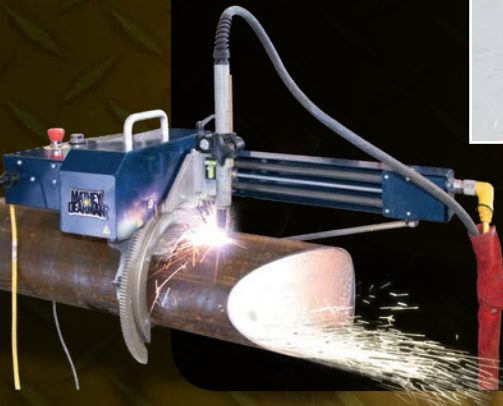
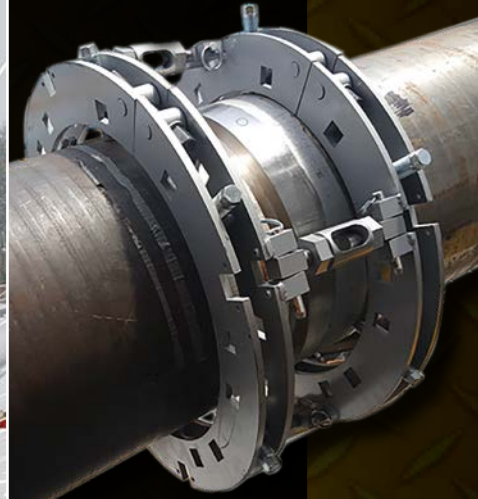
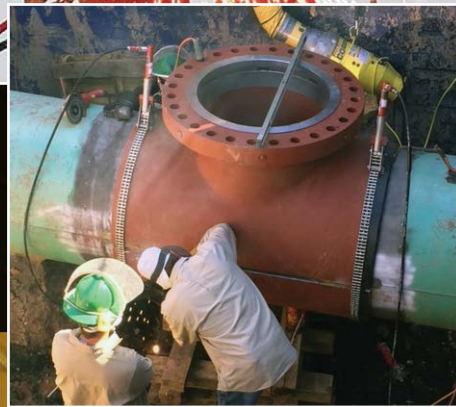


MATHEY DEARMAN®

Smarter. Tougher. Mathey.



sales@mathey.com | 800.725.7311 | www.mathey.com

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Mathey Dearman Master Catalog

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Notes:

Due to our ongoing efforts to offer the finest pipe cutting, beveling, clamping and alignment products available, product improvements may cause changes in specifications without notice.

Some photos include optional equipment or accessories.

Please read the Parts and Operating Manual thoroughly before attempting to use your Mathey Dearman machine or tool. Pictures are for illustration only. Actual product appearance may differ for some equipment.

A BRIEF HISTORY OF MATHEY DEARMAN

Since Chester A. Mathey built and sold his first portable machine in August 1936, industry professionals have relied on Mathey Dearman products for innovative cutting, beveling, clamping and aligning solutions.

SETTING THE STANDARD

In 1952, Mr. Mathey designed and introduced the industry's first Compact Saddle Machine. Cast from high-strength aluminum alloy, the lightweight Compact Saddle Machine is still recognized as the industry standard.



MATHEY INTERNATIONAL, LTD.

By the 1980s, Mathey Manufacturing Company was known as a world leader in cutting and beveling products including Compact Saddle Machines, wireline winching equipment for oil and gas exploration and welding ovens. In 1985, Hinderliter Tool company, a Tulsa-based manufacturer of oil field products purchased Mathey and then sold the company in 1987 to Donald Lockhart, a Hinderliter executive. Mr. Lockhart also acquired winching experts, Leland Truck, combining the companies and changing the name to Mathey Leland. Focusing on the expanding worldwide cutting and beveling business, the company sold the Leland division in 1989, changing the name to Mathey International, LTD.

MATHEY DEARMAN, INC.

In 1996, Mathey acquired the exclusive rights to Dearman clamping systems from Cogsdill Tool Products. Introduced in 1974 by Tim Dearman, his innovative Chain Clamp design quickly became the industry-standard for the product's unique ability to align and reform multiple sizes of pipe with the same machine.

Today, Mathey Dearman, as the company was renamed, manufactures the broadest range of Chain Clamps in the industry, capable of handling any size pipe from 1-inch to 20-feet.

TODAY ... AND TOMORROW

For over 80 years the best welders around the world have relied on authentic Mathey Dearman equipment for cutting, beveling, clamping and aligning pipe.

Each year offers exciting new products, cutting-edge designs and accurate, dependable equipment for the construction of oil and gas pipelines, power plants, ships, refineries, LNG terminals, chemical plants and more. Our past has been filled with innovation and our future will bring new solutions for the next generation. Now more than ever:

“Where there's pipe, there's Mathey.”

SADDLE MACHINES | MOTORIZED / MANUAL

The industry-standard for over 80 years, the Mathey Dearman Saddle Machine is versatile, simple to use, and perfect for almost any pipe cutting and beveling application. Lightweight and durable, Mathey Dearman Saddle Machines are designed for accurate, quality cuts on 1 ½" – 48" (38 mm – 1219 mm) pipes.

Want the easiest way to get a perfect cut every time? Motorized Saddle Machines from Mathey Dearman are precise and fast, delivering smooth cuts requiring little or even no grinding. Both experienced and inexperienced welders can benefit from the increased productivity (up to 5 times quicker!) and cut quality of Motorized Saddle Machines compared to traditional hand-cutting or manual machines. Motorized PLASMASPEED Saddle Machines can use 110/230 VAC for pipe sizes 1 ½" – 48" (38 – 1219 mm) and can operate at increased cutting speeds to use powerful plasma torches.

It's what Mathey Dearman calls PLASMASPEED!

PLASMASPEED

Motorized Saddle Machine Includes:

- | 110/230 VAC Motorized Saddle Machine | Torch Arm
- | Torch Carrier Assembly | Boomer Assembly (fastens the machine to the pipe)
- | Spacer Bolt Set | Parts and Operating Manual | Mounting Bracket
- | Right-angle precision stepper motor | Motor Control Box

NOTE: MACHINE TORCHES SOLD SEPARATELY -
MACHINE SHOWN WITH OPTIONAL STEP SPACERS AND PRO MODEL TORCH



Manual Saddle Machine Includes:

- | Saddle Machine
- | Torch Arm
- | Torch Carrier Assembly
- | Boomer Assembly (fastens the machine to the pipe)
- | Spacer Bolt Set
- | Parts and Operating Manual

NOTE: MACHINE TORCHES SOLD SEPARATELY

VERSATILE | Every model works on a range of pipe sizes

ADAPTABLE | Works with all standard torches, including plasma

PORTABLE | Light and compact, perfect for shop or field applications

EASY SET-UP | Mount and begin cutting in as little as 5 minutes

PROVEN | Depended on by professionals for over 70 years

FAST | Pipe is ready to weld up to five times quicker than hand cutting and grinding

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 DEARMAN CUTTING

Time: 6 Minutes

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

- | Perfect Cut
- | No Grinding
- | Perfect Fit-up

SADDLE MACHINES | MOTORIZED / MANUAL



MSA

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



1SA

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



2SA

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



3SA

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

MANUAL SADDLE MACHINES

Machine Model	MSA	1SA	2SA
Manual with Spacer Bolts	03.0100.000	03.0101.000	03.0102.000
Manual with Step Spacers	-----	03.01S1.000	03.01S2.000

MOTORIZED SADDLE MACHINES | PLASMASPEED

Machine Model	MSA	1SA	2SA
Motorized with Spacer Bolts 115/230 VAC	03.0100.S01	03.0101.S01	03.0102.S01
Motorized with Step Spacers 115/230 VAC	-----	03.01S1.S01	03.01S2.S01

PLASMASPEED RETROFIT KITS

Machine Model	MSA	1SA	2SA
PLASMASPEED Retrofit Kits 115/230 VAC	03.0100.SA1	03.0101.SA1	03.0101.SA1

GENERAL | SPECIFICATIONS

Machine Model	MSA	1SA	2SA
Pipe Size in (mm)	1.5-4 (38-102)	3-8 (76-203)	6-12 (152-305)
Net Weight lbs / kg	10 / 5	16 / 7	26 / 12
Estimated Shipping Weight lbs / kg	12 / 5.4	24 / 11	34 / 15.5
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)
Max. Speed (Motorized) ipm* / mpm**	141 / 3581	71 / 1803	89 / 2261
Min. Speed (Motorized) ipm* / mpm**	4 / 102	4 / 102	6 / 152
Includes Spacer Bolts to cut pipe sizes	2", 3", 4" (51, 76, 102 mm)	3", 4", 6", 8" (76, 102, 152, 203 mm)	6", 8", 10", 12" (152, 203, 254, 305 mm)

* Inches per minute

** Millimeters per minute



4SA

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



5SA

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



6SA

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



8SA

Pipe Size Range
36" - 48" / 914 mm - 1219 mm

	3SA	4SA	5SA	6SA	8SA
	03.0103.000	03.0104.000	03.0105.000	03.0106.000	03.0108.000
	03.01S3.000	----	----	----	----

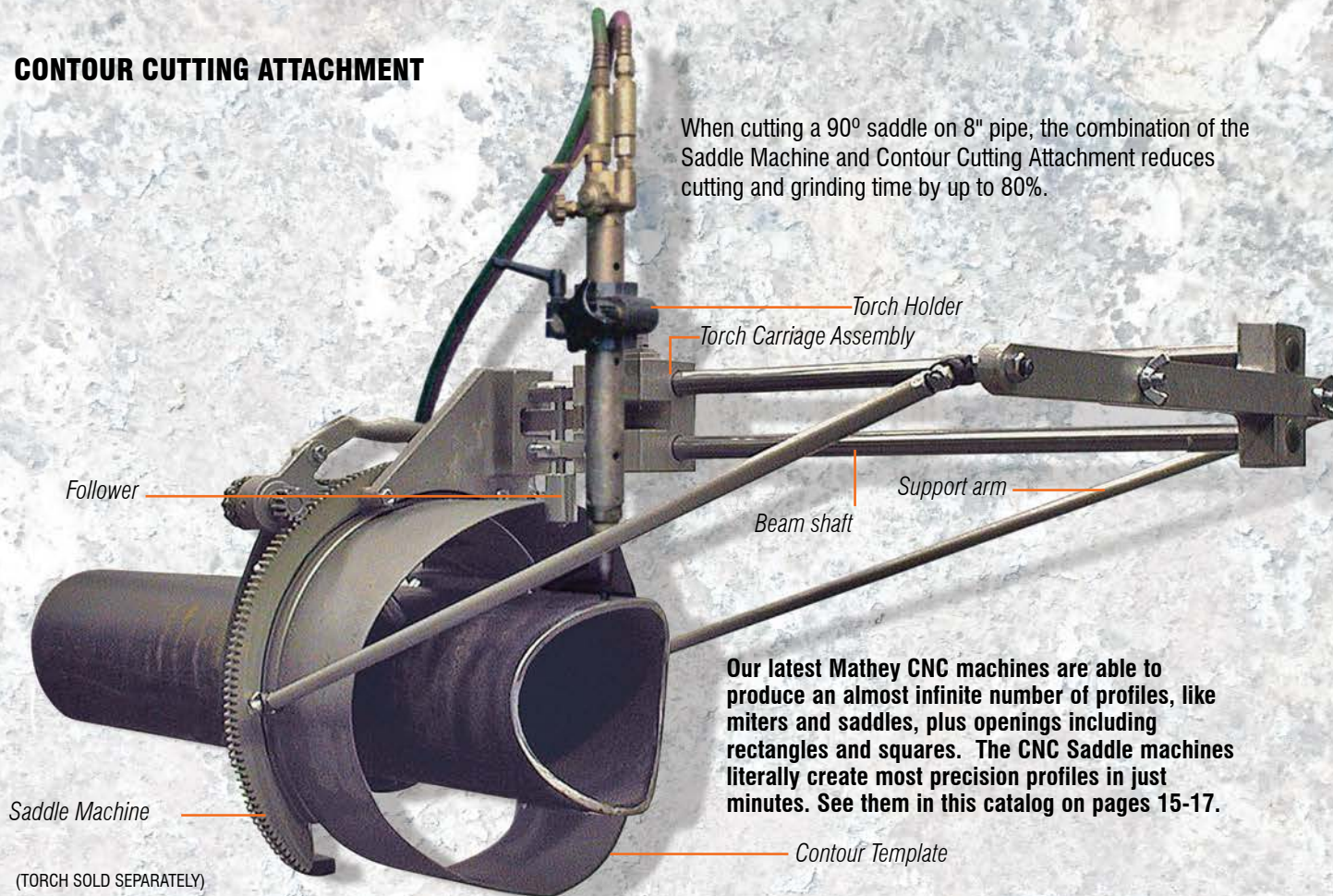
	3SA	4SA	5SA	6SA	8SA
	03.0103.S01	03.0104.S01	03.0105.S01	03.0106.S01	03.0108.S01
	03.01S3.S01	----	----	----	----

	3SA	4SA	5SA	6SA	8SA
	03.0103.SA1	03.0103.SA1	03.0105.SA1	03.0105.SA1	03.0105.SA1

	3SA	4SA	5SA	6SA	8SA
	12-20 (305-508)	20-26 (508-660)	24-30 (610-762)	28-36 (711-914)	36-48 (914-1219)
	50 / 22	75 / 34	110 / 50	180 / 82	287 / 130
	73 / 33	150 / 68	185 / 84	295 / 134	537 / 244
	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)
	47 / 1194	53 / 1346	34 / 864	35 / 889	36 / 914
	7 / 178	7 / 178	8 / 203	5 / 127	5 / 127
	12", 14", 16", 18", 20" (305, 356, 406, 457, 508 mm)	20", 22", 24", 26" (508, 559, 610, 660 mm)	24", 26", 28", 30" (610, 660, 711, 762 mm)	28", 30", 36" (711, 762, 914 mm)	36", 40", 42", 48" (914, 1016, 1067, 1219 mm)

CONTOUR CUTTING ATTACHMENT

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



Our latest Mathey CNC machines are able to produce an almost infinite number of profiles, like miters and saddles, plus openings including rectangles and squares. The CNC Saddle machines literally create most precision profiles in just minutes. See them in this catalog on pages 15-17.

CONTOUR CUTTING ATTACHMENT

Model	Item Numbers	Pipe Size Range in (mm)	Est. Shipping Weight
MSA	03.0116.MSA	1.5 - 4 (38 - 102)	7 lbs / 3 kg
1SA	03.0116.1SA	3 - 8 (76 - 203)	8 lbs / 4 kg
2SA	03.0116.1SA	6 - 12 (152 - 305)	8 lbs / 4 kg
3SA	03.0116.3SA	12 - 20 (305 - 508)	9 lbs / 4 kg
4SA	03.0116.4SA	20 - 26 (508 - 660)	9 lbs / 4 kg
5SA	03.0116.5SA	24 - 30 (610 - 762)	11 lbs / 5 kg
6SA	03.0116.6SA	28 - 36 (711 - 914)	13 lbs / 6 kg
8SA	03.0116.8SA	40 - 48 (1016 - 1219)	16 lbs / 7 kg

SHAPE TEMPLATES

Model	Item Numbers	Est. Shipping Weight
MSA	03.0115.M__	3.5 - 5 lbs / 1.6 - 2.3 kg
1SA	03.0115.1__	4.5 - 6 lbs / 2 - 2.7 kg
2SA	03.0115.2__	6 - 8 lbs / 2.7 - 3.6 kg
3SA	03.0115.3__	11 - 15 lbs / 5 - 7 kg
4SA	03.0115.4__	18 - 27 lbs / 8 - 12 kg
5SA	03.0115.5__	22 - 31 lbs / 10 - 14 kg
6SA	03.0115.6__	27 - 35 lbs / 12 - 16 kg
8SA	03.0115.8__	31 - 40 lbs / 14 - 1 kg

*Includes 32 pitch Torch Holder. Please add the letter "E" at the end of the item number when ordering a Contour Cutting Attachment with a Metric Torch Holder (example: 03.0116.MSAE)

EASY INSTALLATION | Takes just minutes to install

ACCURATE | Shape Templates are precisely designed and manufactured to produce accurate cuts every time

VERSATILE | Works with standard oxy-fuel and plasma torches

FAST | Produce perfect miters and saddles in less than a quarter of the time of hand layout, cutting and grinding

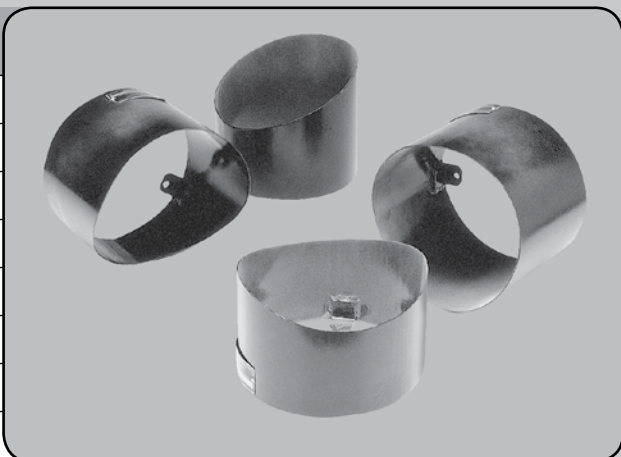
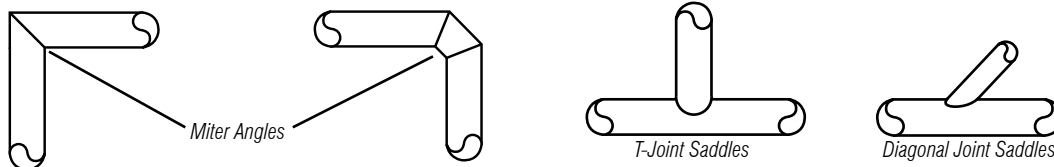
NOTE: CUSTOM DESIGNED SHAPE TEMPLATES AVAILABLE FOR YOUR SPECIFIC APPLICATION INCLUDE MITERS, SADDLES AND DIAGONALS

Saddle and Miter Cutting

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

Please copy this page for use 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.

This form must be filled out and included before we can process your order!



Produce perfect miter and saddle cuts with the easy to use Mathey Dearman Contour Cutting Attachment. Simply choose the Template for the desired type of cut and the torch will follow the Template around the pipe. Contour Cutting Attachments and Templates are available for 1 1/2" – 48" (38 mm – 1219 mm) pipe.

Figure 1

Saddle In
(ID of branch to ID of main)

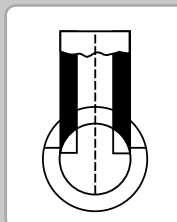
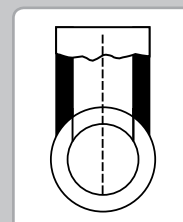


Figure 2

Saddle On
(ID of branch to ID of main)



SADDLE MACHINES | ACCESSORIES

PRO MODEL TORCH ARM

Choose the Pro Model Torch Arm with our innovative Out-of-Round Roller Attachment to create perfect cuts and bevels on oversize, undersize or out-of-round pipe.

MINIMIZES NOTCHING | Torch automatically elevates over pipe weld seams and surface imperfections

SMOOTHER BEVELING | Precise pipe-to-torch distance maintained throughout the cut for more accurate beveling

INTERCHANGEABLE | Use the Pro Model Torch Arm with your current torch holder and adapter for oversized and undersized pipe



Torch holders that can accommodate up to 2" barrel diameter torches are available.

Model	Item Number	Shipping Weight
Pro Model with Out-of-Round Roller Attachment	03.0209.000	9.5 lbs / 4.3 kg
Pro Model Base Unit	03.0209.001	6 - 8 lbs / 2.7 - 3.6 kg
Out-of-Round Roller Attachment Kit	03.0209.003	4.5 - 6 lbs / 2 - 2.7 kg

**Includes 32 pitch Torch Holder. Please add the letter "E" at the end of the item number when ordering a Pro Model Torch Arm with a Metric Torch Holder (example: 03.0209.000E)*

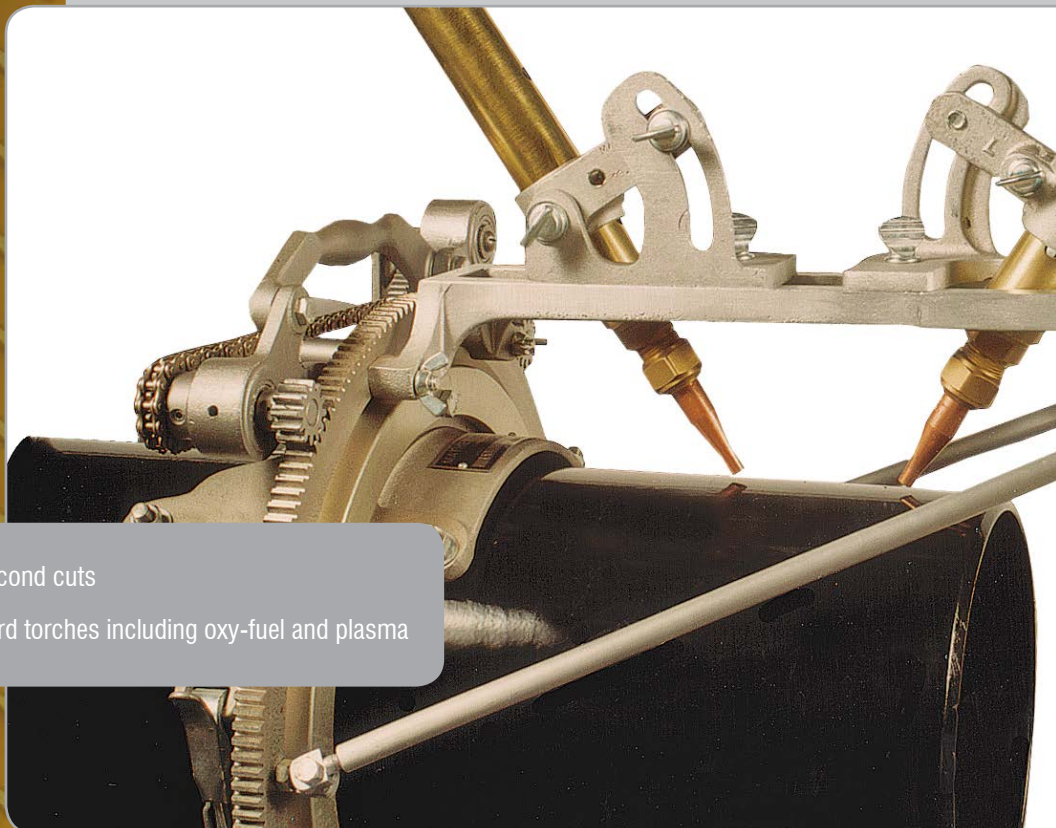
NOTE: MACHINE TORCHES AVAILABLE SEPARATELY. BACK BEVELING NOT RECOMMENDED WITHOUT THE USE OF THE DOUBLE TORCH ARM ACCESSORY.

DOUBLE TORCH ARM

Reduce setup and cutting time by up to 50% with our Double Torch Arm accessory. By eliminating the need to rotate one torch to obtain a forward or back bevel on the pipe end, our Double Torch Arm dramatically reduces cutting and beveling time.

REDUCE EXPENSES | Eliminate second cuts

VERSATILE | Works with all standard torches including oxy-fuel and plasma

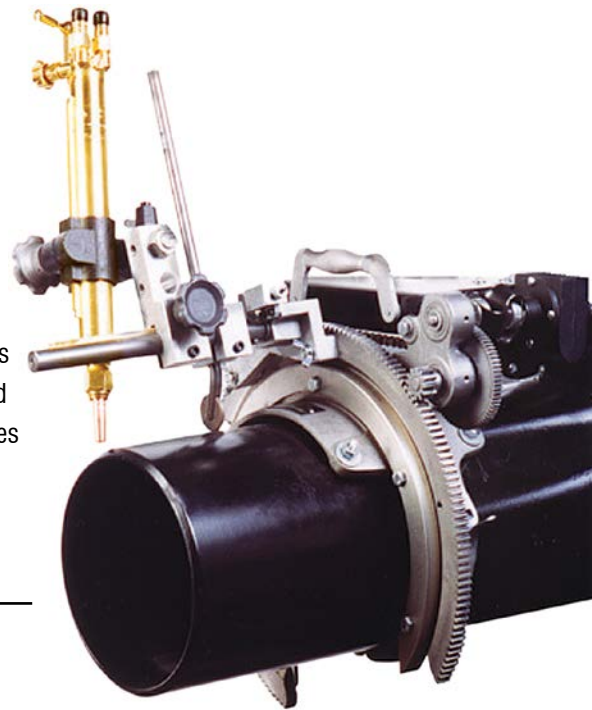


OUT-OF-ROUND ROLLER ATTACHMENT

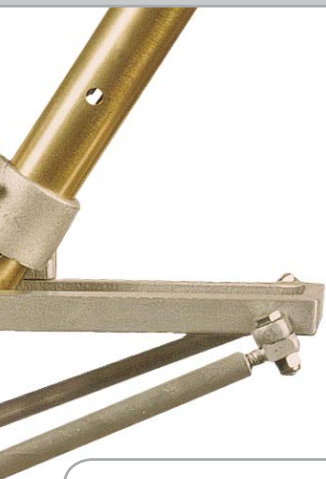
Would you like to add out-of-round compensating capabilities to your current Pro Model Torch Arm?

Our Out-of-Round Roller Attachment Kit compensates for oversize and undersize pipe, handling out-of-round conditions up to 1/4" (6mm). Order separately. Comes with all required parts and assembly instructions.

Pro Model with Out-of-Round Roller Attachment Kit installed

**DOUBLE TORCH ARM ITEM NUMBERS AND SHIPPING WEIGHTS**

Model	With Torch Holder for 1 3/8" (35 mm) Diameter Torch	Est. Shipping Weight
1SA	03.0101.030	5 lbs / 2.3 kg
2SA	03.0102.015	5 lbs / 2.3 kg
3SA	03.0103.030	5 lbs / 2.3 kg
4SA	03.0104.021	5 lbs / 2.3 kg
5SA	03.0105.025	5 lbs / 2.3 kg
6SA	03.0106.018	5.5 lbs / 2.5 kg
8SA	03.0108.014	5.5 lbs / 2.5 kg

**CAM-ADJUSTABLE TORCH CARRIER**

Our Cam-adjustable Torch Carrier makes it simple to make perfect, no-notch cuts, every time. Just start the cut away from the desired cut line, use the knurled cam adjustment knob to move the torch into the cut line then start your cut. In addition, the Torch Holder's large wing screw makes tightening the torch in the Torch Holder easy, even when wearing gloves. Our innovative design even allows forward or back-beveling without the need to reverse the Torch Holder in the Torch Arm.

Item : 03.0100.052

SELF-STORING STEP-DOWN SPACER

Combining multiple Spacer Bolt sizes into one easy-to-use part, our Step-down Spacers are machined to the same tolerances as Spacer Bolts. Each Step Spacer covers a range of four (4) pipe sizes; eliminating the need to store twelve (12) Spacer Bolts. No more searching for lost or misplaced Spacer Bolts with high quality aluminum alloy or stainless steel self-storing Step-down Spacers.



STEP SPACER KIT

Description	Item Number	For Pipe Sizes		Est. Shipping Weight
		in	mm	
1SA Step Spacers	03.0110.1SAKIT	3, 4, 6, 8	76, 102, 152, 203	1.6 lbs / .7 kg
2SA Step Spacers	03.0110.2SAKIT	6, 8, 10, 12	152, 203, 254, 305	1.6 lbs / .7 kg
3SA Step Spacers	03.0110.3SAKIT	12, 14, 16, 18, 20	305, 356, 406, 457, 508	1.6 lbs / .7 kg

STEP SPACERS (INDIVIDUAL)

Description	Item Number	For Pipe Sizes		Est. Shipping Weight
		in	mm	
1SA Step Spacer	03.0110.1SA	3, 4, 6, 8	76, 102, 152, 203	0.4 lbs / 0.2 kg
2SA Step Spacer	03.0110.2SA	6, 8, 10, 12	152, 203, 254, 305	0.4 lbs / 0.2 kg
3SA Step Spacer	03.0110.3SA	12, 14, 16, 18, 20	305, 356, 406, 457, 508	0.4 lbs / 0.2 kg

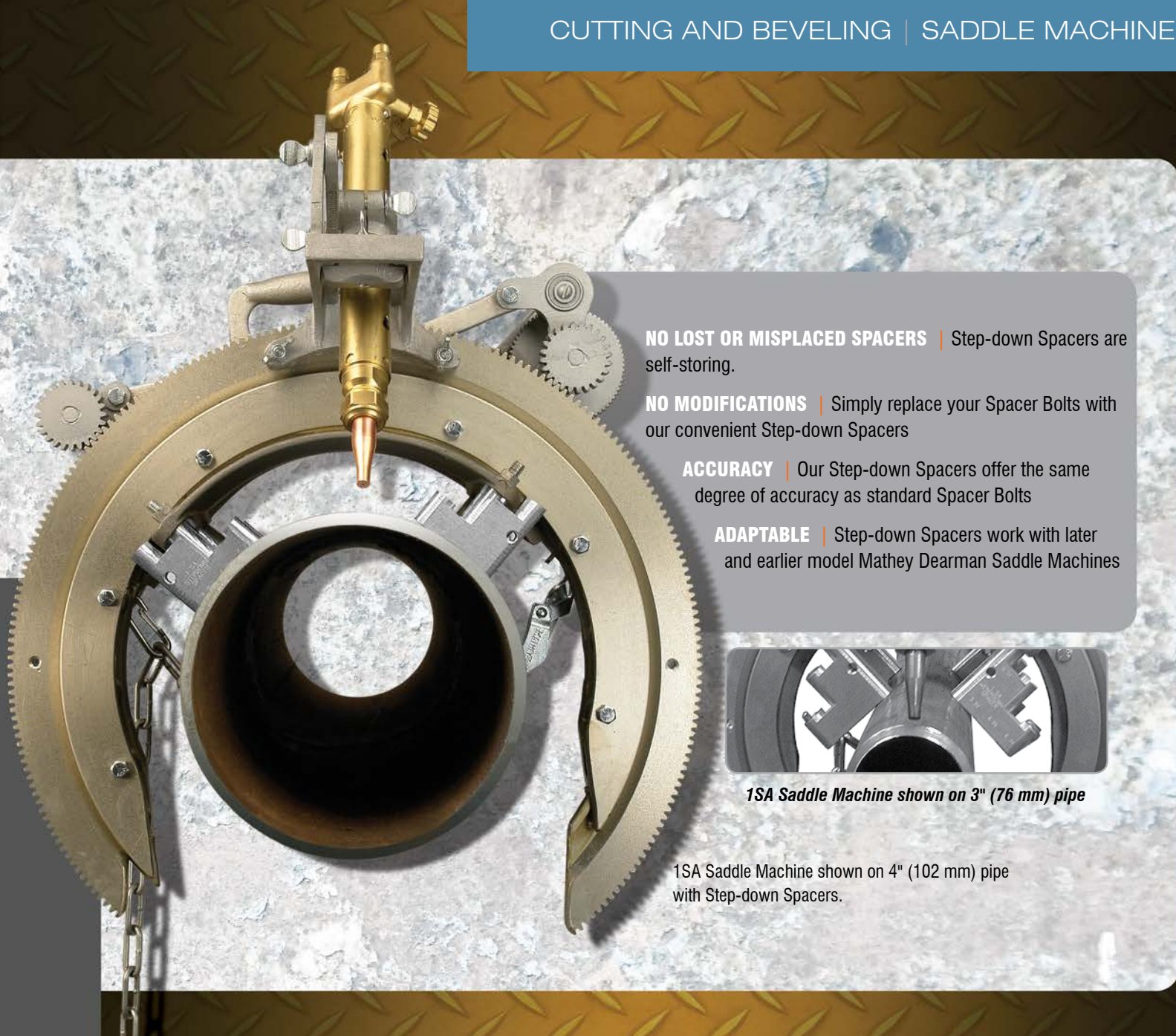


SADDLE MACHINE SPACER BOLTS

Our Spacer Bolt Kits include the Spacer Bolts available for any Mathey Dearman Saddle Machine model in one handy container. An actual-size diagram is located on the lid, making finding the correct Spacer Bolts quick and easy. All Spacer Bolts are precision-machined for maximum cutting accuracy and labeled with the Mathey Dearman logo and item number for quick identification.

Spacer Bolts can be replaced individually or in sets.

Actual size is shown on box lid for quick spacer bolt identification.



NO LOST OR MISPLACED SPACERS | Step-down Spacers are self-storing.

NO MODIFICATIONS | Simply replace your Spacer Bolts with our convenient Step-down Spacers

ACCURACY | Our Step-down Spacers offer the same degree of accuracy as standard Spacer Bolts

ADAPTABLE | Step-down Spacers work with later and earlier model Mathey Dearman Saddle Machines



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

1SA Saddle Machine shown on 4" (102 mm) pipe with Step-down Spacers.

SPACER BOLT KITS

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

SADDLE MACHINES | ACCESSORIES

SADDLE MACHINE STORAGE BOX

To help protect your valuable investment, store your Saddle Machine, Torch, Torch Arm, Torch Carrier, Spacer Bolts and Parts and Operating Manual in this specially-designed Storage Box. MSA, 1SA, and 2SA Storage Boxes are made of 16 gauge, powder-coated steel, with attached lifting handles. Storage Boxes for Saddle Machines larger than the 2SA are made of plywood with reinforced corners and edges. STORAGE BOXES ARE SPECIFICALLY DESIGNED TO PROTECT MACHINES DURING TRANSPORTATION AND STORAGE

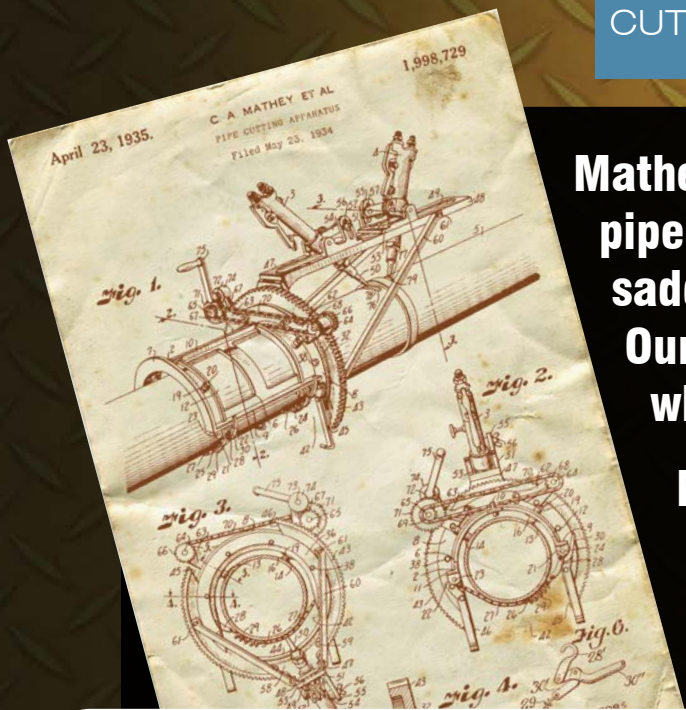


PROTECT YOUR INVESTMENT | Our heavy-duty Storage Boxes are specifically designed for transportation and storage

STAY ORGANIZED | Plenty of room to conveniently store accessories and Spacer Bolts when not in use



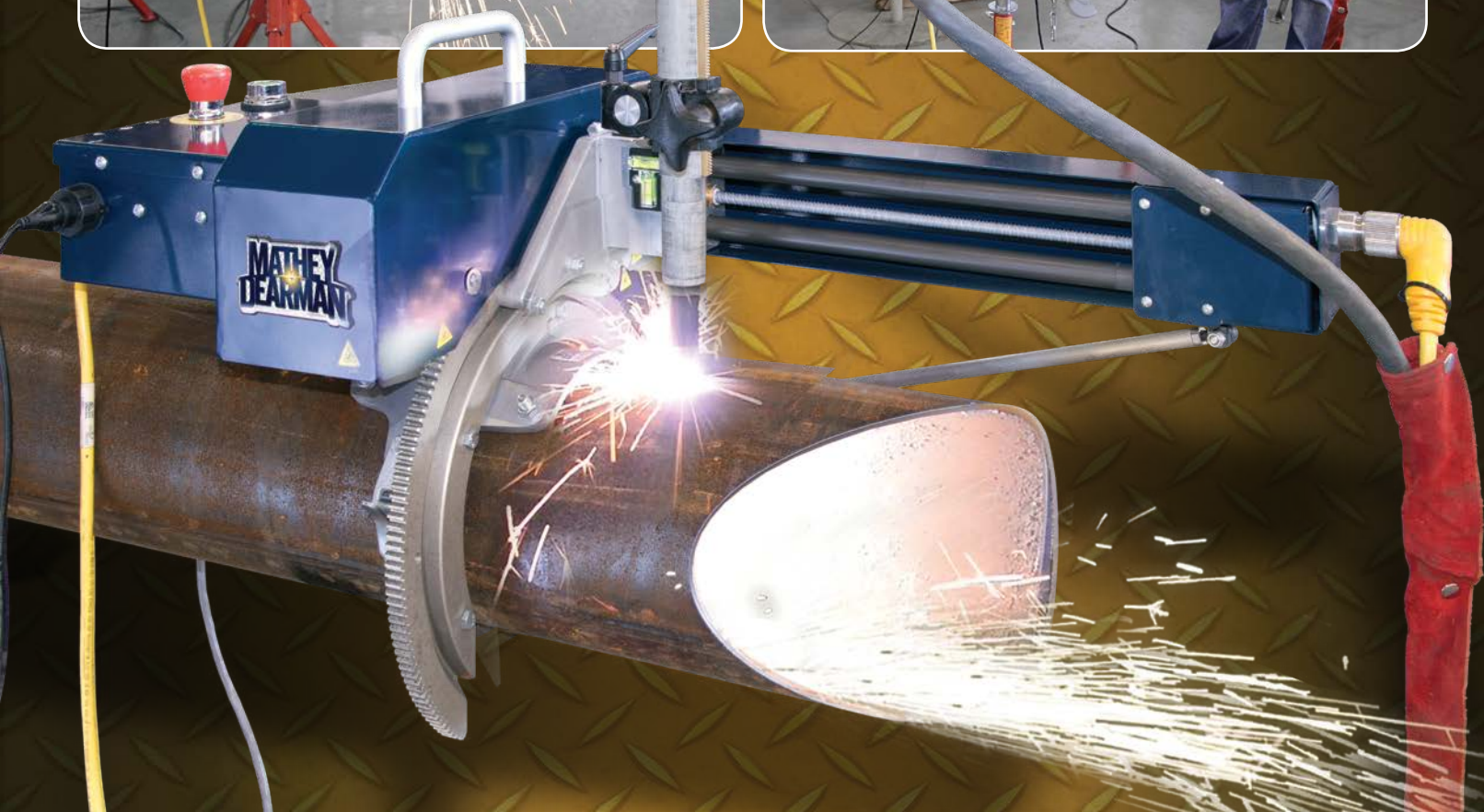
Model	Item Number	Dimensions in (mm)	For Manual or Motorized	Box Type	Est. Shipping Weight
MSA	03.0100.BOX	17 x 17 x 17 (432 x 432 x 432)	Manual Only	METAL	23 lbs / 11 kg
1SA	03.0101.BOX	20 x 18 x 17 (205 x 457 x 432)	Manual Only	METAL	33 lbs / 15 kg
2SA	03.0102.BOX	25 x 22 x 18 (635 x 559 x 457)	Manual Only	METAL	41 lbs / 19 kg
3SA	03.0103.BOX	34 x 34 x 14 (864 x 864 x 356)	Manual or Motorized	WOOD	60 lbs / 27 kg
4SA	03.0104.BOX	40 x 38 x 14 (1016 x 965 x 356)	Manual or Motorized	WOOD	75 lbs / 34 kg
5SA	03.0105.BOX	42 x 40 x 14 (1067 x 1016 x 356)	Manual or Motorized	WOOD	75 lbs / 34 kg
6SA	03.0106.BOX	56 x 48 x 16 (1422 x 1219 x 406)	Manual Only	WOOD	175 lbs / 79 kg
8SA	03.0108.BOX	70 x 56 x 19 (1778 x 1422 x 483)	Manual Only	WOOD	250 lbs / 102 kg



Mathey has been the leader in pipe cutting since we invented the saddle machine in 1934. Our new CNC Saddle Machines prove what the professionals know...

Mathey continues to set the standard!

Our CNC Saddle Machines are truly designed to be field portable.



We've taken the industry's most trusted pipe cutting machines and made them...well, smarter.



For decades, CNC pipe profiling has been reserved for folks with big budgets, spare shop floor space and lots of time for training. Thanks to our amazingly simple and affordable CNC Saddle Machines, those days are long gone. With the industry's most trusted pipe cutting and beveling machines as their foundation, we've engineered a compact 2-axis pipe profiling system that performs like a big stationary machine, but without the complexity or cost. Lightweight enough to be mounted and operated by one person, three models of machines cover pipe sizes ranging from 1½" to 12". Mathey CNC machines are able to produce an almost infinite number of profiles, like miters and saddles plus openings including rectangles and squares. Compared to time and material wasting manual methods, our CNC machines literally create precision profiles in just minutes. When not in use, storage and transportation are safe and secure thanks to the rugged molded HPDE case with custom-designed foam insert that is included with each machine. CNC Saddle Machines perform well with either oxy/fuel or plasma machine torches and require only standard 115 or 230-volt power to operate.

SIMPLE | Icon-driven laptop control screens let users follow an intuitive cut selection process; *no programming required*

COMPREHENSIVE | Literally millions of cuts available including the ability to utilize custom shapes (Contact Mathey CNC support for details and pricing)

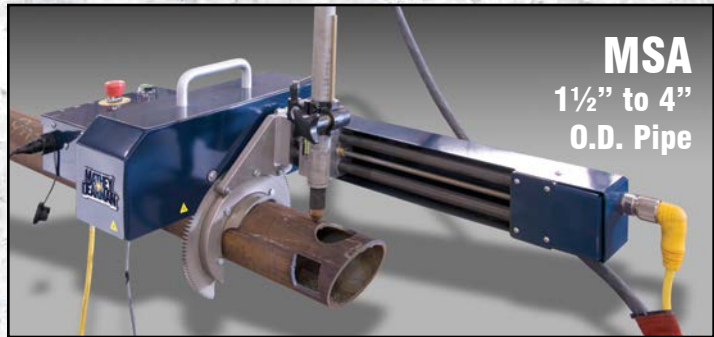
COMPACT | Portable design means no permanent installation or dedicated shop space necessary

ADAPTABLE | Works with standard machine torches, including plasma

RUGGED | Based on our proven and reliable Saddle Machines with industrial-grade electronics and cabling

CNC Saddle Machines Include:

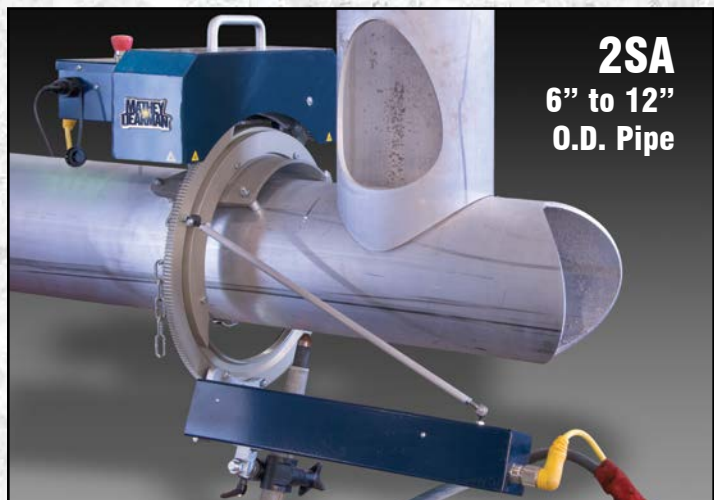
- 115/230 VAC CNC Saddle Machine Base Unit
- Lead Screw Assembly
- Torch Holder Assembly
- Boomer Assembly
- Industrial Grade Automation Connector Cable
- Spacer Bolt Set
- Parts and Operating Manual
- Computer to Machine Industrial USB Cable
- 15' Power Supply Cable
- Mathey CNC Software (USB Memory Stick) for Windows®
- HDPE Shipping and Storage Case w/ Custom Foam Insert



MSA
1½" to 4"
O.D. Pipe



1SA
3" to 8"
O.D. Pipe



2SA
6" to 12"
O.D. Pipe

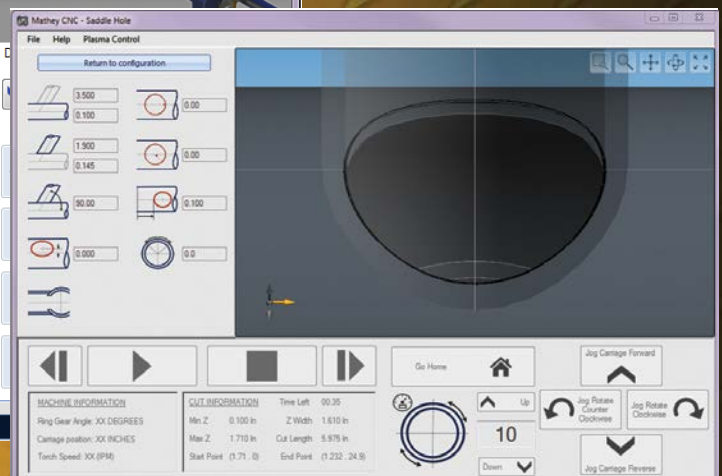
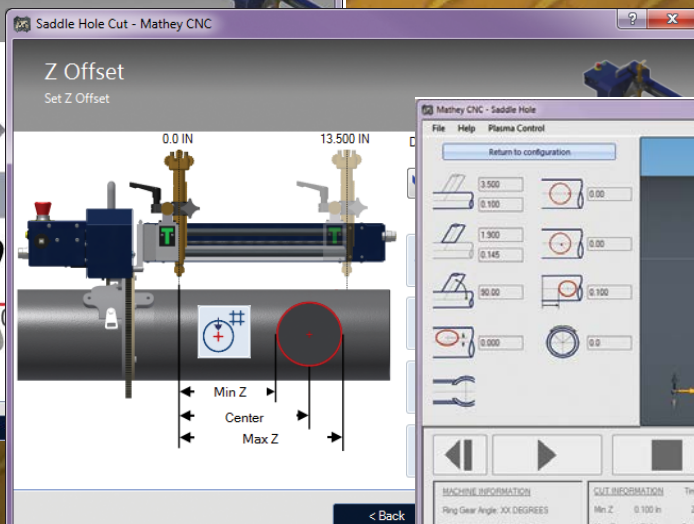
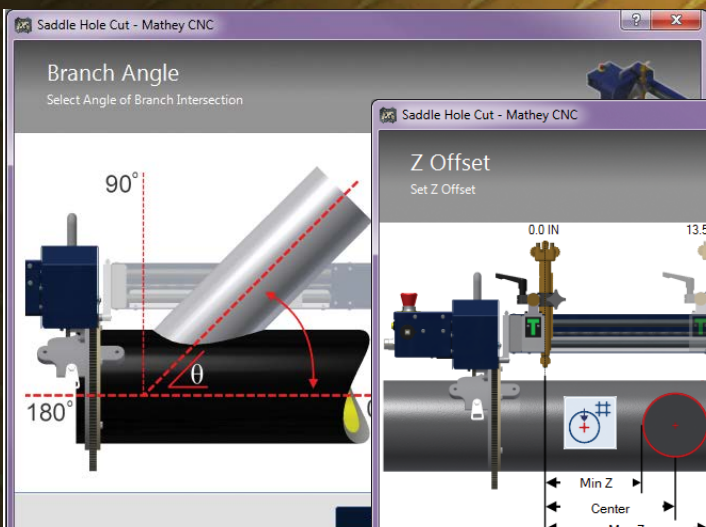
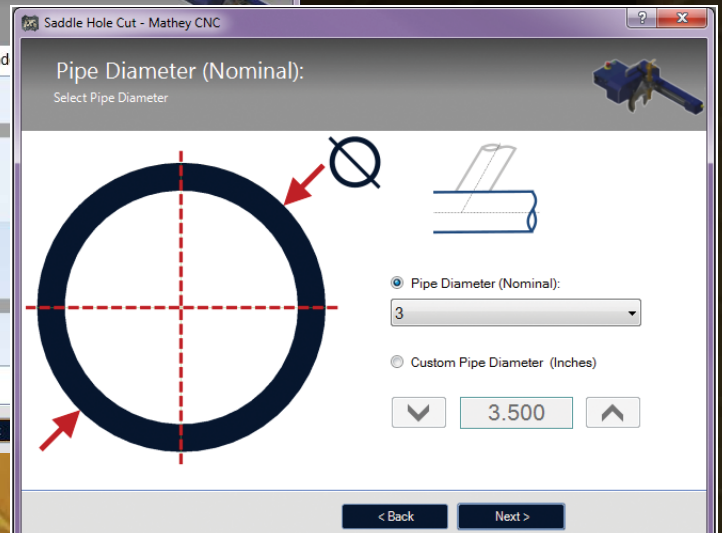
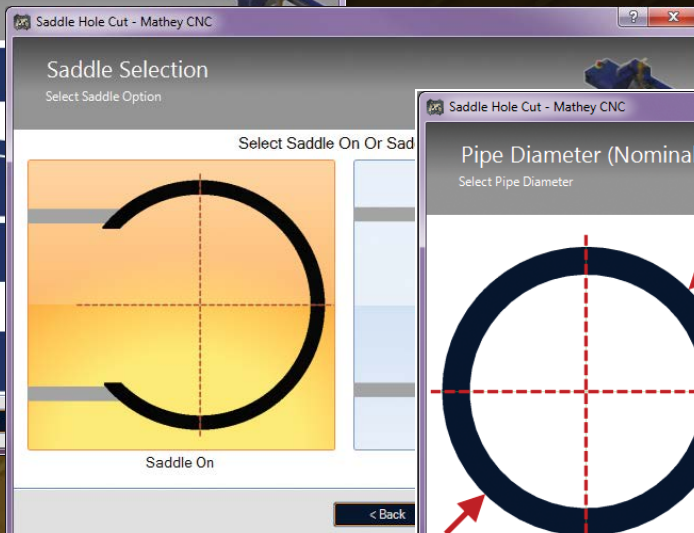
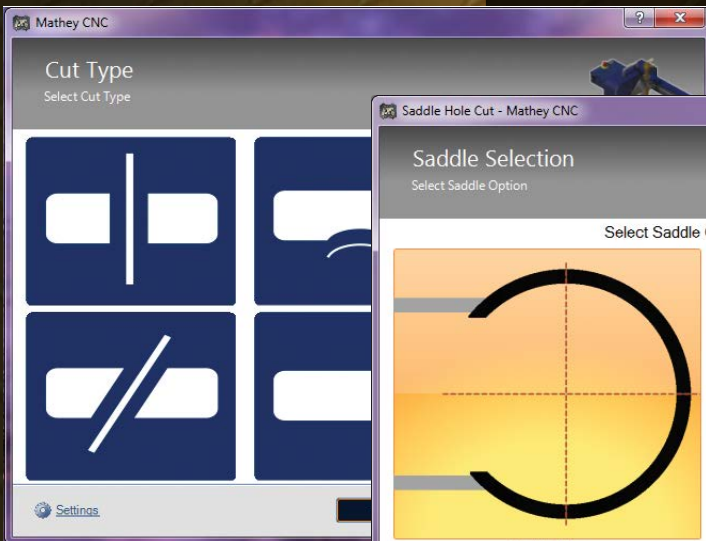
Item Number	Model	Pipe Sizes (NPS)
03.0117.MSA	MSA	1½, 2, 2½, 3, 3½, 4
03.0117.1SA	1SA	3, 3½, 4, 5, 6, 8
03.0117.2SA	2SA	6, 8, 10, 12
03.0117.SET	All 3 Above	1½ thru 12
03.0117.000	Software Only	All Models



Innovative pipefitter-friendly software interface:

Step-by-step software gives you complete control

- Operates on a common Windows laptop
- Simple icon-driven control screens
- Step-by step cut selection process
- Requires little to no training, set up and make cuts in minutes
- Dynamic on-screen display of cut
- Cutting speed can be user controlled during cut
- Automatic storage of previous cuts
- Multiple cut sequencing for automating common tasks
- Plasma torch auto-fire and stop control



JOLLI CHAIN MACHINES

MINI JOLLI CHAIN MACHINE

Extremely rugged yet lightweight, the Mini Jolli is our most popular chain cutting and beveling machine. Recommended for cutting a very broad range of pipe and vessels, the Mini Jolli Chain Machine easily adjusts from one pipe size to the next, precisely following the outside pipe diameter to produce a consistent bevel. The Mini Jolli's unique, compact design delivers exceptional performance and accurate results. Cuts pipe diameters 2" (51 mm) and larger.

BEST CHOICE | For small shop or maintenance facility

BEST MACHINE | For multiple pipe diameters

FASTER | Up to 50% faster than hand cutting and grinding

ACCURATE | Two wheel positions, Double Row Chain and available Guide Track ensure precision cutting and beveling

SIMPLIFIED SETUP | With MagSwitch Magnets

ITEM NO. 05.0520.000
TORCH SOLD SEPARATELY

Mini Jolli Chain Machine Includes:

- | Base machine
- | Torch Arm
- | Service Keys
- | Sliding Support
- | Hose Support
- | Rack-adjustable Torch Holder
- | Parts and Operating Manual

Optional Accessories:

- | Cotter Pin Drive Chain
- | Machine cutting torch
- | Storage box
- | Out-of-Round Roller Attachment
- | Guide Track

NOTE: FOR MAXIMUM CUTTING AND BEVELING ACCURACY THE USE OF OUR OPTIONAL GUIDE TRACK IS RECOMMENDED FOR PIPE OR VESSELS 18 INCHES (457 MM) IN DIAMETER AND LARGER.



MINI JOLLI | OPTIONS & ACCESSORIES

MINI JOLLI OPTIONS |

TORCH HOLDER | Your choice of either a 32-pitch or a metric Torch Holder for a 1 3/8" (35 mm) diameter machine torch

PLASMASPEED MOTORIZED MODEL | Choosing a 110/230 VAC Plasmaspeed motorized machine significantly reduces grinding

DRIVE CHAIN KITS | Convenient double-coated Drive Chain sold separately for all standard pipe and tubing sizes (custom sizes on request)

CONTOUR CUTTING ATTACHMENT | Creates highly accurate saddle and shallow miter angles requiring little or no grinding

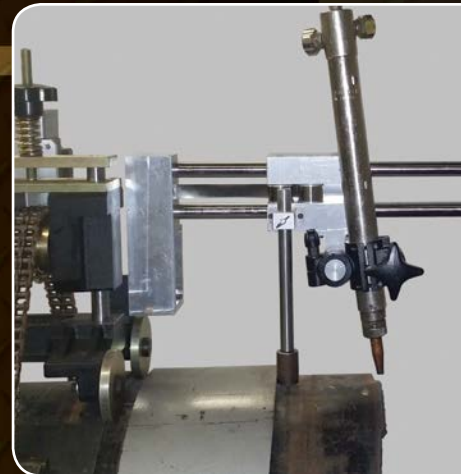


MINI JOLLI ACCESSORIES |

DUAL TORCH HOLDER | 2nd torch holder support and torch holder available for increased productivity

GUIDE TRACK | Fast setup for more accurate cutting of large pipe and vessel diameters above 18". Individual sections available to extend Guide Track range

REMOTE DRIVE CABLE | 9' (2.7M) and 14' (4.3M) flexible drive cables for remote operation



TORCHES & TIPS | Mathey Dearman offers a wide variety of torches and tips for all types of cutting gases

OUT-OF-ROUND ROLLER ATTACHMENT | keeps torch at constant height above pipe, minimizing notching when crossing a weld seam



MAGSWITCH Magnets
are now standard with all
MINI JOLLI CHAIN MACHINES



MINI JOLLI

Model	Item Number	Est. Ship. Weight
Manual Mini Jolli	05.0520.000	34 lbs / 15.4 kg
Plasmaspeed Mini Jolli, 110/230 VAC	05.0520.S01	42 lbs / 18.9 kg
PLASMASPEED Retrofit Kit, 110/230 VAC	05.0520.SA1	18 lbs / 8.1 kg

**Includes 32-pitch torch holder. Add an I to the end of the item number shown to order a Mini Jolli with a metric torch holder.*

The available Out-of-Round Roller Attachment minimizes pipe notching when crossing a weld seam.

MINI JOLLI CHAIN MACHINE | ACCESSORIES



DOUBLE-ROW COTTER PIN CHAIN

Move quickly from one pipe size to another with our Double-row Cotter Pin Chain designed for the Mini Jolli Chain Machine. Simply remove the cotter pins to add or remove sections of chain. Every link is a master link.

MINI JOLLI DRIVE CHAINS

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

Visit our website at www.mathey.com, under Support, for our Drive Chain Length Calculator.



MOTORIZING KITS

Upgrade your current Mini Jolli Chain Machine with our PLASMASPEED motorizing kit for even faster and more accurate cutting and beveling. This easy to install kit takes just minutes to add. Available in 110/230 VAC.



SLIDING SUPPORT AND TORCH HOLDER |

Add a second sliding support and torch holder giving your Jolli Chain Machine the ability to bevel both sides of the cut line simultaneously.

ITEM NO. 05.0510.114 • 05.0510.117



REMOTE CABLE DRIVE |

Operate your Jolli Machine remotely when cutting large diameter pipe by attaching our flexible Drive Cable. Cable available in lengths of 9' (2.7m) and 14' (4.3m).

9' ITEM NO. 05.0510.FDC | 14' ITEM NO. 05.0520.FD14



HEAVY DUTY STORAGE BOX |

Perfect for shipping and storing your Mathey Dearman Jolli Chain Machine, this rugged box is constructed from steel with a durable powder coat finish.

MINI JOLLI: ITEM NO. 05.0520.BOX



OPTIONAL TORCH HOLDER FOR PLASMA TORCH |

Elevates the Mini Jolli Torch Holder to the correct position for use with plasma torches.

ITEM NO. 05.0510.301



ADAPTER FOR PLASMA TORCH HOLDERS |

Adapts customer-supplied torch holders to Mathey Dearman Mini Jolli Chain Machines.

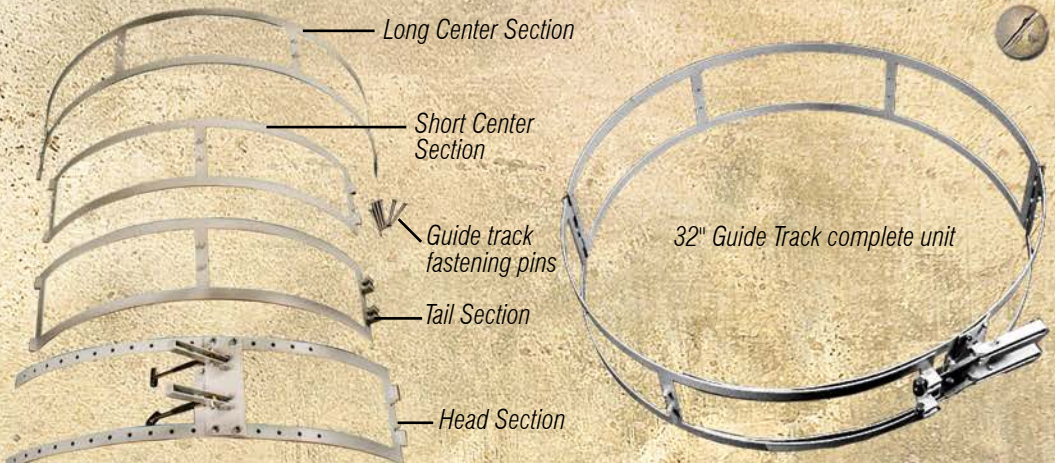
ITEM NO. 05.0510.302



Track components can be added and removed as needed when changing pipe diameters and are sold in four main sections:

GUIDE TRACKS

Mini Jolli Guide Tracks ensure optimum cut accuracy and fit-up while reducing set-up time up to 20%. Guide Tracks are designed for use on horizontal and vertical pipes 18" (457 mm) and larger, and are required when using the Contour Cutting Attachment.



Guide Track insures precise square cuts on 18" (457 mm) and larger pipes.

GUIDE TRACK ORDERING GUIDE

NOTE: EACH SECTION INCLUDES TWO (2) PINS

Model	Head Section	Tail Section	Short Center Section	Long Center Section
Mini Jolli	05.0520.013B	05.0520.013D	05.0520.013C	05.0521.013A
Weight (lbs / kg)	4.7 / 2	3.6 / 1.6	3.2 / 1.5	4.3 / 2
Pipe Range in (mm)	Guide Track Section(s) 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	1
18 - 72 (1674 - 1829)	1	1	2	2

For pipe sizes larger than 72" (1828 mm) contact the Mathey Dearman sales department for assistance in selecting the correct Guide Track components.

JOLLI CHAIN MACHINE | ACCESSORIES

Accessory Description	Item Number	Est. Shipping Weight
PLASMASPEED Mini Jolli Retrofit Kit, 110/230 VAC	05.0520.SA1	18 lbs / 8.1 kg
Sliding Support for 2nd Torch	05.0510.114	1 lbs / .5 kg
1 3/8" (35 mm) Torch Holder with 32-pitch pinion	05.0510.117	.7 lbs / .3 kg
1 3/8" (35 mm) Torch Holder with metric pinion	05.0510.117E	.7 lbs / .3 kg
9' (274 cm) Flexible Remote Drive Cable	05.0510.FDC	12 lbs / 5.4 kg
14' (427 cm) Flexible Remote Drive Cable	05.0510.FD14	15 lbs / 6.8 kg
Out-of-Round Roller Attachment	05.0520.300	7 lbs / .3 kg
Storage Box	05.0520.BOX	28 lbs / 12.7 kg
Plasma Adapter - customer supplied torch	05.0510.301	2 lbs / 1 kg
Plasma Adapter - elevates Mini Jolli Torch Holder	05.0510.302	4 lbs / 2 kg
15' Extension Cord (USA Model only)	03.0203.020	1.2 lbs / 0.5 kg
Protective Leather Sleeve for power cord (recommended)	05.0550.SLV	1.5 lbs / 0.7 kg

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

BAND CRAWLER CUTTING AND BEVELING MACHINES



Manual Band Crawler Includes:

- | Adjustable-height Torch Carrier
- | 9' (2.7 M) or 14' (4.3 M) Flexible Drive Cable
- | Parts and Operating Manual

NOTE: MACHINE TORCH AND TORCH ANGLE HEAD ADAPTER SOLD SEPARATELY

MOTORIZED PLASMASPEED BAND CRAWLER



PRECISE | Band conforms precisely to the out-of-round condition of the pipe to maintain consistent cutting tip distance from pipe surface

SIMPLE | One person can set up and cut horizontal or vertical pipes as large as 48" (1219 mm)

LOW PROFILE | Requires as little as 10 ½" (267 mm) of radial clearance

ONE SIZE FITS ALL | One Band Crawler fits all Band sizes

FAST | 60% faster than hand cutting and grinding

MOTORIZED | Available with PlasmaSpeed Digital Motor Control



BAND CRAWLER | POPULAR ACCESSORIES

TORCH ANGLE HEAD ADAPTER | Allows the torch tip to be adjusted for any angle from a square cut (no bevel) to a bevel angle up to 90 degrees while also allowing torch lead or lag angle adjustment.

ITEM NO. 05.0500.003



RIGHT ANGLE DRIVE ADAPTER | Permits the Flexible Drive Cable to pivot 180 degrees on the end of the Band Crawler, lowering the profile of the Crawler to 6" (153 mm).

ITEM NO. 05.0116.030



The ideal solution for cutting and beveling in close quarters, our Band Crawler requires as little as 6" (153 mm) of clearance around the pipe. Install the stainless steel Band anywhere on the pipe and it conforms to the pipe shape, producing a consistent precise bevel, even on severely out-of-round pipe. Our lightweight Band Crawler can be quickly set up and operated by one person on pipe as large as 60" (1524 mm). Bands 48" (1219 mm) and larger feature a standard stiffening rib which simplifies one-person set-up.

BAND CRAWLER OPTIONS

PLASMASPEED MOTORIZING KITS | Variable-speed 110/230 VAC.

FLEXIBLE MANUAL DRIVE CABLE | 9' (2.7m) length for pipe diameters up to 30" or 14' (4.3m) length for pipe diameters over 30"

BETTER BANDS | Bands for all sizes of pipe and vessels 6" (152 mm) and larger (see next page)

The Motorized PLASMASPEED Band Crawler can increase cutting and beveling efficiency of large diameter pipes up to 60% and is the quickest and easiest cutting tool to set up on vertical pipe.

BAND CRAWLER MODELS

Model	Item Number	Est. Shipping Weight
Band Crawler with 9' (2.7m) Flexible Drive Cable	05.0116.009	26 lbs / 11.7 kg
Band Crawler with 14' (4.3m) Flexible Drive Cable	05.0116.014	30 lbs / 14 kg
Motorized PLASMASPEED Band Crawler 110/230 VAC	05.0116.S01	26 lbs / 11.7 kg
PLASMASPEED Retro fit kit 110/230 VAC	05.0116.SA1	26 lbs / 11.7 kg



DRIVE CABLE | Enables the motorized Band Crawler to be retrofitted to manual operation. Available in 9' (2.7m) and 14' (4.3m) lengths.

ITEM NO. 05.0116.022 ITEM NO. 05.0116.031



RACK ADJUSTABLE TORCH ARM | Allows both horizontal and vertical adjustment of the torch in relationship to the pipe surface.

ITEM NO. 05.0116.032



DOUBLE TORCH ARM | Makes two cuts and bevels simultaneously, reducing cutting time and labor.

ITEM NO. 05.0116.039



BAND CRAWLER CUTTING AND BEVELING MACHINES | PARTS AND ACCESSORIES



Bridge the Gap

Our Famous Band Crawler's Band...Just Got Even Better

- No more special sized bands, Better Bands Bridge the Gap – Up to 3 times more GAP allowance than any other Band on the market
- Patented “Staggered” Latching System for improved setup
- Ensures maximum traction for the beveling machine, maintaining 3 points of contact at all times
- Industry leading GAP allowance allows one size to work on Coated or Out of Round Pipe
- Consistent speed and travel of Beveling machine equals improved cut quality
- MADE IN USA

BETTER BANDS

Pipe Size in (mm)	Item Number	Est. Shipping Weight
6" (152 mm)	05.0204.006	5 lbs / 2 kg
8" (203 mm)	05.0204.008	6 lbs / 3 kg
10" (254 mm)	05.0204.010	7 lbs / 3 kg
12" (305 mm)	05.0204.012	7 lbs / 3 kg
14" (356 mm)	05.0204.014	11 lbs / 5 kg
16" (406 mm)	05.0204.016	12 lbs / 5 kg
18" (457 mm)	05.0204.018	14 lbs / 6 kg
20" (508 mm)	05.0204.020	16 lbs / 7 kg
22" (559 mm)	05.0204.022	17 lbs / 8 kg
24" (610 mm)	05.0204.024	18 lbs / 6 kg
26" (660 mm)	05.0204.026	20 lbs / 9 kg
28" (711 mm)	05.0204.028	22 lbs / 10 kg
30" (762 mm)	05.0204.030	25 lbs / 11 kg
32" (813 mm)	05.0204.032	26 lbs / 12 kg
34" (864 mm)	05.0204.034	27 lbs / 12 kg
36" (914 mm)	05.0204.036	29 lbs / 13 kg
38" (965 mm)	05.0204.038	31 lbs / 14 kg
40" (1016 mm)	05.0204.040	33 lbs / 15 kg
42" (1067 mm)	05.0204.042	36 lbs / 16 kg
44" (1118 mm)	05.0204.044	39 lbs / 18 kg
46" (1168 mm)	05.0204.046	43 lbs / 20 kg
48" (1219 mm)	05.0204.048	90 lbs / 41 kg
50" (1270 mm)	05.0204.050	92 lbs / 42 kg
52" (1321 mm)	05.0204.052	96 lbs / 44 kg
54" (1372 mm)	05.0204.054	100 lbs / 45 kg
56" (1422 mm)	05.0204.056	106 lbs / 48 kg
58" (1473 mm)	05.0204.058	110 lbs / 50 kg
60" (1524 mm)	05.0204.060	115 lbs / 52 kg

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

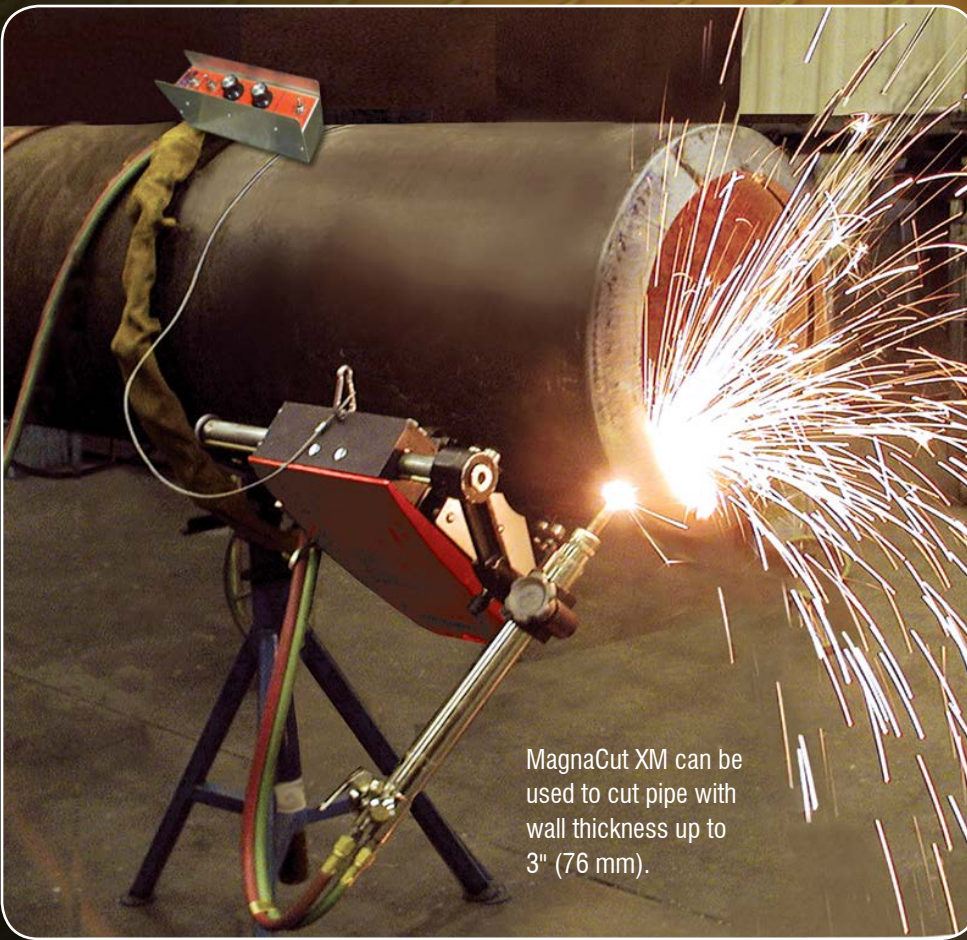
BAND CRAWLER ACCESSORIES

Item/ Assembly Description	Item Number	Est. Shipping Weight
PLASMASPEED Retro fit kit 110/230 VAC	05.0116.SA1	26 lbs / 11.7 kg
Rack-Adjustable Torch Arm	05.0116.032	3 lbs / 1.4 kg
Double Torch Arm	05.0116.039	4 lbs / 1.8 kg
Right Angle Drive Adapter (for Drive Cable)	05.0116.030	2 lbs / .9 kg
Torch Angle Head Adapter	05.0200.003	1.2 lbs / .5 kg
Protective Leather Cable Sleeve	05.0550.SLV	1.5 lbs / .7 kg

BAND CRAWLER REPLACEMENT PARTS

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

MAGNACUT XM PIPE/PLATE CUTTER & WELDER



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

MAGNACUT XM

Featuring a variable-response Motorized Torch Arm, the revolutionary MagnaCut XM cuts, bevels, and welds steel pipe and steel plate without chains, clamps, or other devices. Generating 300 pounds of magnetic force, powerful rare earth magnets in the wheels secure the MagnaCut XM to pipe and plate with a coating of up to .015" (.4 mm) thick. Cuts materials with wall thicknesses up to 3" (76 mm).

Each weld or cut is controlled remotely by the handheld Motor Control Box, keeping the operator a safe distance away and allowing the MagnaCut XM to work in hard-to reach locations such as overhead and on vertical pipes.

The MagnaCut XM works with all standard torches including oxy-fuel and plasma, tracking perfectly straight on steel plate when used with 1" x 1" x 1/8 (25mm x 25mm x 3mm) angle as a guide track.

MagnaCut XM Includes:

- | MagnaCut XM machine
- | 115 VAC Motor Control Box
- | Motorized Torch Arm
- | Torch Holder
- | Torch Support
- | Hose Support
- | Safety Strap – 74" (1880 mm) for up to 24" (610 mm) pipe
- | Snap Hooks (2)
- | Service Keys
- | Storage Box
- | Protective Leather Cable Sleeve
- | Parts and Operating Manual

NOTE: MACHINE TORCH SOLD SEPARATELY.

MINIMUM SET-UP | Ready to operate in minutes

VERSATILE | Cuts pipe, plate, walls and overheads

SAFE | Remote control allows operator to work a safe distance from the pipe

STRONG | Rare-earth magnets hold the MagnaCut XM to the pipe surface with 300 pounds of force

FAST | Up to 80% faster than cutting by hand; cuts or welds up to 40" (1016 mm) per minute

WARNING: 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" (44 mm) OR 2 1/2" (64 mm) BARREL PLASMA TORCHES. MAGNACUT XM IS NOT DESIGNED FOR CUTTING SPIRAL WELDED PIPE. ALWAYS SECURE THE MAGNACUT XM TO THE PIPE WITH A SAFETY STRAP. A SAFETY STRAP SHOULD ALSO BE USED IN CONJUNCTION WITH GUIDE TRACKS.

PERSONS WEARING A PACEMAKER SHOULD NOT COME IN CONTACT WITH THIS EQUIPMENT. PLEASE CONTACT MATHEY DEARMAN PRIOR TO ATTEMPTING ANY APPLICATION NOT LISTED IN THIS CATALOG.

MAGNACUT XM AND ACCESSORIES

Model	Item Number	Est. Shipping Weight
MagnaCut XM, 115 VAC	05.0550.000XM	60 lbs / 27 kg
230-115 VAC Step-Down Transformer	01.0759.008	5.5 lbs / 2.5 kg



ITEM NO. 05.0550.000XM

GUIDE TRACK | For even greater cutting accuracy, a Guide Track can be used to cut pipe or plate with the MagnaCut XM. 1" x 1" x 1/8" (25 mm x 25 mm x 3 mm) thick angle iron can be rolled to fit a specific diameter of pipe, cutting it into two (2) sections and then bolting it together.

MOTOR CONTROL BOX

MagnaCut XM Motor Control Box |

The Motor Control Box allows for precise speed, forward and reverse control of the MagnaCut XM. The Torch Arm Toggle Switch on the Motor Control Box is spring loaded for accurate location of the cutting or welding torch during use.



MagnaCut XM can be used on pipe with coating up to 0.015" (0.4 mm) thick.

MAGNACUT XM TECHNICAL SPECIFICATIONS

Description	MagnaCut XM
Method of Attachment to Pipe or Plate	Rare Earth Magnets
Magnetic Pull per Wheel Assembly	150 lbs / 68 kg
Maximum Pipe Coating Thickness	Up to 15 mils or .015" / .4 mm thick.
Set-up Time	2 Minutes or less
Cutting Range (Pipe O.D.)	6 5/8" / 168 mm and larger
Cutting Range (Pipe I.D.)	24" / 610 mm and larger
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" / 51 mm per Minute
Maximum Speed	40" / 1016 mm per Minute
Net Weight	37 lbs / 16.7 kg
Shipping Dimensions	24 1/2" x 8 7/8" x 19 1/2" " / 622 x 225 x 495 mm
Machine Dimensions	
Width (Torch Arm Extended)	17" / 432 mm
Length	14" / 356 mm
Height	5 1/4" / 133 mm
Electrical Requirement	115 VAC or 230 VAC (with Transformer)

MAGNACUT XM APPLICATIONS

Among the most versatile machines we sell, the MagnaCut XM can carry either plasma or oxy-fuel torches vertically or horizontally. It also serves as an excellent and flexible platform for difficult to reach welding projects.



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



The MagnaCut XM cuts pipe with inside diameters of 24" (610 mm) and larger.



Vertical or horizontal I-beam 20" (508mm) wide or wider can be precision cut with the MagnaCut XM



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



Pipe diameters 16" (406 mm) and larger can be cut lengthwise.



Mathey Dearman can custom manufacture Guide Tracks for 18" (457 mm) and larger pipe.

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" (35 mm) torch holder supplied with the MagnaCut XM. With its precise variable-speed drive, the MagnaCut XM can carry a welding torch to create perfect welds on a wide variety of surfaces and material thicknesses.

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



MagnaCut XM comes standard with roller guides that can be used to track on 1" X 1" X 1/8" (25 mm x 25 mm x 3 mm) angle iron for even greater vertical or horizontal welding and cutting accuracy.





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

Item No. 05.0510.301



Torch Elevation Adapter for Non-Mathey Dearman Torch Holder:
 Designed to adapt to torch holders other than supplied with MagnaCut XM. Torch and Torch Rack sold separately.

Item No. 05.0510.302

MAGNACUT XM PARTS AND ACCESSORIES

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

MAGNACUT XM GUIDE TRACK

Pipe Diameter in (mm)	Item Number	Est. Shipping Weight
18 (457)	05.0550.218	6 lbs / 3 kg
20 (508)	05.0550.220	7 lb s/ 3 kg
24 (610)	05.0550.224	8 lbs / 4 kg
28 (711)	05.0550.228	8.5 lbs / 4 kg
30 (762)	05.0550.230	9 lbs / 4 kg
32 (813)	05.0550.232	10 lbs / 5 kg
36 (914)	05.0550.236	11 lbs / 5 kg
42 (1067)	05.0550.242	13 lbs / 6 kg
48 (1219)	05.0550.248	15 lbs / 7 kg

CONTACT OUR SALES DEPARTMENT FOR LARGER O.D. AND I.D. GUIDE TRACKS

MINIMAG XM PIPE/PLATE CUTTER & WELDER

MINIMAG XM

Like the MagnaCut XM, the versatile MiniMag XM is an excellent tool for cutting, beveling, and welding. It requires minimum set-up time and secures to work surfaces with 300 pounds of magnetic force. The MiniMag XM can be used with plasma or oxy-fuel torches, but unlike the larger MagnaCut XM, does not offer a motorized torch arm. The MiniMag XM cuts pipe and plate with a coating up to .015" thick, and will cut materials with wall thicknesses up to 3" (76 mm). The MiniMag XM can also make flawless welds on steel plate and other flat surfaces, with travel speeds from 2" to 40" (51 mm to 1016 mm) per minute.



- | 115 VAC or 230 VAC MiniMag XM Machine
- | Storage Box
- | Motor Control Box
- | Torch Arm
- | Torch Holder
- | Sliding Support
- | Safety Cable fits up to 24" (610 mm) pipe
- | Snap Hooks (2)
- | Cable Latch
- | Protective Leather Cable Sleeve
- | Parts and Operating Manual

NOTE: MACHINE TORCH SOLD SEPARATELY.

QUICK | Sets up and is ready to cut in minutes

VERSATILE | Makes horizontal and vertical cuts, bevels plate and pipe at angles to 45 degrees

FLEXIBLE | Works with all standard torches (including plasma)

PRECISE | Meets even the most exacting cutting specifications

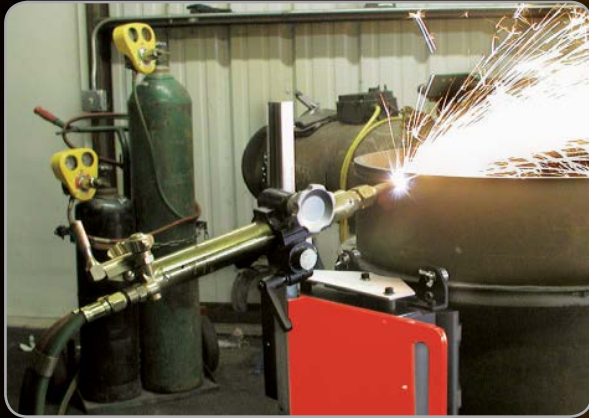
FAST | Up to 80% faster than cutting by hand

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

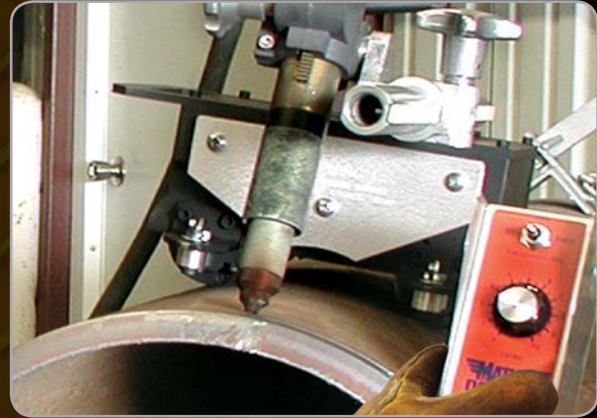
Persons wearing a Pacemaker should not come in contact with this equipment.

MINIMAG XM AND ACCESSORIES

Model	Item Number	Est. Shipping Weight
MiniMag XM, 115 VAC	05.0550.MINIXM	39 lbs / 17.6 kg
MiniMag XM, 230 VAC	05.0550.MINIXM2	39 lbs / 17.6 kg



Cutting and welding on vertical pipe and plate is accomplished safely and with ease when the MiniMag XM is used with an optional Guide Track.



The ability to precisely control cutting speed helps the MiniMag XM and a plasma torch create perfect cuts and bevels that require little or no grinding.

MINIMAG XM TECHNICAL SPECIFICATIONS

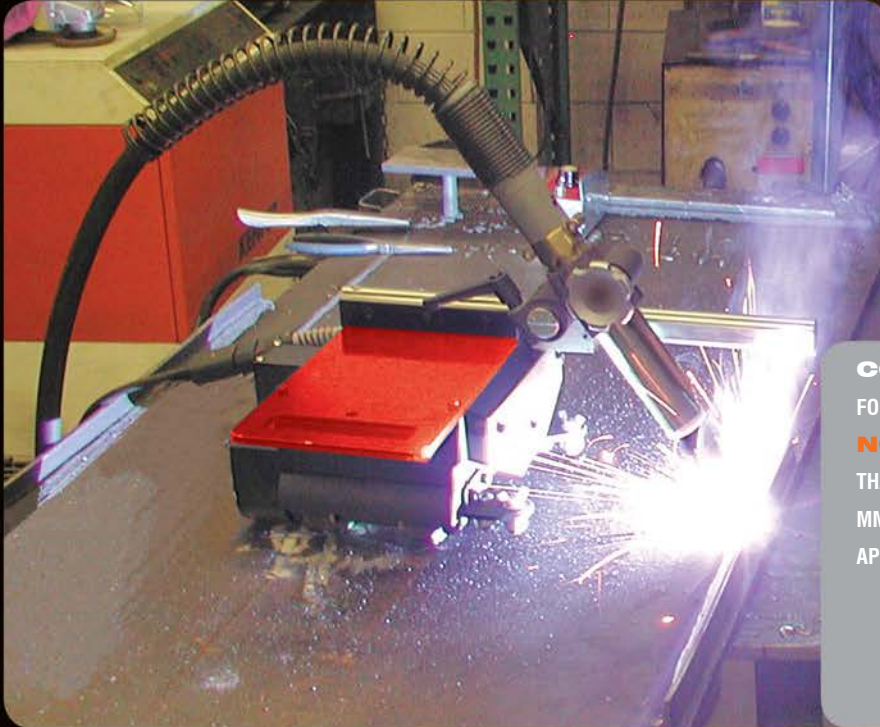
Description	
Method of Attachment	Rare Earth Magnets
Holding Force	150 lbs / 68 kg per Wheel Assembly 300 lbs (136 Kg) Total
Set Up Time	2 Minutes or less
Minimum Cutting Range	O.D. - 6 5/8" / 168 mm I.D. - 24" / 610 mm
Minimum Speed	2" / 51 mm per minute
Maximum Speed	40" / 1016 mm per minute
Net Weight	31 lbs / 14 kg
Shipping Dimensions	24" x 8 7/8" x 19 1/2" / 622 x 255 x 495 mm
Dimensions	
Width	17" (432 mm)
Length	13" (330 mm)
Height	9" (229 mm)
Electrical Requirement	115 VAC or 230 VAC



Custom Storage Box included

MINIMAG XM PIPE/PLATE CUTTER & WELDER

MINIMAG XM WELDING



In addition to perfect cuts and bevels, the MiniMag XM can make flawless welds on steel plate and other flat surfaces, moving at speeds from 2" to 40" (51 mm to 1016 mm) per minute. The machine is remotely controlled by the handheld Motor Control Box, keeping the operator a safe distance from the work.

CONTACT MATHEY DEARMAN TECHNICAL SALES FOR DETAILS ON WELDING WITH THE MINIMAG XM

NOTE: THE MINIMAG XM IS EQUIPPED WITH GUIDES THAT CAN BE USED WITH 1" X 1" X 1/8" (25 MM X 25 MM X 3 MM) ANGLE IRON FOR VERTICAL WELDING APPLICATIONS



OXY-FUEL ACCESSORY: TORCH SHUT-OFF VALVE

Our Torch Shut-Off Valve allows the operator, with a simple flip of a switch, to shut-off gas flow to the torch without changing the oxygen and fuel settings. Inlets and outlets are 9/16"-18 hose thread.

ITEM NO. 05.0200.014



Model	Item Number
Torch Shut-off Valve	05.0200.014
Y - Connector #101 W/O Valve	05.0200.015
Oxygen Hose (Green) w/FTGS End	05.0200.016
Fuel Gas Hose (Red) w/FTGS End	05.0200.017



Getting the right cut and bevel requires the right torch and tip. Uniweld's professional grade torches and accessories are available in all standard diameters and fuel types. They can handle any size pipe or working conditions and they are made right here in the USA.

SELECTING THE RIGHT TORCH

Machine torch selection depends on the machine type and pipe diameter. The Mathey Dearman sales staff is well-trained and ready to answer your questions, if you need help. Just pick up the phone or email us at sales@mathey.com

TORCH, 6" BARREL



TORCH, 10" BARREL



TORCH ANGLE HEAD ADAPTOR



TORCHES & PARTS	Item Number	GAS	Barrel Dia. Inch - mm	Barrel/Tip Length Inch - mm	Cutting Capacity Inch - mm
TORCH, 6" BARREL MACHINE	05.0500.001	OAC	1 3/8 - 35	6 - 172	7 - 178
TORCH, 10" BARREL MACHINE	05.0500.002	OAC	1 3/8 - 35	10 - 254	7 - 178
TORCH ANGLE HEAD ADAPTOR	05.0200.024	All			
TORCH RACK 32 PITCH	05.0500.004				

UNIWELD TORCH TIPS	Item Number	Metal Thickness
UNIWELD TIP 1-101-1	05.0501.001	3/4"
UNIWELD TIP 1-101-2	05.0501.002	1" - 1 1/2"
UNIWELD TIP 1-108-1	05.0501.003	3/4"
UNIWELD TIP 1-101-3	05.0501.004	2" - 2 1/2"
UNIWELD TIP 1-101-5	05.0501.007	4" - 5"
UNIWELD TIP GPN-00	05.0501.010	1/4"
UNIWELD TIP GPN-0	05.0501.011	3/8" - 1/2"
UNIWELD TIP GPN-1	05.0501.013	3/4"
UNIWELD TIP GPN-2	05.0501.014	1" - 1 1/2"
UNIWELD TIP 1-200-1	05.0501.018	3/4"
UNIWELD TIP 1-101-00	05.0501.021	1/4"
UNIWELD TIP GPN-3	05.0501.022	2" - 2 1/2"
UNIWELD TIP 1-108-2	05.0501.025	1" - 1 1/2"
UNIWELD TIP 1-108-3	05.0501.026	2" - 2 1/2"
UNIWELD TIP 1-112-2	05.0501.032	1" - 1 1/2"

1-101 Styles



1-108 Styles



1-112 Styles



1-200 Styles



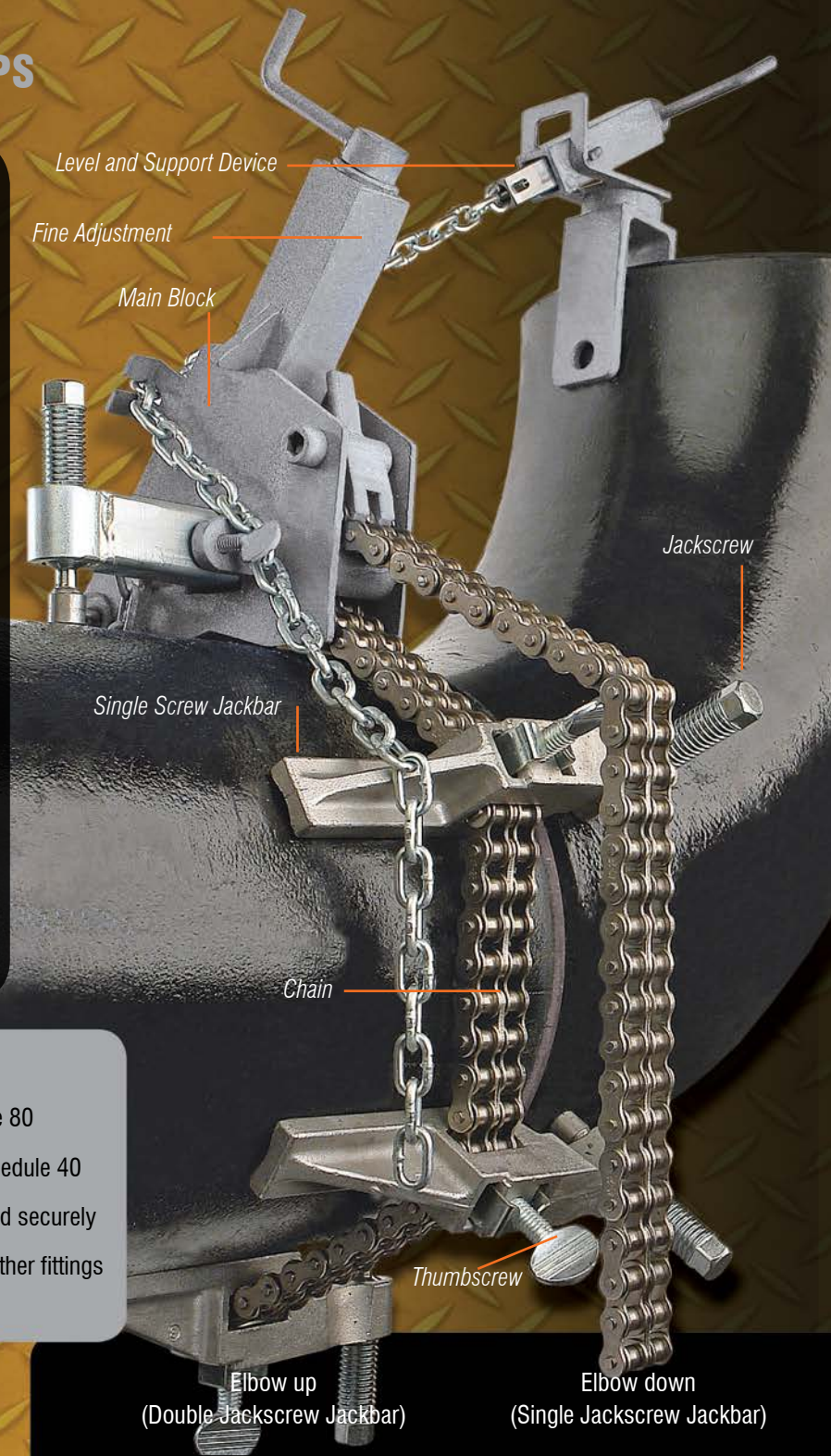
GPN Styles



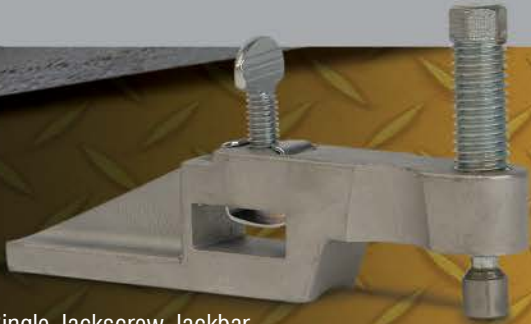
ALIGNING & REFORMING CLAMPS

SINGLE JACKSCREW CHAIN CLAMP

The Single Jackscrew Chain Clamp reforms the mating side of the weld gap and is capable of reforming up to Schedule 40 pipe.* Each jackbar is equipped with its own jackscrew to exert pressure on the high points of the mating pipe, eliminating “High-Low” as pipe and fittings are aligned. Pipe with wall thickness to Schedule 80 can be aligned with the Single Jackscrew Chain Clamp.* The Level and Support Device of the Chain Clamp allows elbows, tees, flanges and other fittings to be held safely and securely for alignment and welding. The Single Jackscrew Chain Clamp is available in nickel plated carbon steel chain and stainless steel chain versions to fit pipe from 1” to 54” (25 mm to 1372 mm) in diameter. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should always be used for stainless steel and specialty alloy applications to avoid potential contamination.

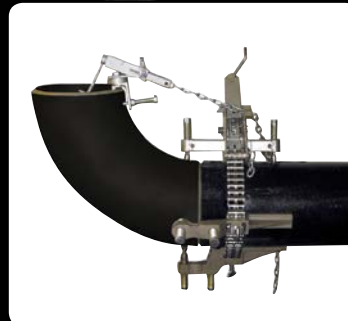


- ACCURATE** | Aligns within 1/64" (.4 mm) of an inch
- HEAVY DUTY** | Aligns pipe with wall thickness to Schedule 80
- STRONG** | Reforms mating pipe with wall thickness to Schedule 40
- SAFER** | Level and Support Device holds fittings safely and securely
- VERSATILE** | Aligns and reforms pipe, elbows, tees and other fittings

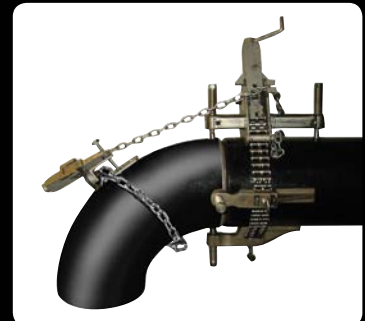


Single Jackscrew Jackbar

THE SINGLE JACKSCREW CHAIN CLAMP SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.



Elbow up
(Double Jackscrew Jackbar)



Elbow down
(Single Jackscrew Jackbar)

Single Jackscrew Chain Clamp Includes:

- | Nickel plated carbon steel or stainless steel duplex roller chain
- | Stainless steel Single Jackscrew Jackbars, quantity as indicated in specifications
- | Stainless steel Main Block
- | Stainless steel Level and Support Device
- | Jackscrew Breaker Bar with Socket
- | Heavy-duty Storage Box
- | Parts and Operating Manual

Single Jackscrew Chain Clamp Benefits:

- | One Chain Clamp covers the range of 8 cage clamps
- | Pipe and fittings can be fully welded with clamp in place
- | Jackscrew contact points swivel to protect against marring the pipe
- | Optional Spacing Screws available to assist in setting weld gap
- | An add-on Jackbar can be added when additional reforming pressure is needed.

The Single Chain Clamp reduces fatigue as elbows, tees and other fittings can be held easily in place while being accurately aligned with the Level and Support Device.

SINGLE JACKSCREW CHAIN CLAMP | SPECIFICATIONS

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

*Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch / 3,164 kg per square centimeter

SS - Indicates clamp includes stainless steel chain. All clamps equipped with stainless steel Jackbars, Jackscrews, and Main Blocks.

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch

NOTE: MATHEY DEARMAN CHAIN CLAMPS CAN BE RECONFIGURED FOR STAINLESS STEEL AND OTHER SPECIALTY ALLOY APPLICATIONS. REPLACE THE CARBON STEEL ROLLER CHAIN WITH STAINLESS STEEL CHAIN. (ALL OTHER COMPONENTS OF CHAIN CLAMPS ARE MADE OF STAINLESS STEEL)

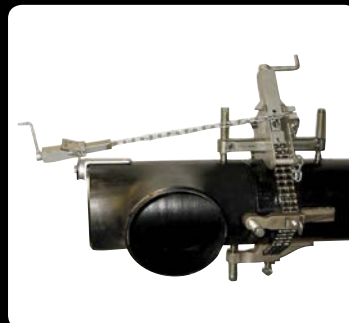
Cross-tee horizontal
(Single Jackscrew Jackbar)



Cross-tee vertical
(Single Jackscrew Jackbar)



Tee in-line
(Single Jackscrew Jackbar)



Pipe to pipe horizontal
(Single Jackscrew Jackbar)



ALIGNING & REFORMING CLAMPS

DOUBLE JACKSCREW CHAIN CLAMP

Mathey Dearman's Double Jackscrew Chain Clamp reforms Schedule 40 pipe on either side of the joint to be welded. It is also able to exert pressure on the high points of both sides to eliminate "Hi-Low." The Chain Clamp's Level and Support Device allows the pipe, elbow, tee, flange and other fittings to be held securely in place during alignment and welding. Pipe with wall thicknesses up to Schedule 80 can be aligned with the Double Jackscrew Chain Clamp. Mathey Dearman Double Jackscrew Chain Clamps are available in carbon steel chain and stainless steel chain versions to fit pipe from 1" to 54" (25 mm to 1372 mm) in diameter. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination.

EXTRA WELDING CLEARANCE | Jackbar design provides additional clearance, so the weld can be easily completed with clamp in place

PRECISE ALIGNMENT | Double Jackbars spaced around the diameter of the pipe allow reforming on both sides of joint to within 1/64" (.4mm)

HEAVY DUTY | Aligns pipe with wall thickness up to Schedule 80

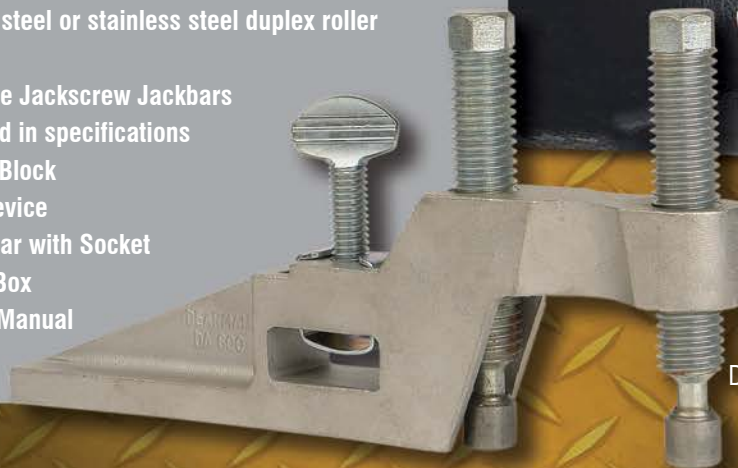
STRONG | Reforms pipe with wall thickness to Schedule 40

WIDE RANGE | Support, align, and reform elbow, tees, and other fittings that cage clamps can't; one Chain Clamp covers the range of 8 cage clamps

VERSATILE | With the standard Level and Support Device, the clamp can be configured to align, reform and support almost any type of fitting for welding

Double Jackscrew Chain Clamp Includes:

- | Nickel plated carbon steel or stainless steel duplex roller chain
- | Stainless steel Double Jackscrew Jackbars - quantity as indicated in specifications
- | Stainless steel Main Block
- | Level and Support Device
- | Jackscrew Breaker Bar with Socket
- | Heavy-duty Storage Box
- | Parts and Operating Manual



Double Jackscrew Jackbar

Fine Adjustment

Main Block

Duplex Roller Chain

Thumbscrew

Jackscrews

WARNING: THE DOUBLE JACKSCREW CHAIN CLAMP SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.

Level and Support Device

Universal Jackbar

Double Jackscrew Jackbar



DOUBLE JACKSCREW CHAIN CLAMP | SPECIFICATIONS

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

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,164 kg per square centimeter)
 SS - Indicates clamp Includes stainless steel chain. All clamps are equipped with stainless steel Jackbars, Jackscrews, and Main Blocks.

ALIGNING & REFORMING CLAMPS

DEARMAN STURDI-CLAMP

D235-SC

Fine Adjustment

Main Block

The Mathey Dearman STURDI-CLAMP is ideal for Schedule 40 & below pipe alignment and reforming. Lighter weight than the original Mathey Dearman Chain Clamps, Dearman STURDI-CLAMPS are quick and easy to set up while still providing the ability to get excellent fitups on pipe from 1" to 36" (25 mm to 914 mm) diameter. Dearman STURDI-CLAMPS are available in carbon steel chain or stainless steel chain versions. ALL Mathey Dearman STURDI-CLAMPS feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination. Dearman STURDI-CLAMPS have the same Quality as all Mathey Dearman products but at a lesser cost than our Heavy Duty Clamping models.

PRECISE ALIGNMENT | Jackbars, spaced around the diameter of the pipe allow for precise alignment of joint

QUALITY | Same proven quality as other Dearman chain clamps

WIDE RANGE | One Chain Clamp covers a wide range of pipe sizes

STRENGTH | Aligns & Reforms pipe with wall thickness to Schedule 40

Dearman STURDI-CLAMP Includes:

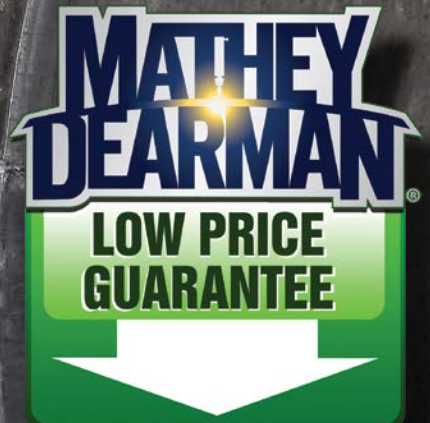
- | Nickel plated carbon steel or stainless steel duplex roller chain
- | Stainless steel Single or Double Jackscrew Jackbars - quantity as indicated in specifications
- | Stainless steel Main Block
- | Jackscrew Breaker Bar & Socket
- | Heavy-duty Storage Box*
- | Parts and Operating Manual

***NOTE:** D231-SC AND D231-SCSS CLAMPS DO NOT INCLUDE LEVEL AND SUPPORT DEVICE OR HEAVY-DUTY STORAGE BOX

WARNINGS: STURDI CLAMPS SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.

Thumbscrew

Duplex roller chain



**D231-SC**

MATHEY DEARMAN STURDI-CLAMP CHAIN CLAMP

Model	Number of Jackbars	Pipe Size Range in (mm)	Reforms Pipe to Schedule*	Jackbar Type	Est. Shipping Weight
D231-SC**	5	1-12 (25-305)	40	Single	13 lbs / 6 kg
D231-SCSS**	5	1-12 (25-305)	40	Single	13 lbs / 6 kg
D249-SC	7	4-20 (102-508)	40	Double	36 lbs / 16.2 kg
D249SCSS	7	4-20 (102-508)	40	Double	36 lbs / 16.2 kg
D235-SC	10	6-36 (152-914)	40	Double	90 lbs / 40.5 kg
D235-SCSS	10	6-36 (152-914)	40	Double	90 lbs / 40.5 kg

*Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,168 kg per square centimeter)

SS - INDICATES CLAMP IS FOR STAINLESS STEEL APPLICATION. ** DOES NOT INCLUDE LEVEL AND SUPPORT DEVICE OR STORAGE BOX.

NOTE: COMPLETE WELDING OF THE JOINT CAN BE ACCOMPLISHED WITHOUT REMOVING THE CLAMP. AN ADDITIONAL JACKBAR CAN BE INSTALLED IF PRESSURE NEEDS TO BE APPLIED BETWEEN THE CLAMP JACKBARS. OPTIONAL SPACING SCREWS CAN BE ADDED FOR PRECISE WELD GAP ADJUSTMENT.

ALIGNING & REFORMING CLAMPS

UNIVERSAL CHAIN CLAMP

Universal Chain Clamps reform pipe to Schedule 20 and align pipe to Schedule 40. Available in carbon steel chain and stainless steel chain versions to fit pipe from 1" to 36" (25 mm to 914 mm). The versatile design provides the ability to accurately fit-up, weld and grind joints without removing the clamp. The Level and Support Device of the Universal Chain Clamp allows pipe, elbow, tee, flange and other fittings to be safely secured during the alignment and welding process. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination.

VERSATILE | Reforms pipe to Schedule 20 and aligns pipe to Schedule 40

PRECISE | Swivel-foot Jackscrews help ensure precise alignment by securely holding on uneven pipe surfaces

SAFER | Jackbars can be adjusted to relocate the contact point of Jackscrews for extra support of mating pipe or fittings

WIDE RANGE | A single Universal Chain Clamp covers the same range as 8 cage clamps

Universal Chain Clamp Includes:

- | Nickel plated carbon steel or stainless steel duplex roller chain
- | Universal stainless steel Jackbars
 - quantity as indicated in specifications
- | Stainless steel Main Block
- | Level and Support Device
- | Jackscrew Breaker Bar with Socket
- | Heavy-duty Storage Box
- | Parts and Operating Manual

Universal Jackbar equipped with 2 Jackscrews



Fine Adjustment

Main Block



Universal Jackbar

Jackscrews

WARNINGS: UNIVERSAL CHAIN CLAMPS SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.

Level and Support Device

Universal Jackbar



NOTE: MATHEY DEARMAN CHAIN CLAMPS CAN BE RECONFIGURED FOR STAINLESS STEEL AND OTHER SPECIALTY ALLOY APPLICATIONS. REPLACE THE CARBON STEEL ROLLER CHAIN WITH STAINLESS STEEL CHAIN. (ALL OTHER COMPONENTS OF CHAIN CLAMPS ARE MADE OF STAINLESS STEEL)

UNIVERSAL CHAIN CLAMP | SPECIFICATIONS

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

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,164 kg per square centimeter).

SS - Indicates clamp is for stainless steel application

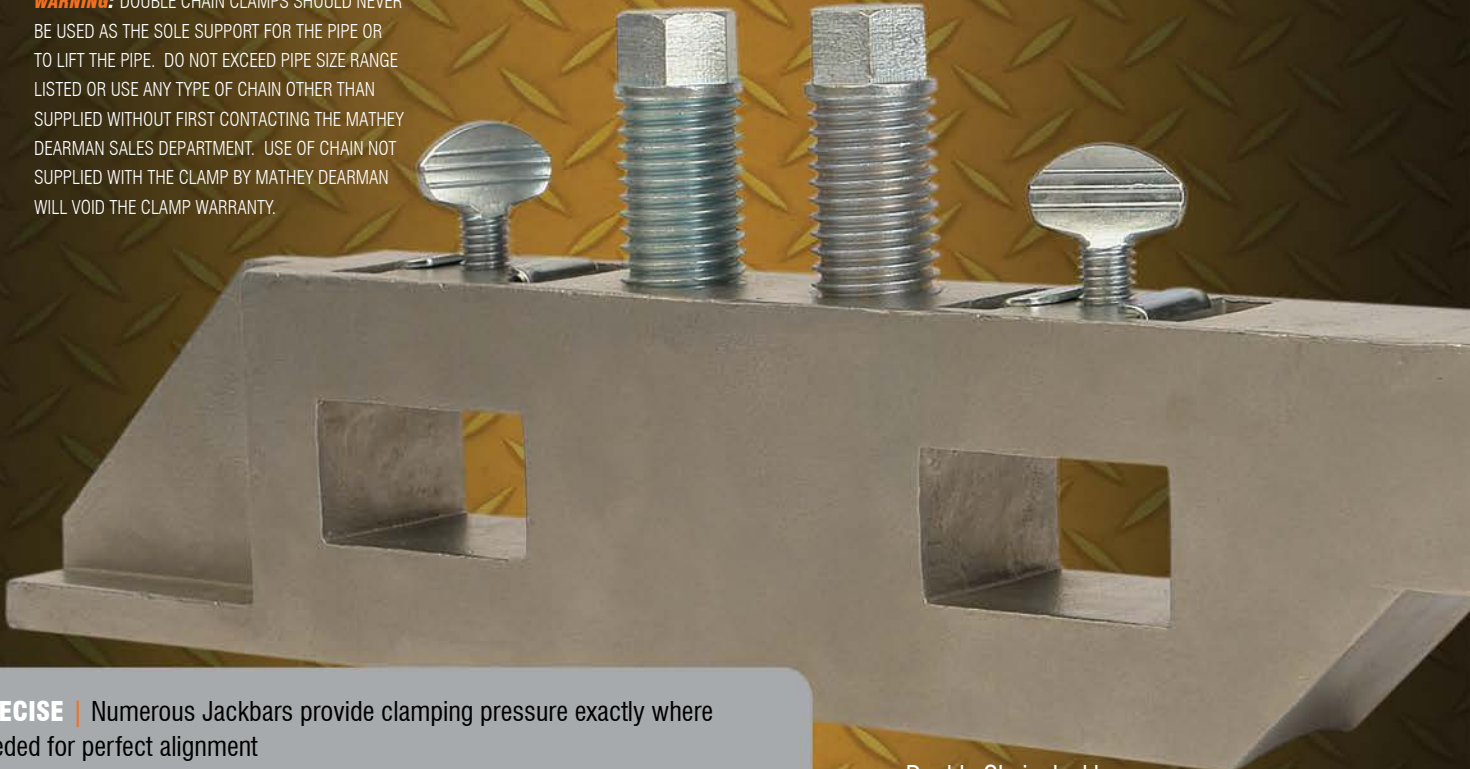
COMPLETE WELDING OF THE JOINT CAN BE ACCOMPLISHED WITH REMOVING THE CLAMP. ADD-ON JACKBAR CAN BE ADDED IF PRESSURE NEEDS TO BE APPLIED BETWEEN THE CLAMP JACKBARS. JACKSCREW PADS PIVOT INDEPENDENTLY TO HANDLE UNEVEN SURFACES. OPTIONAL SPACING SCREWS CAN BE ADDED FOR PRECISE WELD GAP ADJUSTMENT.

ALIGNING & REFORMING CLAMPS

DOUBLE CHAIN CLAMP | D251 SERIES

The Mathey Dearman Double Chain Clamp is a heavy-duty vessel clamp designed for alignment and reforming of pipes and vessels up to 20' (6 m) in diameter with Schedule 80 wall thickness. Our Double Chain Clamps also align Schedule 80 pipe and heavier when no reforming is required. The extra heavy-duty Jackbars and Main Block provide the brute strength necessary to accomplish even the toughest reforming jobs. Models 10" to 36" through 10" to 54" come with a Level and Support Device. All other models come with a cable hoist. The Double Chain Clamp is available in steel and stainless steel versions and is shipped in a wooden crate.

WARNING: DOUBLE CHAIN CLAMPS SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.



Double Chain Jackbar

PRECISE | Numerous Jackbars provide clamping pressure exactly where needed for perfect alignment

TOUGH | Reforms and aligns pipe with Schedule 80 wall thickness

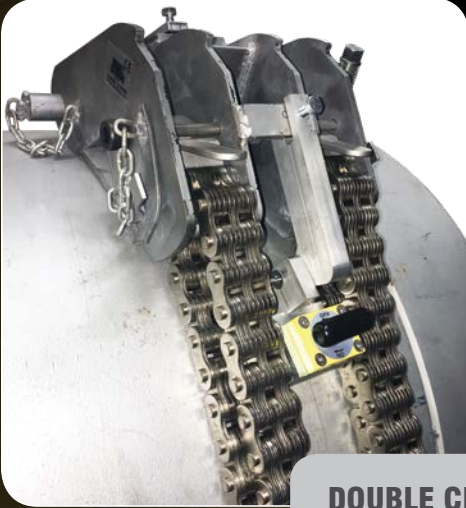
ADAPTABLE | Fits extremely large range of pipe diameters

CONFORMING | Jackbar pads pivot independently to handle uneven pipe and fitting surfaces

Double Chain Clamp Includes:

- | 2 Nickel plated or stainless steel high-strength leaf chains
- | Extra heavy-duty stainless steel Jackbars-quantity as listed in specifications
- | Double chain Main block with 2 Fine Adjustments
- | Level and Support Device (D251-1060 model and larger supplied with cable hoist)
- | Jackscrew Breaker Bar with Socket
- | Parts and Operating Manual





MAGSWITCH
Magnets are now standard with all **DOUBLE CHAIN CLAMPS** to make setup simple and easy.

Joints on large pipe or tube shells up to 20' (6096 mm) in diameter can be aligned, reformed and welded without removing the clamp, saving time and improving weld quality.



DOUBLE CHAIN CLAMP | SPECIFICATIONS

Number	Number of Main Blocks	Number of Jackbars	Pipe Size Range in (mm)	Est. Shipping Weight
D251-1036	1	9	10-36 (254-914)	220 lbs / 100 kg
D251-1036SS	1	9	10-48 (254-914)	220 lbs / 100 kg
D251-1048	1	12	10-48 (254-1219)	278 lbs / 126 kg
D251-1048SS	1	12	10-48 (254-1219)	278 lbs / 126 kg
D251-1054	1	14	10-54 (254-1372)	300 lbs / 136 kg
D251-1054SS	1	14	10-54 (254-1372)	300 lbs / 136 kg
D251-1060	1	16	10-60 (254-1524)	328 lbs / 149 kg
D251-1060SS	1	16	10-60 (254-1524)	328 lbs / 149 kg
D251-1072	1	20	10-72 (254-1829)	387 lbs / 176 kg
D251-1072SS	1	20	10-72 (254-1829)	387 lbs / 176 kg
D251-1084	1	24	10-84 (254-2134)	442 lbs / 200 kg
D251-1084SS	1	24	10-84 (254-2134)	442 lbs / 200 kg
D251-1096	2	28	10-96 (254-2438)	498 lbs / 226 kg
D251-1096SS	2	28	10-96 (254-2438)	498 lbs / 226 kg
D251-10108	2	32	10-108 (254-2743)	554 lbs / 251 kg
D251-10108SS	2	32	10-108 (254-2743)	554 lbs / 251 kg
D251-10120	2	36	10-120 (254-3048)	610 lbs / 277 kg
D251-10120SS	2	36	10-120 (254-3048)	610 lbs / 277 kg
D251-1011F	2	39	10-132 (254-3353)	660 lbs / 299 kg
D251-1011FSS	2	39	10-132 (254-3353)	660 lbs / 299 kg
D251-1012F	2	42	10-144 (254-3658)	710 lbs / 322 kg
D251-1012FSS	2	42	10-144 (254-3658)	710 lbs / 322 kg
D251-1014F	2	48	10-168 (254-4267)	810 lbs / 367 kg
D251-1014FSS	2	48	10-168 (254-4267)	810 lbs / 367 kg
D251-1016F	3	54	10-192 (254-4877)	910 lbs / 410 kg
D251-1016FSS	3	54	10-192 (254-4877)	910 lbs / 410 kg
D251-1018F	3	60	10-216 (254-5486)	1010 lbs / 455 kg
D251-1018FSS	3	60	10-216 (254-5486)	1010 lbs / 455 kg
D251-1020F	3	66	10-240 (254-6096)	1110 lbs / 500 kg
D251-1020FSS	3	66	10-240 (254-6096)	1110 lbs / 500 kg

NOTE: ALL DOUBLE CHAIN CLAMPS WITH 16 OR MORE JACKBARS INCLUDE CABLE HOIST. SMALLER CLAMPS INCLUDE LEVEL AND SUPPORT DEVICE.

* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,164 kg per square centimeter).

SS - Indicates clamp is for stainless steel application.

ALIGNING & REFORMING CLAMPS

HYDRAULIC CLOSURE MECHANISM

Perfect for clamping larger diameters and applying extra clamp load, Mathey Dearman's Hydraulic Chain Clamp Closure Mechanism uses a 5" (127 mm) stroke to apply up to 10,000 pounds (4535kg) of tension to the standard Double Chain Clamp. Hydraulic pressure is supplied to the closure mechanism's hydraulic cylinder by a hand pump with reservoir. Tension can be applied to close the clamp on the pipe. Using the Hydraulic Closure Mechanism, our Double Chain Clamp is able to align pipe up to Schedule 120 and reform pipe to Schedule 80.



D251 SERIES HYDRAULIC CLOSURE MECHANISM

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

The Hydraulic Closure Mechanism can be added to a previously purchased Double Chain Clamp.



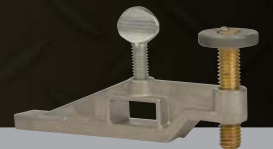
MANUAL HYDRAULIC PUMP KIT
ITEM NO. D104-KIT



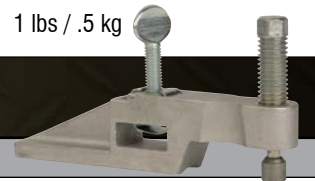
DD-580 HYDRAULIC CLOSURE MECHANISM

CHAIN CLAMP ACCESSORIES & REPLACEMENT PARTS

JACKBARS | All Single and Double Jackbars are investment cast stainless steel.

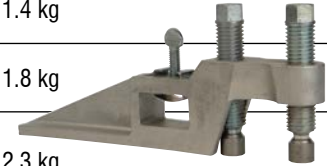


Item Number	Original Chain Clamp	Original Chain Clamp Range	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range	Est. Shipping Weight
Mini-Fit Jackbar		in (mm)		in (mm)	
DXL-523	D230	1-8 (25-203) (Carbon Steel)	D231-LT	1-12 (25-305) (Carbon Steel)	1 lbs / .5 kg
DXL-523S	D230SS	1-8 (25-203) (Carbon or Stainless Steel)	D231-LTSS	1-12 (25-305) (Carbon or Stainless Steel)	1 lbs / .5 kg

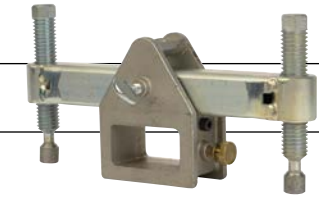


Single Screw Jackbar		in (mm)		in (mm)	
DA-500S	D231, D231SS	1-8 (25-203) (Carbon or Stainless Steel)	D231-LT, D231-LTSS	4-20 (102-508) (Carbon or Stainless Steel)	3 lbs / 1.4 kg
DB-500S	D232, D232SS	4-16 (102-406) (Carbon or Stainless Steel)	D232-LT, D232-LTSS D233-LT, D233-LTSS	6-36 (152-914) (Carbon or Stainless Steel)	4 lbs / 1.8 kg
DC-500S	D233, D233SS, D234, D234SS	10-36 (254-914) 10-54 (254-1372) (Carbon or Stainless Steel)			5 lbs / 2.3 kg

Item Number	Original Chain Clamp	Original Chain Clamp Range	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range	Est. Shipping Weight
Double Screw Jackbar		in (mm)		in (mm)	
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 lbs / 1.4 kg
DB-600S	D249, D249SS D249SC, D249SCSS	4-16 (102-406) Carbon or Stainless Steel	D235-LT, D235-LTSS	6-36 (152-914) (Carbon or Stainless Steel)	4 lbs / 1.8 kg
DC-600S	D235, D235SS D235SC, D235SCSS D236, D236SS	10-36 (254-914) 10-54 (254-1372) Carbon or Stainless Steel			5 lbs / 2.3 kg



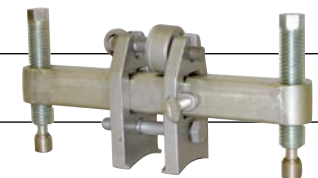
Universal Jackbar		in (mm)			
DA-800	D2250, D2250SS	1-8 (25-203) Carbon Steel			1 lbs / .5 kg
DB-800	D2249, D2249SS	4-16 (102-406) Carbon Steel			3 lbs / 1.4 kg
DC-800	D2235, D2235SS	10-36 (254-914) Carbon Steel			4 lbs / 1.8 kg



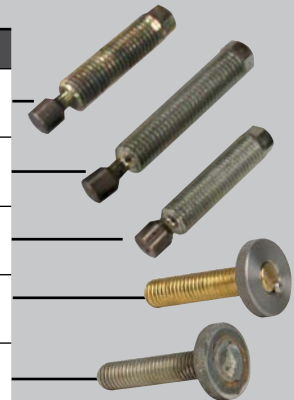
Double Chain Jackbar		in (mm)			
DD-500S	D251 Series	10"-20' (254-6096)			8 lbs / 3.6 kg



Add-on Jackbar		in (mm)			
DA-900	D231, D231SS D250, D250SS	1-8 (25-203) Carbon or Stainless Steel			3 lbs / 1 kg
DB-900	D232, D232SS D249, D249SS	4-16 (102-406) Carbon or Stainless Steel			3 lbs / 1 kg
DC-900	D233, D233SS D234, D234SS D235, D235SS D236, D236SS	10-54 (254-1372) Carbon or Stainless Steel			5 lbs / 2 kg



Jackscrews	Jackbar	in (mm)	Size	in (mm)	Weight
DA-501	DA-500S, DB-500S	1-8 (25-203)	5/8" - 11 NC X 3 1/4"		.2 lbs / .1 kg
DA-701	DA-600S, DA-800, DA-900 DB-600S, DB-800, DB-900	4-16 (102-406)	5/8" - 11 NC x 4"		.25 lbs / .11 kg
DC-501	DC-500S, DC-600S, DC-800, DC-900, DD-500	10 - 54 (254-1372)	7/8" - 9 NC x 4 1/2"		.6 lbs / .2 kg
DXL-525	DXL-523		1/2" -13	1-12 (25-305) Carbon Steel	.2 lbs / .1 kg
DXL-525S	DXL-523S		1/2" -13	1-12 (25-305) Stainless Steel	.2 lbs / .1 kg
DR-500	FOR CLAMP - D711		1 1/4"-8 ACME x 8 1/4"		.2 lbs / .1 kg



CHAIN CLAMP REPLACEMENT PARTS AND ACCESSORIES

MAIN BLOCK | FINE ADJUSTMENT | LEVEL AND SUPPORT DEVICE

MAIN BLOCK

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 chain rollers and positively engages the chain.



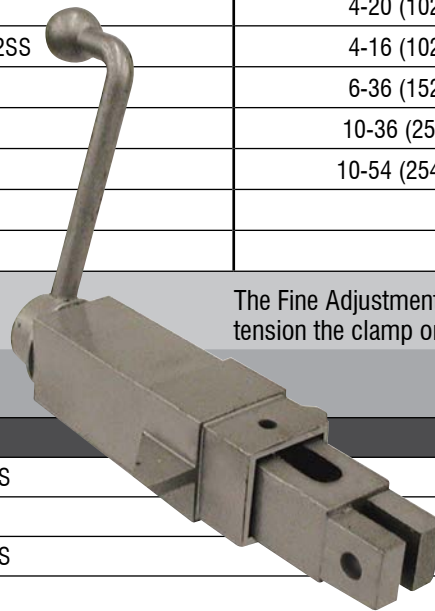
MAIN BLOCK

Item Number	Single, Double, Universal or D251 Series Chain Clamp	Pipe Size Range n (mm)	Est. Shipping Weight
Main Block			
DXL-524	D230	1-8 (25 -203)	3 lbs / 1.4 kg
DXL-524S	D230SS	4-16 (102-406)	3 lbs / 1.4 kg
DXL-524LT	D231-LT	1-12 (25-305)	7 lbs / 3 kg
DXL-524LTSS	D231-LTSS	4-16 (102-406)	7 lbs / 3 kg
DA-100	D231, D231SS, D250, D250SS, D2250, D2250SS	1-8 (25 -203)	3 lbs / 1.4 kg
DA-100LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4-20 (102-508)	3 lbs / 1.4 kg
DB-100	D249, D249SS, D2249, D2249SS, D232, D232SS	4-16 (102-406)	13 lbs / 6 kg
DB-100LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6-36 (152-914)	25 lbs / 11 kg
DC-100	D2235, D2235SS, D235, D233, D233SS	10-36 (254-914)	25 lbs / 11 kg
DC-100	D236SS, D236, D234, D234SS	10-54 (254-1372)	25 lbs / 11 kg
DD-100	D251 SERIES (carbon steel)		
DD-100S	D251 SERIES (stainless steel)		

FINE ADJUSTMENT

The Fine Adjustment engages in the Main Block and is used to tension the clamp on the pipe.

Item Number	Single, Double, and Universal Chain Clamp	Pipe Size Range in (mm)	Est. Shipping Weight
Fine Adjustment			
DA-200	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 (25-203)	.1 lbs / .045 kg
DA-200LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 (102-508)	.1 lbs / .045 kg
DB-200	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 (102-406)	3 lbs / 1.4 kg
DB-200LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 (152-914)	3 lbs / 1.4 kg
DC-200	D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS, D2235, D2235SS, D251 Series	10 - 36 (254- 914)	4 lbs / 1.8 kg
DXL-200	D230, D230SS	10 - 240 (254- 6096)	1.6 lbs / 0.7 kg
DXL-200LT	D231-LT, D231-LTSS	10 - 240 (254- 6096)	1.6 lbs / 0.7 kg



LEVEL AND SUPPORT DEVICE

Our Level and Support Device allows accurate positioning of all types of fittings while freeing the user's hands.



CLAMP ADJUSTMENT WRENCH

Breaker-bar and socket furnished with clamps for Jackscrew adjustment and attachment of the Level and Support Device.



Socket	Jackscrew	Socket Size
DWR-100	DA-701, DA-501	9/16" x 1/2" Drive*
DWR-300	DC-501, DC-501E	3/4" x 1/2" Drive*
DWR-400	DR-500	7/8" x 1/2" Drive*

* D900-005 1/2" drive Breaker Bar also required

Item Number	Single, Double and Universal Chain Clamp	Pipe Size Range in (mm)	Est. Shipping Weight
Level and Support Device			
DA-400S	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 (25-203)	2 lbs / 1 kg
DA-400SLT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 (102-508)	2 lbs / 1 kg
DB-400S	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 (102-406)	5 lbs / 2.3 kg
DB-400SLT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 (152-914)	5 lbs / 2.3 kg
DC-400	D233, D234, D235, D236, D2235, D251 Series (carbon steel)	10 - 36 (254-914)	14 lbs / 16.4 kg
DC-400S	D233SS, D234SS, D235SS, D236SS, D2235SS, D251 Series (Stainless Steel)	10 - 36 (254-914)	14 lbs / 16.4 kg

CHAIN CLAMP STORAGE BOXES

Durable Chain Clamp Steel Storage Boxes are available in two (2) sizes. Storage Boxes come standard with lifting handle(s), and lockable hasp with a powder coated finish.

Item Number	Description	Chain Clamp
D862	Metal Red Tool Box 29 1/4" x 14" x 10 1/2"	D2235, D2235SS, D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS
D864	22" Black Tool Box	D2249, D2249SS, D2250, D2250SS, D231, D231SS, D231-SC, D231-SCSS, D232, D232SS, D232-LT, D232-LTSS, D233-LT, D233-LTSS, D235-LT, D235-LTSS, D235-SC, D235-SCSS, D249, D249SS, D249-LT, D249-LTSS, D249-SC, D249-SCSS, D250, D250SS



CHAIN CLAMP REPLACEMENT PARTS AND ACCESSORIES

JACKBAR SPACING SCREWS

Spacing Screws are used to obtain a precise weld gap between pipes or 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.

Item Number	Type	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
DD-570	Carbon Steel	D251
DD-570S	Stainless Steel	D251SS

Spacing Screws, when mounted to the Jackbar and Main Block, provides a precise and simple way to hold a weld gap between pipes or pipe and fitting.



Jackbar Spacing Screw assembly

Main Block (Universal Jackbar) Spacing Screw assembly

MAIN BLOCK SPACING SCREWS

Item Number	Type	Chain Clamp
DA-870	Carbon Steel	D231, D249-LT, D232-LT, D250
DA-870S	Stainless Steel	D231SS, D249-LTSS, D232-LTSS, D250SS
DB-870	Carbon Steel	D232, D233-LT, D235-LT, D249
DB-870S	Stainless Steel	D232SS, D233-LTSS, D235-LT D249SS
DC-870	Carbon Steel	D233, D234, D235, D236
DC-870S	Stainless Steel	D233SS, D234SS, D235SS, D236SS



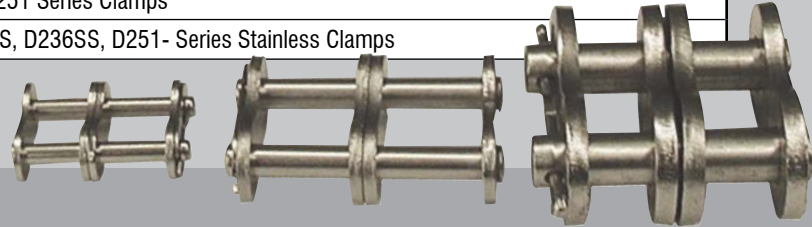
CHAIN CLAMP CHAIN

Three (3) different sizes of 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. Chain is available in stainless steel or nickel plated carbon steel.

CHAIN AND CONNECTING LINKS

Item Number	Connecting Link	Standard Chain Clamp
Chain		
DA-300	DA-301	D2250, D230, D231, D231-LT, D231-SC, D232-LT, D249-LT, D249-SC, D250
DA-300S	DA-301S	D2250SS, D230SS, D231SS, D231-LTSS, D231-SCSS, D232-LTSS, D249-LTSS, D249-SCSS, D250SS
DB-300	DB-301	D2249, D232, D233-LT, D235-LT, D235-SC, D249
DB-300S	DB-301S	D2249SS, D232SS, D233-LTSS, D235-LTSS, D235-SCSS, D249SS
DC-300	DC-301	D2235, D233, D234, D235, D236, D251 Series Clamps
DC-300S	DC-301S	D2235SS, D233SS, D234SS, D235SS, D236SS, D251- Series Stainless Clamps

NOTE: A CONNECTING LINK IS REQUIRED TO JOIN CHAIN ENDS TOGETHER. ONE ADDITIONAL JACKBAR SHOULD BE ADDED FOR EACH ADDITIONAL FOOT OF CHAIN.



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

WARNINGS: THE REFORMING CAPABILITY OF THE CHAIN CLAMP CAN BE SEVERELY AFFECTED IF THE LENGTH OF THE CHAIN IS EXTENDED BEYOND THE PUBLISHED WORKING RANGE. MATHEY DEARMAN WILL NOT WARRANTY ANY CLAMP THAT IS APPLIED BEYOND THE NORMAL OPERATING RANGE OF THE CLAMP. TO MAINTAIN WARRANTY USE ONLY CHAIN PURCHASED FROM MATHEY DEARMAN. 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.

HOW TO DETERMINE LENGTH OF CHAIN TO EXTEND THE RANGE OF A CHAIN CLAMP.

Example:

- Step 1:** For a D249 [range: 4"-16" (102 mm-406 mm)] standard length of chain is: 60" / 1524 mm
- Step 2:** Multiply the diameter of the pipe that you wish to align by 3.1416 (i.e.: 20" (508 mm) pipe diameter x 3.1416) = 62.8" / 1595 mm
- Step 3:** Subtract the length of chain noted on the D249 clamp used in Step 2. - 60" / 1524 mm
- 2.8" / . 71 mm
- Step 4:** Round up to the next whole foot (305 mm) for additional chain required. 1' / 305 mm of additional chain

NOTE: FORMULA FOR DETERMINING CHAIN LENGTH REQUIRED IS AVAILABLE AT WWW.MATHEY.COM

ALIGNING & REFORMING CLAMPS

THE DEARMAN HYDRAULIC SLEEVE CLAMP

In THE DEARMAN SYSTEM tradition, we're excited to introduce a faster and safer way to install sleeves and fittings - Dearman Sleeve Clamps. Leveraging our industry-leading clamping technology, we've built these extreme-duty clamps to handle welded sleeves up to $\frac{3}{4}$ " thick and up to 70,000 PSI tensile strength. Unlike the common and unsafe application of a bottle jack and chain, our purpose-built clamps provide virtually 360 degrees of clamping force for perfect fit-ups. Our easy to operate hydraulic closure system makes set up and removal easy and quick.

Why risk the chance for flying jacks and falling sleeves when finally, there's a better solution?

All models feature 2-speed hydraulic hand pumps for quicker installation time and high-strength modular design for safer handling. Choose from 4 models of clamps for your specific need and application - 5,000 PSI or 10,000 PSI of clamping pressure and 6" to 24" or 6" to 48" range for sleeves up to $\frac{3}{4}$ " (19mm) thick. All clamps include a rugged steel transportation and storage box.

UNSAFE



SAFE



- SAFE** | No unstable bottle jacks to suddenly slip and disengage
- PRECISE** | Equal clamping force provides better fit-up
- EASY TO HANDLE** | Engineered to be installed by one person
- ADAPTABLE** | Fits a wide range of pipe sizes and sleeve thicknesses
- DURABLE** | Rugged corrosion-resistant construction for years of use

Dearman Sleeve Clamps Include:

- | Nickel plated carbon steel duplex roller chain (DB models) or Nickel plated carbon steel leaf chain (DC models) for pipe size range
- | High strength stainless steel Main Block with hydraulic cylinder
- | 2-Speed hand operated hydraulic pump
- | Heavy duty transportation and storage box
- | Parts and Operating Manual



DB-724
5,000 PSI



DC-724
10,000 PSI

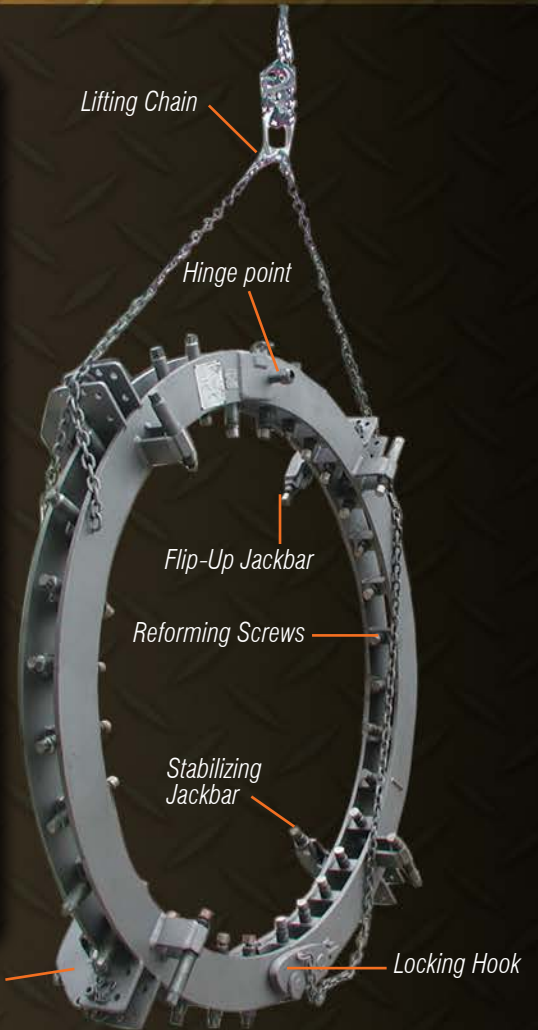
DEARMAN HYDRAULIC SLEEVE CLAMP

Model	Pipe Size Range in (mm)	Clamping Pressure	Chain	Weight – Sleeve Clamp Only	Shipping Weight
DB-724	6 - 24 (152 – 610)	5,000 PSI	DB-300	31 lbs / 14 kg	76 lbs / 34 kg
DB-748	6 – 48 (152 – 1219)	5,000 PSI	DB-300	48 lbs / 22 kg	93 lbs / 42 kg
DC-724	6 -24 (152 – 610)	10,000 PSI	DC-300	50 lbs / 23 kg	94 lbs/ 43 kg
DC-748	6 – 48 (152 – 1219)	10,000 PSI	DC-300	81 lbs / 37 kg	125 lbs/ 57 kg

DEARMAN HYDRAULIC SLEEVE CLAMP RECOMMENDED APPLICATION

Sleeve Tensile Strength	Sleeve Wall Thickness	Pipe Diameter & Material			
		6-12" (152 - 305 mm)	12-18" (305 - 457 mm)	18-24" (457 - 610 mm)	24-48" (610 - 1219 mm)
		CS	CS	CS	CS
36,000 PSI	3/16"	DB-724	DB-724	DB-724	DB-748
	1/4"	DB-724	DB-724	DB-724	DB-748
	5/16"	DB-724	DB-724	DB-724	DB-748
	3/8"	DB-724	DB-724	DB-724	DB-748
	1/2"	DB-724	DB-724	DC-724	DC-748
	5/8"	DC-724	DC-724	DC-724	DC-748
	3/4"	DC-724	DC-724	DC-724	DC-748
50,000 PSI	3/16"	DB-724	DB-724	DB-724	DB-748
	1/4"	DB-724	DB-724	DB-724	DB-748
	5/16"	DC-724	DC-724	DC-724	DC-748
	3/8"	DC-724	DC-724	DC-724	DC-748
	1/2"	DC-724	DC-724	DC-724	DC-748
	5/8"	DC-724	DC-724	DC-724	DC-748
	3/4"	DC-724	DC-724	DC-724	DC-748
70,000 PSI	3/16"	DC-724	DC-724	DC-724	DC-748
	1/4"	DC-724	DC-724	DC-724	DC-748
	5/16"	DC-724	DC-724	DC-748	DC-748
	3/8"	DC-724	DC-724	DC-748	DC-748
	1/2"	DC-724	DC-724	DC-748	DC-748
	5/8"	DC-724	DC-724	DC-748	DC-748
	3/4"	DC-724	DC-724	DC-748	DC-748

ALIGNING AND REFORMING CLAMPS



RIM CLAMPS

Mathey Dearman Rim Clamps are built for tough reforming jobs and are ideal for applications requiring 100% weld and grind without releasing clamping pressure. Symmetrically placed Jackscrews apply pressure on high points to precisely reform and align pipe or shells. All surfaces of the Rim Clamp in contact with the pipe are made of stainless steel enabling the Clamp to be used on a variety of materials.

Mathey Dearman Rim Clamps will reform 45,000 PSI tensile strength pipe up to Schedule 80, with out-of-round conditions up to 2" (51 mm), depending on wall thickness.



ACCURATE | Apply reforming pressure exactly where required

STRONG | Corrects out-of-round conditions up to 2" (51 mm)

EASY | Self-latching design, 14" (356 mm) and larger, makes installation simple and safe

VERSATILE | Handles a range of pipe sizes and materials

The 14" to 16" (356 mm to 406 mm) and larger Rim Clamp closes over the pipe automatically, for quick and simple operation.

REFORMING CAPABILITY - Maximum Wall Thickness for Specified Material Tensile Strength

Clamp Type	Pipe Tensile Strength		Pipe Diameter in (mm)					
	PSI	MPA	4" - 12" (102 - 305)	14" - 24" (356 - 610)	26" - 30" (660 - 762)	32" - 48" (813 - 1219)	50" - 60" (1270 - 1524)	62" - 72" (1575 - 1829)
			Pipe Wall Thickness in. (mm) *					
RIM	45,000	310	1/2 (13)	3/4 (19)	7/8 (22)	1 (25)	1 1/8 (29)	1 1/4 (32)
			1/2 (11)	3/4 (19)	1 (25)	1 1/8 (29)	1 1/4 (32)	1 3/8 (35)
MEGA RIM	65,000	448	7/16 (11)	5/8 (16)	3/4 (19)	1 (25)	1 1/8 (29)	1 3/8 (35)
	70,000	483	3/8 (10)	1/2 (13)	3/4 (19)	7/8 (22)	1 (25)	1 1/4 (32)
	80,000	552	3/8 (10)	1/2 (13)	5/8 (16)	3/4 (19)	1 (25)	1 1/8 (29)

* Calculations based on material temperature of 72° F (22° C)

RIM CLAMP

Rim Clamp Item No.	Pipe Size Range in. (mm)	Estimated Shipping Weight
D711-0406	4 - 6 (102 - 152)	40 lbs / 18 kg
D711-0608	6 - 8 (152 - 203)	30 lbs / 22.5 kg
D711-0810	8 - 10 (203 - 254)	70 lbs / 31.5 kg
D711-1012	10 - 12 (254 - 305)	90 lbs / 40.5 kg
D711-1214	12 - 14 (305 - 356)	120 lbs / 54 kg
D711-1416	14 - 16 (356 - 406)	190 lbs / 85.5 kg
D711-1618	16 - 18 (406 - 457)	240 lbs / 108 kg
D711-1420	14 - 20 (356 - 508)	280 lbs / 126 kg
D711-1824	18 - 24 (457 - 610)	350 lbs / 157.5 kg
D711-2026	20 - 26 (508 - 660)	360 lbs / 162 kg
D711-2228	22 - 28 (559 - 711)	380 lbs / 171 kg
D711-2632	26 - 32 (660 - 813)	400 lbs / 180 kg
D711-3036	30 - 36 (762 - 914)	420 lbs / 189 kg
D711-3440	34 - 40 (864 - 1016)	450 lbs / 202.5 kg
D711-3844	38 - 44 (965 - 1118)	490 lbs / 220.5 kg
D711-4248	42 - 48 (1067 - 1219)	510 lbs / 229.5 kg
D711-4450	44 - 50 (1118 - 1270)	575 lbs / 258.75 kg
D711-4652	46 - 52 (1168 - 1321)	610 lbs / 274.5 kg
D711-5056	50 - 56 (1270 - 1422)	680 lbs / 308 kg
D711-5460	54 - 60 (1372 - 1524)	750 lbs / 337.5 kg
D711-5864	58 - 64 (1473 - 1626)	820 lbs / 369 kg
D711-6268	62 - 68 (1575 - 1727)	880 lbs / 396 kg
D711-6672	66 - 72 (1676 - 1829)	950 lbs / 427.5 kg

Additional sizes available - contact sales@mathey.com

ALIGNING AND REFORMING CLAMPS

MEGA RIM CLAMPS

For reforming high tensile strength pipe, there is nothing like a Mathey Dearman Mega Rim Clamp.

Our Mega Rim Clamps align and reform high tensile strength X65, X70 and X80 pipe with wall thicknesses up to 1 3/8" (35 mm). Capable of reforming pipe with an out-of-round condition of up to 2" (51 mm), this clamp's performance comes from the heavy-duty oval shaped Side Plates, Latching Mechanism, and flip-up Jackbars for mating pipes and fittings.

The Mega Rim's hinged flip-up Jackbars are precisely positioned on the Clamp so they can be rotated away from the primary pipe for insertion of the mating pipe, valve or fitting and to facilitate welding and grinding. The independent pivoting pads of the Jackscrews compensate for uneven pipe surfaces. To avoid the risk of contamination, all surfaces of the Mega Rim Clamp that contact the pipe are made of stainless steel.

EXTREME CAPACITY | Reforms even high tensile strength pipe

ACCURATE | Corrects out-of-round conditions up to 2" (51 mm)

VERSATILE | Allows for 100% weld and grind without releasing clamp pressure

WARNINGS: CONTACT MATHEY DEARMAN WHEN PIPE IS CLAD WITH MATERIALS SUCH AS ICONEL OR TITANIUM. AS TEMPERATURES FALL BELOW 0 DEGREES FAHRENHEIT (-18 CELSIUS), REFORMING CAPABILITY RAPIDLY DECREASES.

Mega Rim Clamp Item No.	Pipe Size Range inch (mm)
D711-0406M	4 - 6 (102 - 152)
D711-0608M	6 - 8 (152 - 203)
D711-0810M	8 - 10 (203 - 254)
D711-1012M	10 - 12 (254 - 305)
D711-1214M	12 - 14 (305 - 356)
D711-1416M	14 - 16 (356 - 406)
D711-1618M	16 - 18 (406 - 457)
D711-1420M	14 - 20 (356 - 508)
D711-1824M	18 - 24 (457 - 610)
D711-2026M	20 - 26 (508 - 660)
D711-2228M	22 - 28 (559 - 711)
D711-2632M	26 - 32 (660 - 813)
D711-3036M	30 - 36 (762 - 914)
D711-3440M	34 - 40 (864 - 1016)
D711-3844M	38 - 44 (965 - 1118)
D711-4248M	42 - 48 (1067 - 1219)
D711-4450M	44 - 50 (1118 - 1270)
D711-4652M	46 - 52 (1168 - 1321)
D711-5056M	50 - 56 (1270 - 1422)
D711-5460M	54 - 60 (1372 - 1524)
D711-5864M	58 - 64 (1473 - 1626)
D711-6268M	62 - 68 (1575 - 1727)
D711-6672M	66 - 72 (1676 - 1829)

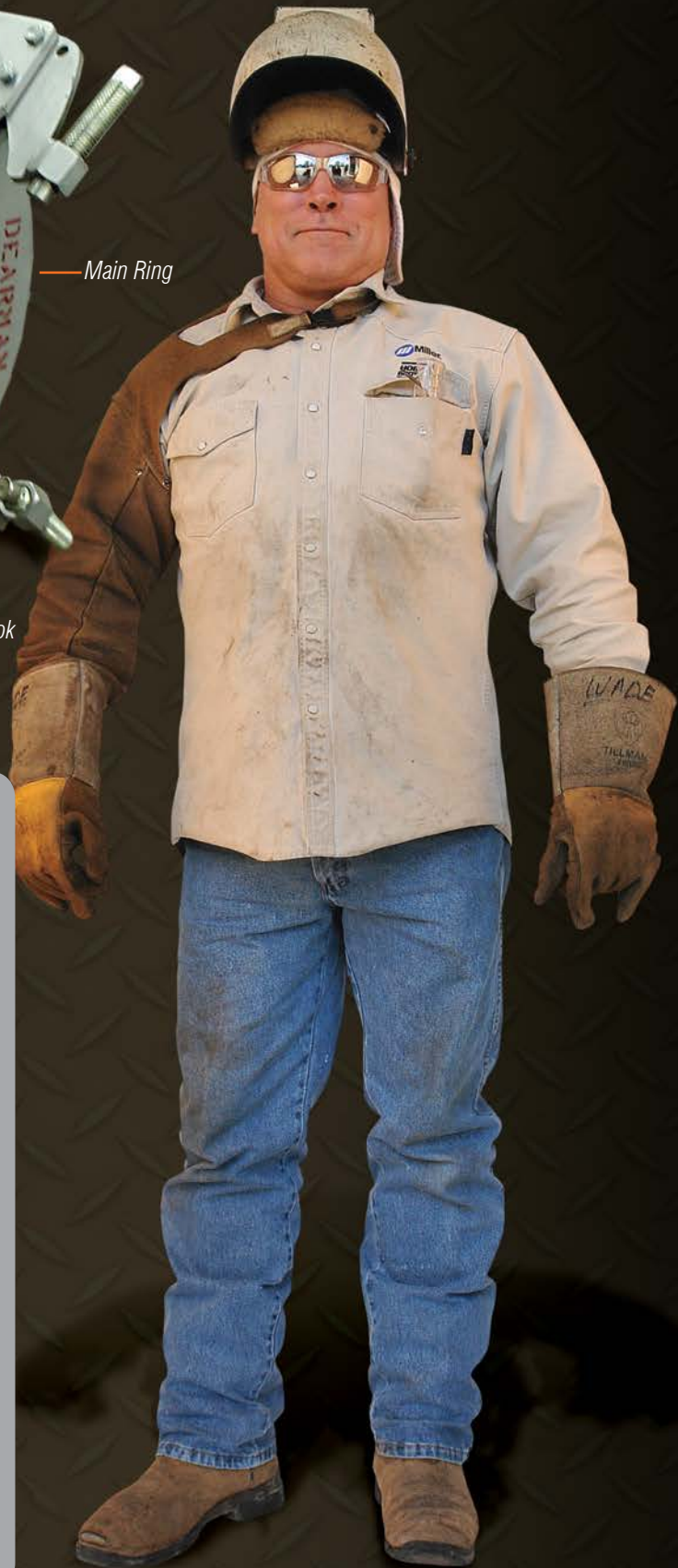
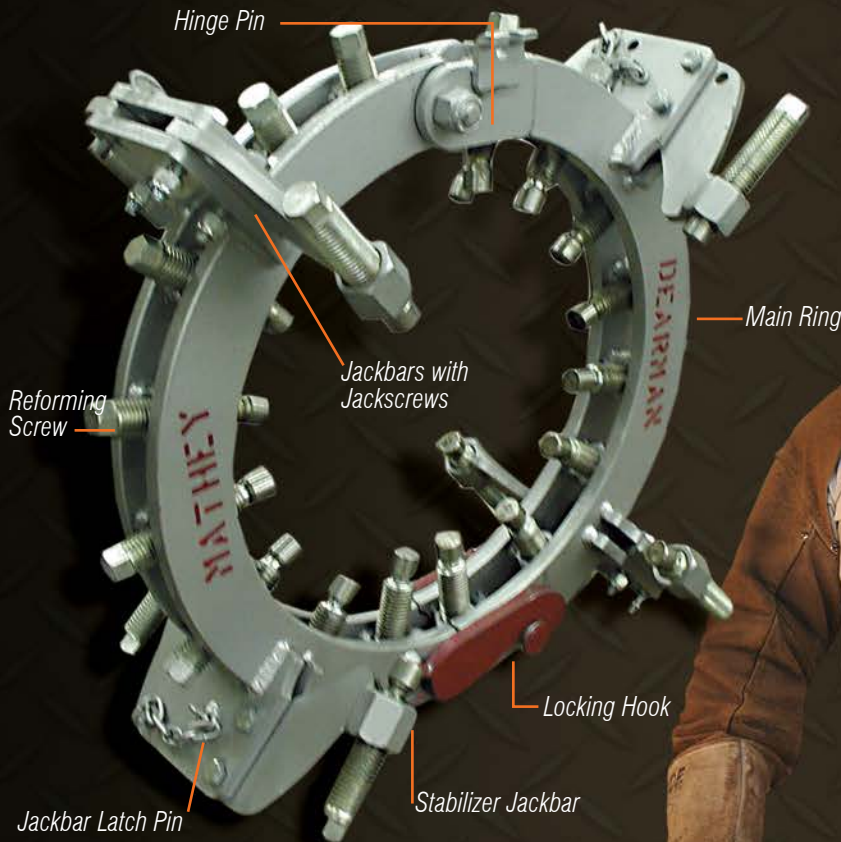
Please Contact Mathey Dearman Sales for Shipping Weights & Information



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

1. Pipe diameter (inches or millimeters) _____
2. Pipe wall thickness (inches or millimeters) _____
3. Pipe tensile strength and/or type of material _____

4. Horizontal or vertical application _____
5. Ambient temperature _____



PARTS AND 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)
DR-900 Add-on (Mega)	4 - 14 (102 - 356)
DR-901 Add-on (Rim)	14 - 72 (356 - 1829)
Jackscrews	
DC-501	4 - 14 (102 - 356)
DR-500	14 - 72 (356 - 1829)
Breaker Bar & Socket	
D900-005 + DWR 300 3/4" / 19 mm	4 - 14 (102 - 356)
D900-005 + DWR 400 7/8" / 22.2 mm	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

ALIGNING AND REFORMING CLAMPS



Align, Reform AND SET THE WELD GAP with a few turns of a wrench



- | One clamp works on multiple pipe sizes
- | Able to do light reforming to correct ovality in the pipe
- | Able to push or pull the pipe joint together to attain the proper gap
- | Works on Carbon Steels, Stainless Steels, and Alloys
- | Clamp can work on multiple types of joints
- | Split Frame Rim Style Clamp with turnbuckles, solid steel frames

All SUPERCLAMPS Include:

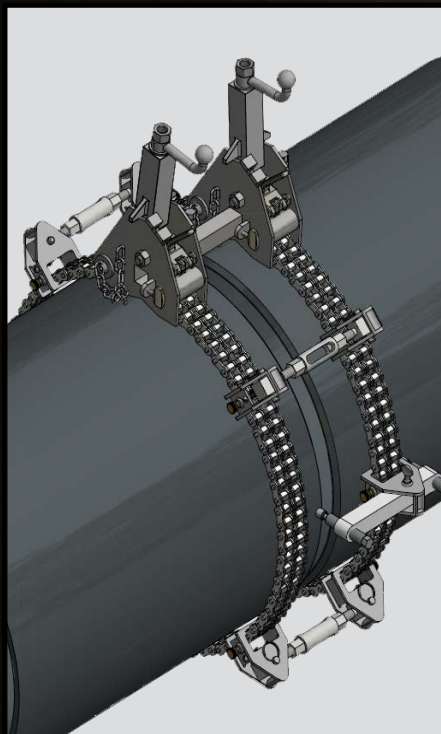
- Parts and Operating Manual
- Jackscrews with Swivel Pads
- Jackscrew Breaker Bar & Socket

Dearman SUPERCLAMP - HD

Model Part No.	Reforms To Schedule	Aligns To Schedule	Pipe Size Range (in/mm)
SC-RC-0612HD	40	80	6-12 / 152-305
SC-RC-1218HD	40	80	12-18 / 305-457
SC-RC-1824HD	40	80	18-24 / 457-610
SC-RC-2430HD	40	80	24-30 / 610-762
SC-RC-3036HD	40	80	30-36 / 762-914

SUPERCLAMP Reforming Abilities

SUPERCLAMP	Pipe OD	for max 1/16" out of round condition					for max 1/8" out of round condition				
		Schedule					Schedule				
		10	20	30	40	STD	10	20	30	40	STD
SC-RC-0612	6		--	--				--	--		
SC-RC-0612	8	x									
SC-RC-0612	10	x	x								
SC-RC-0612	12	x	x	x	x	x	x				
SC-RC-1218	12	x	x								
SC-RC-1218	14	x	x	x		x					
SC-RC-1218	16	x	x	x		x	x				
SC-RC-1218	18	x	x	x	x	x	x	x			
SC-RC-1824	18	x	x	x		x					
SC-RC-1824	20	x	x	x		x	x				
SC-RC-1824	22	x	x	x	--	x	x			--	
SC-RC-1824	24	x	x	x	x	x	x	x			x
SC-RC-2430	24	x	x	x		x	x				
SC-RC-2430	26	x	x	--	--	x	x		--	--	x
SC-RC-2430	28	x	x	x	--	x	x			--	x
SC-RC-2430	30	x	x	x	--	x	x	x		--	x
SC-RC-3036	30	x	x	x	--	x	x			--	x
SC-RC-3036	32	x	x	x	x	x	x				x
SC-RC-3036	34	x	x	x	x	x	x	x			x
SC-RC-3036	36	x	x	x	x	x	x	x			x



SUPERCLAMP Chain Clamp Variant

The chain variant offers maximum size versatility while still providing the positional adjustment capability the rigid clamp variant provides. More importantly, the new Push/Pull accessory works hand in hand with your existing Dearman Chain Clamps.

Chain Clamp Operating Range & Alignment/Reforming Capabilities

Mathey offers chain versions that work on carbon steel, as well as stainless steel pipes.

Product Line	Operating Range	Max Pipe Schedule Capability					
		With Universal Jackbars		With Dearman Single Jackscrews		With Dearman Double Jackscrews	
		Alignment	Reforming	Alignment	Reforming	Alignment	Reforming
SC-CC-DA	2" - 8"	40	20	40	20	40	20
SC-CC-DB	4" - 16"	40	20	80	40	80	40
SC-CC-DC	10" - 54"	40	20	80	40	80	40

* The universal jackbars can be used to align up to schedule 80 if reforming is not required

ALIGNING-ONLY CLAMPS

CAGE CLAMPS



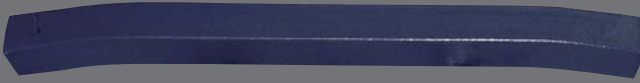
Mathey Dearman Cage Clamps are available in Hand-lever, Ratchet, and Hydraulic models in either tack or no-tack versions, ranging in sizes for pipes 2" to 60" (51 mm to 1524 mm). Our Cage Clamps will align pipe through Schedule 80. Cage Clamps are intended for alignment use only and are not designed to reform pipe. Each size Clamp fits one specific pipe diameter. If the O.D. of the pipe varies more than +/- 3/16" (5 mm) from the indicated Clamp diameter, pipes may not align accurately.



QUICK | Aligns pipes easily and fast

EFFICIENT | Good choice when aligning pipes with no reforming required

CAGE CLAMP CROSS BAR DESIGNS



Tack-type straight cross bars have flared ends so pipes can be moved easily into position and clamped. After the pipe is 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 alloy applications.



No-tack cross bars are arched to permit a full-circle weld without removing the Clamp. The no-tack Clamp can help increase welding quality and efficiency.

HAND LEVER CAGE CLAMP

Hand-lever Tack Model	Hand-lever No-tack Model	Pipe Size in (mm)
01.0505.001	-----	2 (51)
01.0505.002	-----	3 (76)
01.0505.003	01.0505.N03	3.5 (89)
01.0505.004	01.0505.N04	4 (102)
01.0505.005	01.0505.N05	5 (127)
01.0505.006	01.0505.N06	6 (152)
01.0505.008	01.0505.N08	8 (203)
01.0505.010	01.0505.N10	10 (254)
01.0505.012	01.0505.N12	12 (305)
01.0505.014	01.0505.N14	14 (356)
01.0505.016	01.0505.N16	16 (406)
01.0505.018	01.0505.N18	18 (457)
01.0505.020	01.0505.N20	20 (508)
01.0505.022	01.0505.N22	22 (559)
01.0505.024	01.0505.N24	24 (610)
01.0505.026	01.0505.N26	26 (660)
01.0505.028	01.0505.N28	28 (711)
01.0505.030	01.0505.N30	30 (762)
01.0505.032	01.0505.N32	32 (813)
01.0505.034	01.0505.N34	34 (864)
01.0505.036	01.0505.N36	36 (914)
01.0505.038	01.0505.N38	38 (965)
01.0505.040	01.0505.N40	40 (1016)
01.0505.042	01.0505.N42	42 (1067)
01.0505.048	01.0505.N48	48 (1219)
01.0505.054	01.0505.N54	54 (1372)
01.0505.060	01.0505.N60	60 (1524)

Clamps with stainless steel contact points or for odd-size pipe available on request. Add SS at end of part number for stainless steel.



In the field, rapid alignment can be achieved using the Hand-lever Cage Clamp.

ALIGNING-ONLY CLAMPS

RATCHET CAGE CLAMP

The ratchet closure system of Mathey Dearman's Ratchet Cage Clamp provides the extra force needed to align large pipe diameters. The Ratchet Cage Clamp is available for 14" to 60" (356 mm to 1524 mm) pipe. A special 1" (25mm) Ratchet Wrench fits all clamp sizes.

Pipe can be quickly aligned for welding with a Ratchet Cage Clamp.



Ratchet Wrench

(Handle must be ordered separately)

01-0505-R01

3/4" Ratchet Wrench for 4" - 8" Ratchet Clamps

01-0505-R02

7/8" Ratchet Wrench for 10" - 42" Ratchet Clamps

01-0505-R03

1" Ratchet Wrench for 44" - up Ratchet Clamps

Ratchet Tack Model	Ratchet No-tack Model	Pipe Size In (mm)
01.0505.R06	---	6 / 152
01.0505.R08	---	8 / 203
01.0505.R10	---	10 / 254
01.0505.R12	---	12 / 305
01.0505.R14	01.0505.RN14	14 / 356
01.0505.R16	01.0505.RN16	16 / 406
01.0505.R18	01.0505.RN18	18 / 457
01.0505.R20	01.0505.RN20	20 / 508
01.0505.R22	01.0505.RN22	22 / 559
01.0505.R24	01.0505.RN24	24 / 610
01.0505.R26	01.0505.RN26	26 / 660
01.0505.R28	01.0505.RN28	28 / 711
01.0505.R30	01.0505.RN30	30 / 762
01.0505.R32	01.0505.RN32	32 / 812
01.0505.R34	---	34 / 864
01.0505.R36	01.0505.RN36	36 / 914
01.0505.R38	01.0505.RN38	38 / 965
01.0505.R40	01.0505.RN40	40 / 1016
01.0505.R42	01.0505.RN42	42 / 1067
01.0505.R48	01.0505.RN48	48 / 1219
---	01.0505.RN54	54 / 1372
---	01.0505.RN60	60 / 1524

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

HYDRAULIC CAGE CLAMP

Mathey Dearman's Hydraulic Cage Clamp utilizes a rugged hydraulic closure mechanism to create the extra force necessary to align large pipe diameters while also permitting the rapid release of the clamp from the pipe. The Hydraulic Cage Clamp is available for 16" to 60" (406 mm to 1524 mm) pipe.



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

Hydraulic Tack Model	Hydraulic No-tack Model	Pipe Size In (mm)
01.0505.H16	01.0505.HN16	16 (406)
01.0505.H18	01.0505.HN18	18 (457)
01.0505.H20	01.0505.HN20	20 (508)
01.0505.H22	01.0505.HN22	22 (559)
01.0505.H24	01.0505.HN24	24 (610)
01.0505.H26	01.0505.HN26	26 (660)
01.0505.H28	01.0505.HN28	28 (711)
01.0505.H30	01.0505.HN30	30 (762)
01.0505.H32	01.0505.HN32	32 (812)
01.0505.H34	01.0505.HN34	34 (864)
01.0505.H36	01.0505.HN36	36 (914)
01.0505.H38	01.0505.HN38	38 (965)
01.0505.H40	01.0505.HN40	40 (1016)
01.0505.H42	01.0505.HN42	42 (1067)
01.0505.H48	01.0505.HN48	48 (1219)
01.0505.H54	01.0505.HN54	54 (1372)
01.0505.H60	01.0505.HN60	60 (1524)
01.0505.H00	Hydraulic Jack	

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

ALIGNING-ONLY CLAMPS

MINI-FIT CHAIN CLAMP



Aligns pipe to Schedule 40
Reforms pipe to Schedule 10

LIGHTWEIGHT | Easy to carry and handle

ECONOMICAL | Covers all pipe diameters from 3/4" to 8" (19 mm to 203 mm) with one clamp

ACCURATE | 3 Jackscrews help ensure perfect alignment on small diameter pipe and fittings

VERSATILE | Align pipe to Schedule 40, reform pipe to Schedule 10

STRONG | Constructed with the same materials and methods as our larger heavy-duty Chain Clamps

Mini-Fit Chain Clamps include:

- | Double-row chain (nickle plated carbon or stainless steel)
- | Single Screw Jackbars listed for the pipe diameter
- | Main Block Jackbar
- | Parts and Operating Manual

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
D230SS	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 is an excellent tool to align and fit-up small tubes, pipes and fittings. It is extremely lightweight, easy to set up and adjust, is small enough to fit in the welder's toolbox, and requires no tools to use. This ingenious adaptation of our proven Chain Clamp design is perfect for light-duty applications. The Mini-Fit is tough enough to align 3/4" to 8" (19 mm to 203 mm) carbon or stainless steel pipe and fittings with a wall thickness up to Schedule 40 and will reform Schedule 10.

Mini-Fit Single Screw Jackbar

The end of the jackscrew is round to reduce the risk of marring the pipe.



QUIK-FIT CLAMPS

The Mathey Dearman Quik-Fit Clamp offers the simplest method of achieving quick, easy and precise fit ups. The Quik-Fit is a compact tack-type clamp that is easy to use in close quarters. Quik-Fit is available in 3 sizes to cover a range of 1"-12" (25-305mm) pipe, and can be used on either carbon or stainless steel without adding special shoes or screws. The Clamp aligns pipe to pipe or pipe to fitting, and is ideal for alignment applications where reforming is not needed.



simplest method of achieving quick, easy and precise fit ups. Quik-Fit is available in 3 sizes to cover a range of 1"-12" (25-305mm) pipe, and can be used on either carbon or stainless steel without adding special shoes or screws. The Clamp aligns pipe to pipe or pipe to fitting, and is ideal for alignment applications where reforming is not needed.

RUGGED | Built for years of reliable service

LIGHTWEIGHT | Easy to use in overhead work

VERSATILE | 3 Clamps cover 1"-12" (25-305mm) pipe

FAST | Smooth, quick action for rapid fit-ups

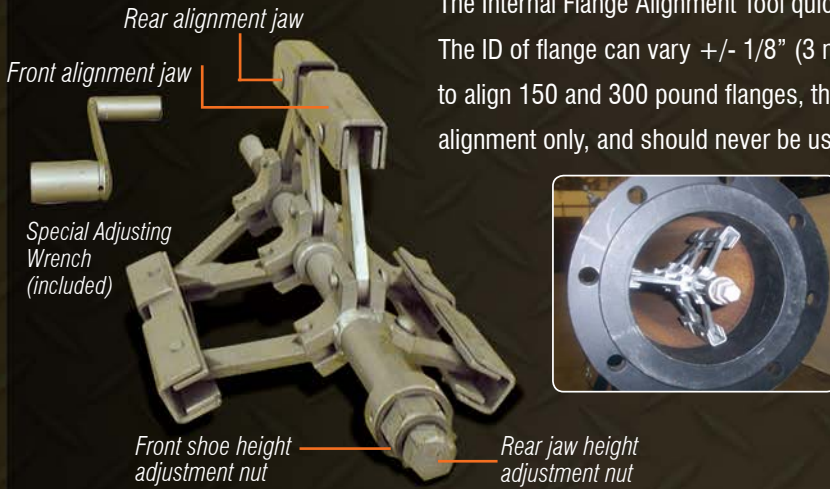
QUIK-FIT CLAMP | SPECIFICATIONS

Item Number	Pipe Size Range in (mm)
QFC-12	1-2 (25-51)
QFC-26	2-6 (51-152)
QFC-512	5-12 (127-305)



PIPEFITTER'S TOOLS

INTERNAL FLANGE ALIGNMENT TOOL



The Internal Flange Alignment Tool quickly and precisely aligns the ID of flange to the ID of pipe. The ID of flange can vary +/- 1/8" (3 mm) to the ID of the pipe and still align perfectly. Designed to align 150 and 300 pound flanges, the Internal Flange Alignment Tool should be used for flange alignment only, and should never be used as the sole support of the flange.

- ACCURATE** | Eliminates guesswork
- FAST** | Flanges can be aligned and squared in as little as one minute
- SAVES TIME & MONEY** | Alignment can be performed by one person

Item 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)

PUSH-BUTTON CARBON STEEL FLANGE LINE UP PINS

Introducing the latest addition to the Mathey Dearman Flange Line Up Pins (FLUP) range, our new push-button carbon steel model. The new Flange Line Up Pin installs and removes quickly thanks to its convenient push-button operation. Rugged ACME thread and rust-resistant black oxide coated carbon steel means you can expect years of reliable use. Our most affordable FLUP still provides the accuracy and ease of use that you've come to expect from quality Mathey Dearman pipefitting tools.

Push-button FLUP



Item Number	Model / Assembly Description	Flange Hole Diameter Range in (mm)
05.0100.020	Push-button Carbon Steel FLUP	5/8" - 1 7/8" (16 - 47)

STAINLESS STEEL FLANGE LINE UP PINS

Mathey Dearman stainless steel Flange Line-up Pins (FLUPS) are available in two styles - Slide-lock and Wobble-nut. Both designs feature a spring-loaded arrangement that enables removal even when flanges expand from welding heat. The Slide-lock style features an easy to use locking lever for release, while the Wobble-nut style uses a clever design that requires less than one spin of the nut to disengage for removal. The wide profile supports a level or square solidly when used in pairs.

Slide-lock FLUP



Wobble-nut FLUP

Item Number	Model / Assembly Description	Flange Hole Diameter Range in (mm)
05.0100.000	Slide-lock FLUP	5/8" - 1 7/8" (16 - 47)
05.0100.010	Wobble-nut FLUP	5/8" - 1 7/8" (16 - 47)



Easy and quick, our FLUPS are sturdy and extremely precise.

FAB BOLTS (FLANGE ALIGNMENT BOLTS)



Safe, fast, and effective solution for even the toughest flange alignment jobs. The tool's tapered shaft eliminates hammering and prying when lining up flange bolt holes.

NEW



Step 1: Place first bolt into pair of aligned holes
Step 2: Place second bolt into mis-aligned holes and turn bolt to align both flange faces

PART NUMBER	DESCRIPTION
FAB.138	1 3/8" FAB
FAB.114	1 1/4" FAB
FAB.118	1 1/8" FAB
FAB.100	1" FAB
FAB.078	7/8" FAB
FAB.034	3/4" FAB
FAB.BOX	Tool Box Only
FAB.KIT	FAB Kit Containing 1 SET of: 3/4", 7/8", 1", 1 1/8", 1 1/4" & 1 3/8"

FLANGE SPREADER



Hydraulic Flange Spreader
ITEM NO. D103

SAFER | Eliminates the need for wedges or hammers
PROTECTS | Greatly reduces risk of damage to the flange face



Mechanical Flange Spreader
ITEM NO. D100

NOTE: FLANGE SPREADERS ARE SOLD INDIVIDUALLY. MOST APPLICATIONS REQUIRE TWO (2) SPREADERS.

Mathey Dearman Flange Spreaders separate flanges safely and easily without hammering. The Spreader, which attaches to the flange holes, spreads the flange faces without damaging flange sealing surfaces. The wedge action of the Spreader widens the gap between flanges up to 1 1/4" (32 mm). 100 ft-lbs of torque applied to the Flange Spreader yields up to 12,000 lbs of spreading force. Hydraulic Flange Spreaders are available for 2" – 36" (51 mm – 914 mm) flanges and use a Hydraulic Pump Kit (sold separately) to easily separate flanges.



A pair of Flange Spreaders quickly separates flanges up to 1 1/4" (32 mm) without damage to the flange sealing area.



Hydraulic Pump Kit
ITEM NO. D104-KIT



Item Number	Style	Flange Size in (mm)	Flange Class (lb)
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 Pump Kit includes pump with reservoir, hoses and quick disconnects.		

PIPEFITTER'S TOOLS

Q.C. WELDER'S GAUGE



The Q.C. Welder's Gauge from Mathey Dearman rapidly and accurately measures inside "High-Low" and plate mismatch before and after welding, minimizing weld rejections. The gauge is available in English and Metric models.

Item Number	Description
D253E	English Q.C. Welder's Gauge
D253M	Metric Q.C. Welder's Gauge
BOX	
D253E-BOX	English Q.C. Welder's Gauge (10 ea)
D253M-BOX	Metric Q.C. Welder's Gauge (10 ea)

PIT DEPTH GAUGE | NOW INCLUDED WITH Q.C. WELDER'S GAUGE

PRECISE | Measures as small as 1/64" (.4 mm)

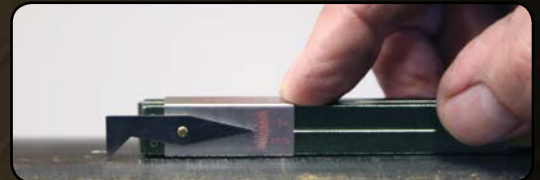
EASY | Simply slide the Pit Depth Gauge over the Q.C. Gauge and take the reading



Measurement 1/64th or .4 mm increments.

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

The Pit Depth Gauge accessory measures pit depth, weld height and outside "High-Low". The stainless steel Pit Depth Gauge mounts on the end of the Q.C. Welder's Gauge housing and displays in both English and Metric measurements.



FRAMING SQUARE



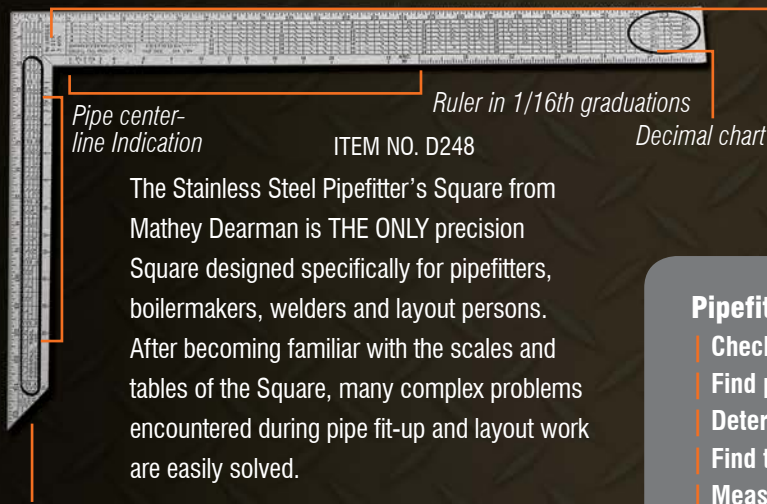
1/8" increments (front & back)
ITEM NO. D256

The Small Stainless Steel Framing Square from Mathey Dearman measures angles, squareness, and find pipe centerline. When used with a level, the Square measures drops in inches per foot to determine slope. The Square is marked in 1/8" increments.

Item Number	Description	Blade Length St x Lg x Thick in (mm)
D256	Small Stainless Steel Framing Square	8 x 12 x 1/16 Thick (203 x 305 x 1.6 Thick)

PIPEFITTER'S SQUARE

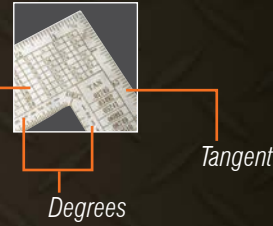
TAN chart is located on the back



ITEM NO. D248

The Stainless Steel Pipefitter's Square from Mathey Dearman is THE ONLY precision Square designed specifically for pipefitters, boilermakers, welders and layout persons. After becoming familiar with the scales and tables of the Square, many complex problems encountered during pipe fit-up and layout work are easily solved.

Set-backs for fit-up of pipe to elbow



Instruction booklet included

Pipefitter'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 equivalents.
- | Layout a variety of weld joint configurations.

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

The Pipefitter's Square can be used to layout a variety of joint configurations, such as miters, tees and diagonals.

HOLD DOWN CLAMPS

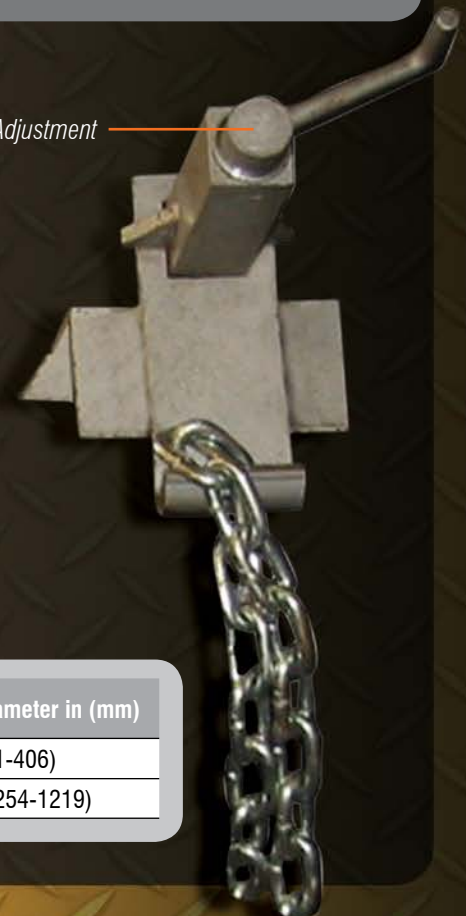
Mathey Dearman Hold Down Clamps safely secure the pipe to a jackstand or table for the fit-up of tees, elbows, flanges and other fittings. Hold Down Clamps can also be used in conjunction with the Level and Support Device to hold pipes or fittings in place during alignment and welding. Lightweight and easy to install, the D244 Hold Down Clamp has a range of 2" – 16" (51 mm – 406 mm) with an 800 lb. working load. The D245 Hold Down Clamp has a range of 10" – 48" (254 mm – 1219 mm) with 1,300 lb. working load. The crank mechanism of the Mathey Dearman Hold Down Clamp takes up slack in the chain to hold the pipe securely in place.

Hold Down Clamps can be used with Chain Clamps for pipe to elbow down and pipe to cross-tee applications

Caution: The clamping chain should be wrapped at the base of the V-Head of the jackstand, not through the legs.

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

Fine Adjustment



PIPEFITTER'S TOOLS



ITEM NO. DK-100

The Large Protractor will measure squareness of pipe ends up to 40" (1016 mm) diameter or can be used to check large pipe miter angles up to 180°. Leg lengths of 48" (1219 mm) & 36" (194 mm)

PROTRACTORS

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



Item No. DXX-250
Length: 6" (152 mm)

The Mini Protractor can be used for a variety of applications including measuring bevel angle.



The Small Protractor is an excellent tool for sheet metal layout, checking squareness of pipe ends up to 17" (432 mm) diameter. It has a large 18" (457mm) leg, a shorter 12" (305mm) leg and it is accurate to $\pm 1^\circ$.



ITEM NO. DK-239

CENTERING HEAD

Mathey Dearman's Centering Head provides a quick and accurate method for establishing pipe centerline, locating points on tanks or pipes, measuring slope, establishing angles and laying keyways. The Centering Head dial face is marked in 2 1/2 degree increments, and can also be used to measure and mark points around the pipe flange or fitting.

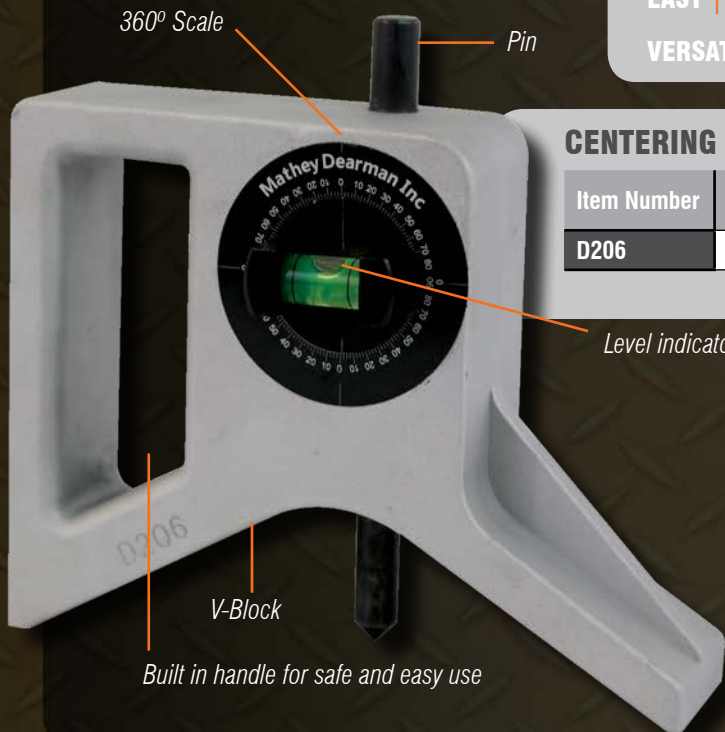
TRUE | Precisely locates top dead center

EASY | Simple and quick to use

VERSATILE | Use to find points on shafts, tanks, or pipe

CENTERING HEAD

Item Number	Description
D206	Centering Head, pipe 1/2" (13 mm) and larger



ITEM NO. D206



SPACING WEDGES

When using Mathey Dearman Chain Clamps, Spacing Wedges enable better fit-up of pipe ends. Wedges are used to create precise weld gap. Simply move the pipe ends together, mount and tighten the chain clamp or cage Clamp and spread the gap to the desired width using the Spacing Wedge. The wedge portion of the Spacing Wedge is case hardened for long life, while the upper part of the Wedge is soft enough to prevent splintering.

Item Number	Description
D271	Spacing Wedge, 8" x 1 1/2" x 1/4" (203 mm x 38 mm x 6.4 mm)
D272	Spacing Wedge, 3 1/2" x 1 1/2" x 1/4" (89 mm x 38 mm x 6.4 mm)
D274	Spacing Wedge, 4" x 3/4" x 1/4" (102 mm x 19 mm x 6.4 mm)
BOXES OF 10	
D271-BOX	D271 Spacing Wedge - Box of 10
D272-BOX	D272 Spacing Wedge - Box of 10
D274-BOX	D274 Spacing Wedge - Box of 10

ITEM NO.
D271 (Large)
D272 (Medium)
D274 (Small)

Clip to belt or
hang in tool box.



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



Weld gap can be quickly set using our Spacing Wedges.

PIPE WRAP

Mathey Dearman Pipe Wrap has double-ruled edges so it is never upside down or backwards. The Wrap can be used as a straight edge to mark straight lines around the pipe and to mark angles for pipe elbows. The Pipe Wrap is constructed of highly abrasion and solvent resistant materials to last under heavy use.

Pipe Wrap Includes:

- | Table of tangents and straight edge
- | Instructions for cutting elbows
- | Sides marked in 1/8" (3.2 mm) increments to 36" (914 mm)
- | Instructions for finding the length of an elbow
- | 45-degree angle chart
- | Degree markings

Pipe Size in (mm)	Size	Item Number	Description
3-15 (76-381)	Medium	D160	Wrap, 4" x 4' / 102 mm x 1219 mm
3-22 (76-559)	Large	D170	Wrap, 4" x 6' / 102 mm x 1829 mm
3-26 (76-660)	Extra Large	D177	Wrap, 4" x 7' / 102 mm x 2134 mm
Pipe size to be specified		D184	4" / 102 mm Width x Length Desired Sold in 1' / 305 mm Increments*
Pipe size to be specified		D185	5" / 127 mm Width x Length Desired Sold in 1' / 305 mm 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 MagnaCut XM Guide Tracks on pipe over 18" (457 mm) to insure a square cut. *Pipe Wrap sold per foot does not have any markings or instructions.

STURDI-JACK

JACK STANDS

High Visibility Neon Green for Safety

Fixed Leg Pipe Stand
Part # D674
2" - 16" Capacity - 2,500 lbs.



Sturdi-Jack Fixed Leg Pipe Stand (2,500 lbs.) -
 Min. Height 29" (74 cm) - Max. 50" (127 cm)

Part Number	Description Range (in.)	Shipping Weight	
		lbs.	kg
D674	Sturdi-Jack™ with Standard V Head 12" - 16" OD capacity/2,500 lb. limit	21	9.5
Parts/Accessories			
D886-001*	Slip-on CS Roller Head (ea.) 1,000 lb. limit	5	2.3
D886-003*	Slip-on SS Ball Transfer (ea.) 1,000 lb. limit	5	2.3
D886-010	Standard V Head (head only)	6	2.7
D886-015	Large V Head (head only)	15	6.8

* Must be used with the D886-015 Large V Head for Pipe OD 12" or greater

STURDI-JACK JR

Folding Low Pipe Stand
Part # D673
2" - 16" Capacity - 2,500 lbs.

Mathey Dearman's Sturdi-Jack JR™ Folding Pipe Stand features a heavy-duty frame with a convenient handle for easy transportation between jobsites.

Its smooth folding action means quick setup and teardown and easier storage when not in use. Three different head options allow the Sturdi-Jack JR™ to perform well in a wide range of applications for pipe 12" - 16" OD.



Working height
19.5" (49.5 cm)
to 33.5" (85 cm)

Sturdi-Jack JR Folding Pipe Stand (2,500 lbs.) -
 Min. Height 19.5" (49.5 cm) - Max. 33.5" (85 cm)

Part Number	Description Range (in.)	Shipping Weight	
		lbs.	kg
D673	Sturdi-Jack JR™ with Standard V Head 12" - 16" OD capacity/2,500 lb. limit	21	9.5
Parts/Accessories			
D886-001*	Slip-on CS Roller Head (ea.) 1,000 lb. limit	5	2.3
D886-003*	Slip-on SS Ball Transfer (ea.) 1,000 lb. limit	5	2.3
D886-010	Standard V Head (head only)	6	2.7
D886-015	Large V Head (head only)	15	6.8

* Must be used with the D886-015 Large V Head for Pipe OD 12" or greater

STURDI-JACK II™

Folding Pipe Stand Part # D675 2" - 16" Capacity - 2,500 lbs.

Mathey Dearman's Sturdi-Jack™ II Folding Pipe Stand features a heavy-duty frame with a convenient handle for easier transportation between jobsites. Its smooth folding action means quick setup and teardown and easier storage when not in use. Three different head options allow the Sturdi-Jack™ II to perform well in a wide range of applications for pipe 2" - 16" OD.



Sturdi-Jack II Folding Pipe Stand (2,500 lbs.) - Min. Height 29" (74 cm) - Max. 50" (127 cm)

Part Number	Description Range (in.)	Shipping Weight	
		lbs.	kg
D675	Sturdi-Jack™ with Standard V Head 2"-16" OD capacity/2,500 lb. limit	25	11.3
Parts/Accessories			
D886-001*	Slip-on CS Roller Head (ea.) 1,000 lb. limit	5	2.3
D886-003*	Slip-on SS Ball Transfer (ea.) 1,000 lb. limit	5	2.3
D886-010	Standard V Head (head only)	6	2.7
D886-015	Large V Head (head only)	15	6.8

* Must be used with the D886-015 Large V Head for Pipe OD 12" or greater

Optional Slip On
CS Roller Head



Optional Slip On
SS Ball Head



STURDI-JACK XL™

Heavy-Duty Rolling Pipe Stand Part # D676 2" - 36" Capacity - 3,500 lbs.

The Sturdi-Jack XL™ rolling Pipe Stand has a heavy-duty frame with an industry leading weight capacity of 3,500 lbs. Five heavy duty locking casters, standard on the Sturdi-Jack™ XL, allow for easier, faster setup. Three different head options allow the Sturdi-Jack™ XL to perform well in a wide range of applications for pipe 2"-36" OD.

Sturdi-Jack XL Rolling Pipe Stand (3,500 lbs.) - Min. Height 32" (81cm) - Max. 42" (107 cm)

Part Number	Description Range (in.)	Shipping Weight	
		lbs.	kg
D676	Sturdi-Jack™ with Large V Head and CS Rollers - 2"-36" OD capacity/3,500 lb. limit	150	67.5
Parts/Accessories			
D886-011	Large V Head (head only)	30	13.5
D886-012	Roller Head (frame only)	26	11.7
D886-013	CS Rollerw with Fasteners (ea.)	2	0.9
D886-014	Slip-on SS Ball Transfer	2	0.9

COUPON CUTTER



An excellent tool for making coupons for bend, tensile strength, and hardness tes

- COUPONS** | Perfect for cutting test coupons for API, ASME and AWS welder certification
- TESTING** | Accurately cuts the same size coupon over and over
- VERSATILITY** | Use gas or plasma torches

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" (102 mm) and larger. A magnetic attachment is used to rapidly fasten the machine to the pipe. The Coupon Cutter now includes a torque spline Feed Screw for rapid torch advance if required.

Item Number	Item/ Assembly Description	Cuts Coupons
03.0300.000	Coupon Cutter	2" x 12" (51 mm x 305 mm)



Smarter. Tougher. Mathey.

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