from just a couple of hundred kilograms to several hundred tonnes. Size has never been a problem with Bode!

Free-standing, robust all steel fabrication, variable speed table rotation, round or square „T slotted“ tables with extension arms on some models, table tilt, steel gears, enclosed electric motors including electro-magnetic brakes, efficient built-in earthing, pendant remote push button controls on many models, and a range of optional extras, all make Bode Positioners exceptionally valuable pieces of equipment on any production floor. Equally, they represent great value for money. Contact us today for more information, or to discuss your special positioner needs.



BODE Column & Boom Manipulators

Globally the Bode range of Column & Boom Manipulators stands out not only for innovation in design and quality of manufacture, but also for reliability and robustness.

- 360° powered column rotation with manual locking at any position.
- Free standing or variable speed travelling carriage.
- Optional fittings, including welding heads, available.
- Variable speed boom.
- Boom elevation through geared motor rack and pinion drive with elektro-magnetic brake.
- Elevation and traverse drive mounted on saddle providing for easy access servicing and maintenance.
- Machines fully counter-balanced by column internal weight, connected to the saddle by heavy duty wire rope. Anti-fall device offers full safety feature.
- Extra wide rollers and unique slideways ensure minimum deflection traversing. Innovative machined 'V' ways to column ensure that the boom saddle moves smoothly with no vibration. This reduces wear and tear.

Whatever your need Bode will have the answer. Just talk to us, and remember, Bode also makes other ranges of Column & Boom Manipulators from portable to ultra heavy duty models.

Company profile of UP Helfert Schweisstechnik GmbH

UP Helfert is based in Kreuztal-Buschhütten (100 miles south of German's largest industrial area „Ruhrgebiet“) and was founded in 2001 as a Spin-Off of key personnel. Of the former welding machine supplier „Kröger Schweisstechnik“. This company, founded in 1972, was integrated into the Uniweld group after the company founded passed away.

UP Helfert is specialized in both standard and customized solutions in the field of submerged arc welding. UP offers all standard and special submerged arc welding processes, including standard single wire heads, strip cladding heads, narrow gap welding heads and multiple wire welding heads.

The UP Helfert staff has access to decades of experience in the fields of:

- Pressure vessel manufacturing
- Steel construction
- Pipe mills
- Wind mill tower production
- Shipbuilding
- Submarine (naval) shipbuilding

and is therefore able to offer bespoke solutions to customers worldwide.

Currently UP Helfert employs a staff of twelve. In order to secure continuity of the business, the UP Helfert shares have been sold to the Kistler group in 2007 and 2008.

SUBARARC WELDING HEAD FOR THREE WIRES TYPE H-UP-S5

Description:

Subararc Welding Head for three wires model H-UP-S5, suitable for diameters from 400 mm upwards.

Complete with laser pointer, headlamp, height sensor, flux separator, flux pan, flux suction hose and motorized cross slide 80 mm stroke each.



Technical Data:

Welding Head:

Maximum Wire diameter:	4 mm
Maximum Wire diameter (Stainless Steel):	3 mm
Maximum Current:	1200 A / 1200 A / 1200 A
Control Voltage:	42 V

Wire Feed Unit:

Motor Voltage:	38 V
Motor speed:	3200 / 36 U/min
Motor power:	180 W
Motor torque:	36 Nm
Maximum wire feed speed:	5,4 m/min

Cross slides:

Vertical stroke:	80 mm
Horizontal Stroke:	80 mm

FLUX FEED AND RECOVERY UNIT TYPE HE-PA-LU-8



Description:

Flux feed and recovery unit, working in closed loop with circular flow, operated by compressed air.

Technical Data:

Flux content: 8 l
 maximum air pressure: 6 bar
 Dimensions (L x W x H) approx.: 1000 x 200 x 850 mm
 Weight approx.: 20 kg

WELDING RECTIFIER TYPE HMS 1000



Description:

Stationary, thyristor controlled welding rectifier for submerged arc welding with constant voltage characteristic and infinitely adjustable welding voltage.

Technical Data:

Mains voltage: 400 V, 3 Ph.+Earth, 50 Hz
 Power consumption: 78 kVA
 Fuse required: 125 A, B type
 Open circuit voltage max.: 65 V
 Welding Current range: 19 V - 44 V
 Rating at 100% duty cycle: 1000 A
 Cooling class: F
 Protection class: IP 21
 Dimensions (L x H x D): 820 x 1000 x 1110 mm
 Weight (approx.): 440 kg

FLUX DRYING OVENS SPM RANGE



Description:

Flux drying ovens of different capacity with digital temperatur control and programmable drying temperature and drying time as well as holding time and holding temperature.

Technical Data:

Model	SPM 4,4.4/400	SPM 5,8.5/400	SPM 7,8.5/400
Capacity (l):	50 l	100 l	200 l
Internal diameter (mm):	400	580	780
Internal height (mm):	400	500	500
Dimensions (L x H x D) (mm):	560x815x1360	700x1080x1500	940x1320x1570
Maximum temperature:	400°C	400°C	400°C
Power requirement:	1,5 kW	3 kW	6 kW
Electricals:	400 / 3 / 50	400 / 3 / 50	400 / 3 / 50
Isolation class:	IP20	IP20	IP20
Weight:	105 kg	210 kg	290 kg