



GAMMA 110



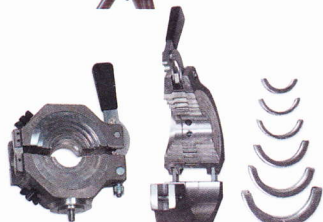
Machine body



Heating plate



Milling cutter



Bends clamps



3-leg machine support



Milling cutter/heating plate support

GAMMA 110

Portable welding machine for the **construction of segmented bends**. Thanks to a special clamp, this machine can also weld moulded fittings like **bends, tees, wyes (Y) and flange necks** up to $\text{Ø}110$ mm. Necks with a highly reduced tang can be welded with the help of a **special tool** (on request), applied to the clamps.

Composed of:

- a **machine body** with pressure regulating device, a **support base** and a **bench vice** for the heating plate;
- an extractable **heating plate** with an automatic electronic temperature control device;
- an electrically controlled extractable **milling cutter** for levelling the ends of the pipe and/or fitting;
- a **pair of special clamps** for making bends (useful also for straight welding);
- a **special right clamp** for welding fittings;
- a **three-leg** machine support;
- a **support** for the milling cutter and the heating plate;
- two **tripod supports** to sustain the pipe;
- a special **bench vice** so the machine can be used on a work bench.

SUPPLIED WITH

- **Machine body** with a support base and bench bracket for the heating plate;
- **TP GAMMA 110 TE plate**;
- **Milling cutter**;
- **Bends clamps $\text{Ø} 110$ mm** (2 pcs.) with **adapters from $\text{Ø} 40$ to 90 mm** (4 pcs./ Ø);
- **Three legs** to sustain the machine (3-leg machine support);
- **Milling cutter/heating plate support**;
- **Pipe support tripod** (2 pcs.);
- **Special vice** (to fix to the welding machine's bench);
- **Wooden transport case**;
- **Steel case** containing a **right special clamp $\text{Ø} 110$ mm** (lower half), extractable upper jaws (1 pc./ Ø) and lower clamp adapters (1 pc./ Ø) $\text{Ø} 40 \div 110$ mm (56 mm Ø excluded), and **tool kit**.

ON REQUEST (ACCESSORIES)

- **Bends clamps adapters $\text{Ø} 25$ and 32 mm** (4 pcs./ Ø) [Ø supplied singly, but $\text{Ø}32$ mm is required to weld $\text{Ø}25$ mm];
- **Right special clamp adapters $\text{Ø} 25, 32, 56$ mm** (1 pc. up + 1 pc. down/ Ø) [Ø supplied singly];
- **Left special clamp $\text{Ø} 110$ mm** (for fitting-fitting welding);
- **Left special clamp adapters from $\text{Ø} 25$ to $\text{Ø} 90$ mm** (1 pc. up + 1 pc. down/ Ø) [Ø supplied singly];
- **Tool** for flange necks;

TECHNICAL FEATURES

Working range	25 ÷ 110 mm	
Power supply	110 V	230 V
	Single phase - 50/60 Hz	
Power absorbed by the TP	800 W	800 W
Power absorbed by the milling cutter	500 W	650 W
Total absorbed power	1300 W	1450 W
Working temperature	180 ÷ 280°C (*)	
Outside temperature range	-5 ÷ +40°C	
Time to reach welding temperature	~ 10 min.	
(*) Materials	PE,PP,PVDF and other plastic materials	

DIMENSIONS (W x D x H)	
Machine body (without clamps)	540 x 180 x 110 mm D: 320 mm (with handwheel)
Heating plate (TP)	430 x 50 x 270 mm
Milling cutter	470 x 85 x 370 mm
Bends clamps with adapters ("Supplied with")	170 x 85 x 200 mm
3-leg machine support	770 x 620 x 740 mm
Milling cutter/heating plate support	225 x 260 x 445 mm
Pipe support tripod	410 x 350 x 880 mm
Transport wooden case	840 x 470 x 390 mm
Steel case	335 x 150 x 90 mm
Right special clamp (lower part)	200 x 60 x 190 mm
Machine being transported (in case)	840 x 470 x 390 mm
Machine working (with 3-leg machine support)	770 x 620 x 1070 mm
Left special clamp	200 x 60 x 190 mm
Tool for flange necks	180 x 110 x 320 mm

WEIGHT	
Machine body (without clamps)	8,00 Kg
Heating plate (TP)	2,30 Kg
Milling cutter	5,55 Kg
Bends clamps with adapters ("Supplied with")(2 pcs.)	5,16 Kg
3-leg machine support	4,00 Kg
Milling cutter/heating plate support	3,30 Kg
Pipe support tripod	2,38 Kg
Transport wooden case	18,00 Kg
Steel case	1,34 Kg
Right special clamp (lower part)	0,95 Kg
Total (GAMMA 110 only)	55,76 Kg
Left special clamp	1,29 Kg
Tool for flange necks	1,64 Kg

Weight (Kg) - bends clamps adapters (4 pcs./Ø - Ø 25 and 32 mm on request)							
Ø 25	Ø 32	Ø 40	Ø 50	Ø 56	Ø 63	Ø 75	Ø 90
0,10	0,10	0,16	0,12	0,20	0,36	0,56	1,00

Weight (Kg) right special clamp extractable upper jaws (1 pc./Ø)								
Ø 25	Ø 32	Ø 40	Ø 50	Ø 56	Ø 63	Ø 75	Ø 90	Ø 110
0,25	0,25	0,30	0,30	0,30	0,31	0,39	0,39	0,39

Weight (Kg) right special clamp lower adapters (*) (1 pc./Ø)							
Ø 25	Ø 32	Ø 40	Ø 50	Ø 56	Ø 63	Ø 75	Ø 90
0,20	0,19	0,17	0,16	0,16	0,14	0,12	0,10

Weight (Kg) left special clamp adapters (*) (2 pcs./Ø)							
Ø 25	Ø 32	Ø 40	Ø 50	Ø 56	Ø 63	Ø 75	Ø 90
0,40	0,38	0,34	0,32	0,32	0,28	0,24	0,20

(*): The right special clamp lower adapters are the same as the left special clamp adapters (up and down).



3-leg pipe support



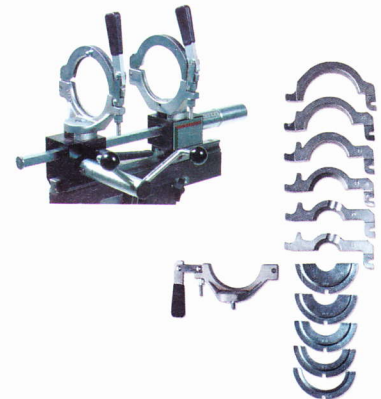
Special bench vice



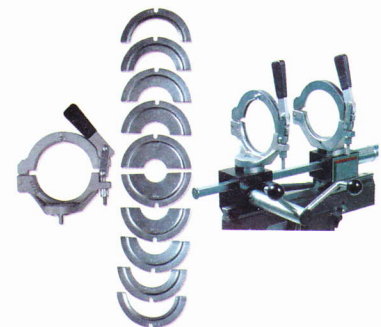
Transport wooden case



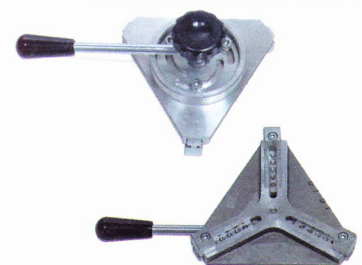
Steel case



Right special clamp



Left special clamp



Tool for flange necks