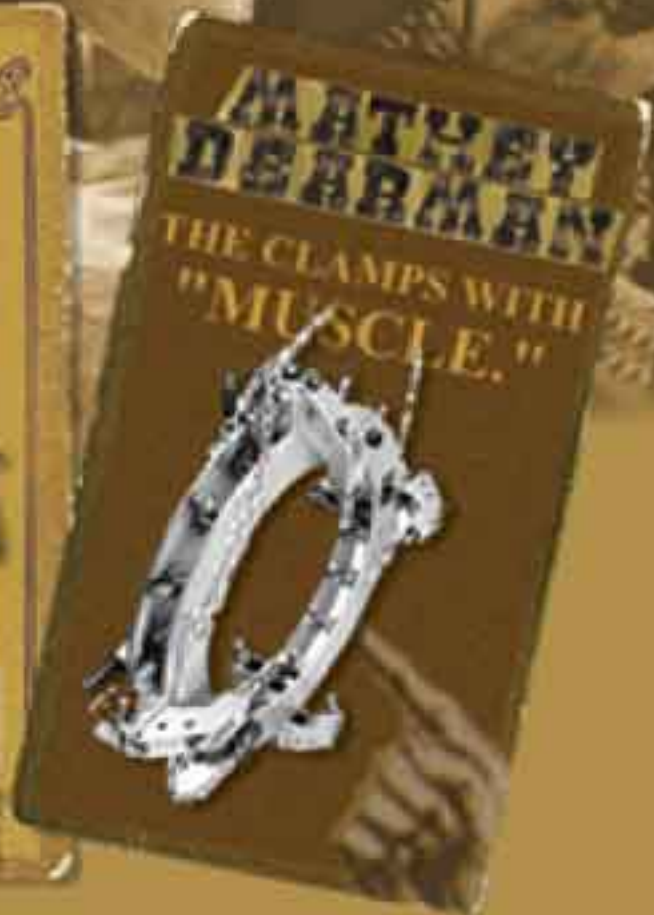
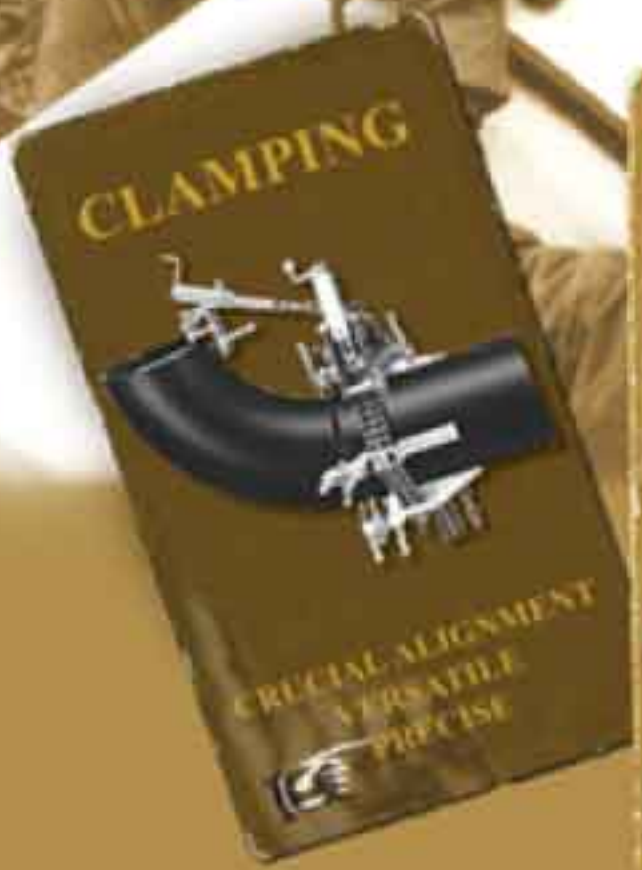


# MATHEY DEARMAN

Tulsa, Ok USA



## Pipe Alignment and Reforming Clamps

June 2004

Copyright © Mathey Dearman, Inc.



**VISIT OUR WEBSITE AT: [www.mathey.com](http://www.mathey.com)**

**The World's Largest Selection  
of Hand Tools Designed Specifically  
for the Pipefitter and Welder.**

**10** *Different  
Pipe Beveling &  
Cutting Machines*

Is your current cutting and beveling method outdated, labor intensive or causing you to miss deliveries? Discover our complete line of innovative cold cutting, flame cutting and beveling machines. Mathey Dearman's precision equipment produces a good-looking, accurate, quality cut requiring little or no grinding.

**15** *Different  
Clamping &  
Aligning Systems*

Have a clamping application that is causing you to lose sleep at night? Put the fun back into your life! We offer several advanced methods of achieving, quick and accurate alignment or reforming of pipes, elbows, tees and other fittings, while providing the maximum amount of safety for the welder.

**24** *Different  
Pipefitter's Tools*

Does the pipe or plate job that you are working on require precise job alignment? Discover our sensational line of Pipefitter's Tools to help you achieve and check the alignment that is required.

**16** *Different  
Welding Electrode  
& Flux Ovens*  
FREE CONSULTING

Need to keep or rebake welding electrodes or flux? Our proven line of small or large Keeping and Rebaking Ovens are known throughout the WORLD for their quality and craftsmanship.

**SATISFACTION  
GUARANTEED**

**Contact Us Today to Solve All  
of Your Fitting and Alignment Needs!**

**SATISFACTION  
GUARANTEED**



Phone: (918) 447-1288  
Fax: (918) 447-0188  
Toll Free: 1-800-725-7311  
Email: [sales@mathey.com](mailto:sales@mathey.com)

4344 S. Maybelle Avenue • Tulsa, Ok USA 74107 • P.O. Box 472110 • Tulsa, Ok USA 74147







# Our Products - Pipe Alignment and Reforming Chain Clamps


## External Aligning and Reforming Chain Clamps

	Mathey Dearman Chain Clamp.....02
	Single Jackscrew.....06
	Double Jackscrew.....08
	Dearman Light.....10
	Universal Clamp.....12
	Double Chain Clamp.....14
	Chain and Conn Link Chart.....21
	Hydraulic Double Chain Clamp.....16
	Add-on Jackbar.....18
	Chain Clamp Parts Jackbars.....18
	Chain Clamp Accessories.....19
	Main Block
	Fine Adjustment
	Level and Support Device
	Spacing Screws
	Chain and Connecting Links

## Other Clamps

	Pipe Puller.....17
	Hold Down Clamp.....22
	Rim Clamp.....23
	Mega Rim Clamp.....27
	Rim Clamp Accessories.....28
	Cage Clamp.....29
	Pipe Tongs.....33

 Manufactured in NAFTA Countries

 Manufactured in E.U. Countries

## Small Diameter Clamps

	Accu-Fit.....34
	Accu-Fit Variable Angle Clamp.....35
	EZ-Fit.....36
	Mini Fit.....38
	Manual Internal Alignment Clamp.....39
	Internal Pneumatic Alignment Clamp.....40

## Appendix

	Pipe Alignment and Reforming Clamps Explained.....41
	Customer Ratings.....43
	Clamp Selection Chart - Questionnaire.....44
	Credit Application.....45
	Order Form.....46
	Mathey Dearman Warranty.....47

### PIPE SIZES AND WALL THICKNESS CHART (Inside Back Cover)

"Last year we had a project that required the elimination of pipe ovality in order that an I.D. mounted beveling machine could realize proper bevel and counterbore. With the use of a Mathey Dearman Rim Clamp, the necessary bevel tolerances were achieved."

Jeff Scott  
Triten Corporation

## In Focus:

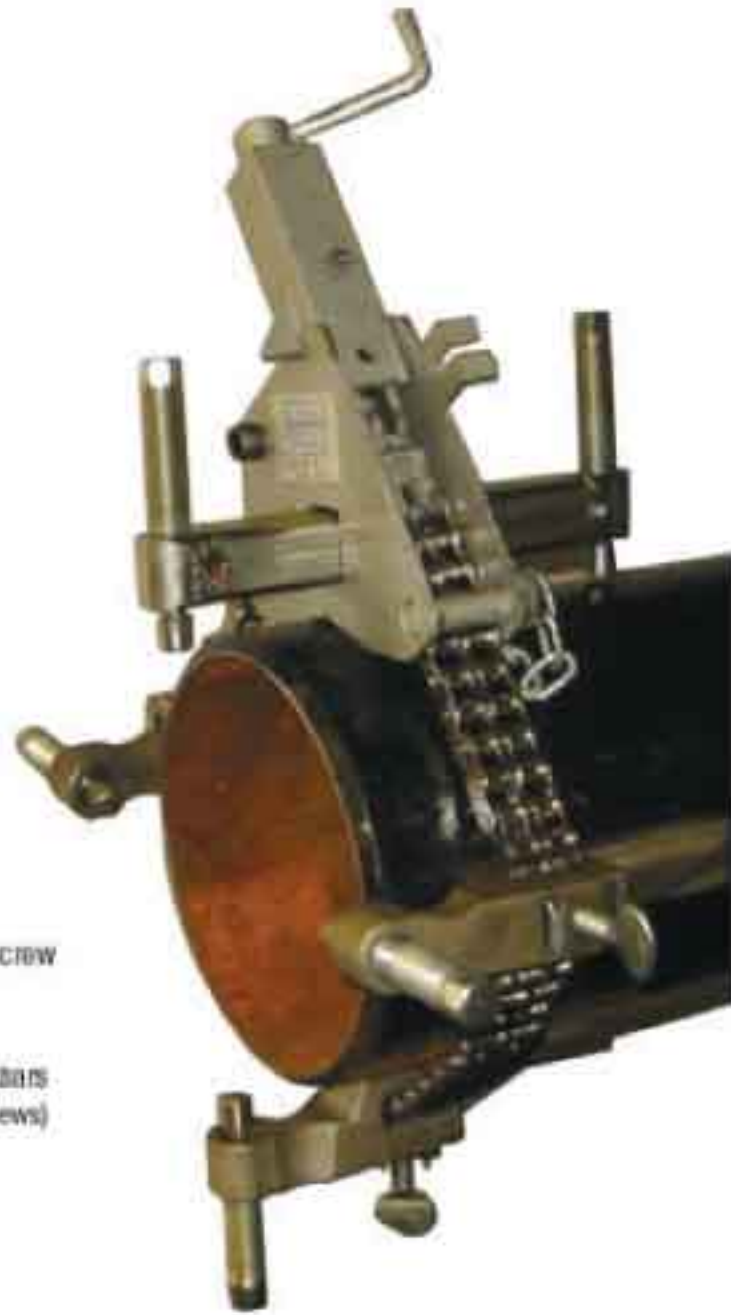
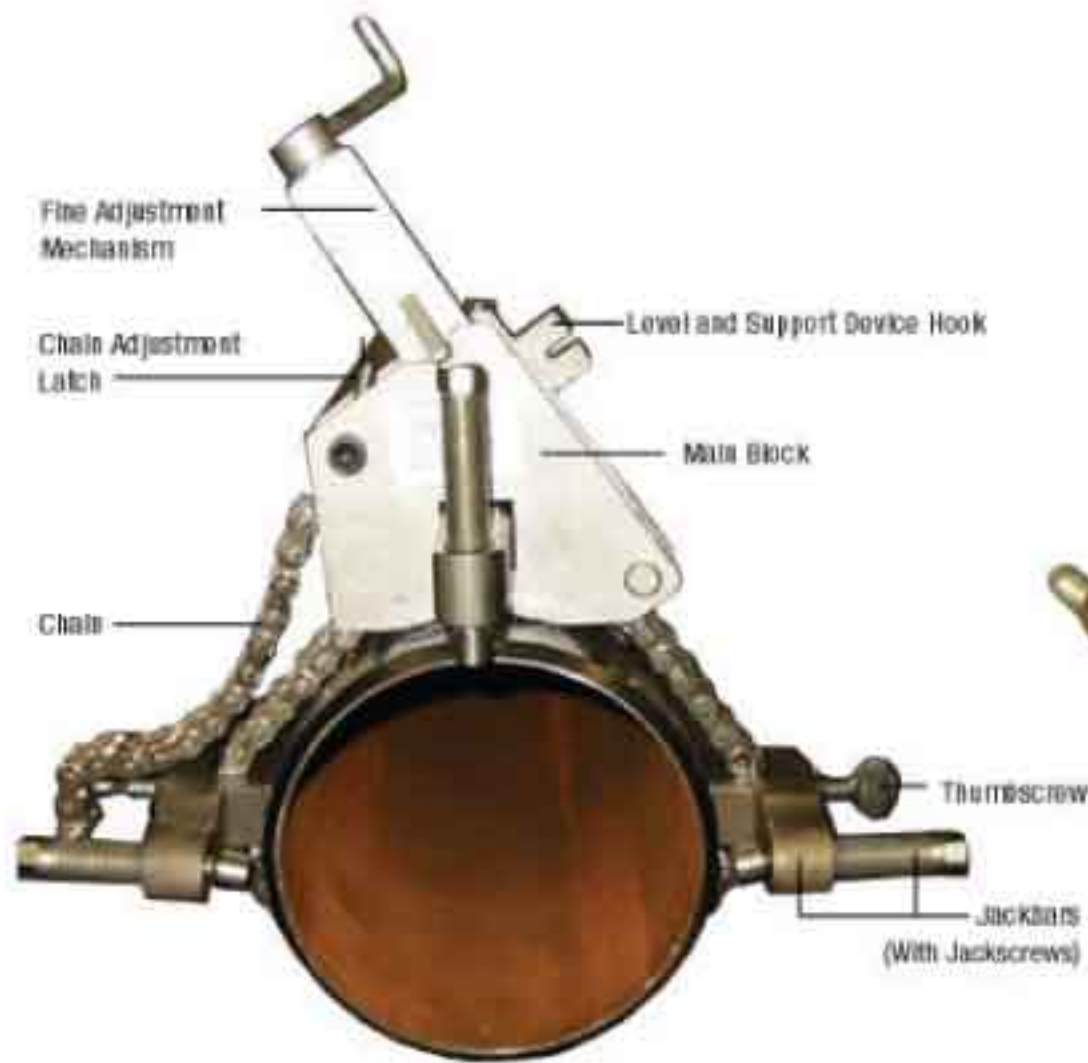
### Who uses Mathey Dearman Equipment?

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

.....AND MANY OTHERS!

## ALIGNMENT AND REFORMING CHAIN CLAMPS

(All Clamps pictured are Single Screw Jackbar.)



Straight Pipe



Tee In-Line



## ALIGNMENT AND REFORMING CHAIN CLAMPS



Elbow Down  
(Single Screw Jackbar)



Elbow Up  
(Universal Jackbar)

### Process Improvement

**M**athey Dearman Chain Clamps "align Schedule 80 and "reform Schedule 40 pipes, elbows, tees and other fittings" within their range, while providing the maximum amount of safety for the welder. Whether the process involves aligning and/or reforming small tubes or large vessels, a clamp is available to fit the process requirements. Five (5) distinct Chain Clamp Models are available to accomplish the critical alignment and reforming of pipes and fittings to improve "upstream processes" that have a substantial impact on product quality and performance.

The Original and Light Chain Clamp, with Level and Support Device, are designed to achieve the critical alignment of elbows, tees and other fittings reducing rework required due to poor weld joint alignment. The Hydraulic Double Chain Clamp is a "specially engineered" clamp for the rapid clamping and alignment of large diameter pipes and shells.

Mathey Dearman Chain Clamps eliminate the need for such items as bottle or house jacks, weld-on lugs and cable hoists that present a safety risk to the welder.



Cross-tee Horizontal  
(Single Screw Jackbar)



Cross-tee Vertical  
(Single Screw Jackbar)



## ALIGNMENT AND REFORMING CHAIN CLAMPS

The Mathey Dearman Chain Clamp is adjustable for an enormous amount of fit-up applications on a variety of pipe and fittings, valves and flanges. By removing the Chain Stop and the Main Block from the Chain and sliding the Jackbar on the chain, the Jackbars may be added or removed from the clamp

as required. Reinstall the Chain through the Main Block and re-attach the Chain Stop. Jackbars can also be removed using the same process. Before beginning the fit-up, be sure that bent and distorted pipe edges are repaired.



Determine hand placement on the clamp for easy installation on the pipe. Let out enough chain so that the clamp fits around the pipe.



Place the clamp on the pipe so that the Main Block is top-center on the pipe.



Place the Fine Adjustment into the notch on the Main Block and install the Chain Locking Pin.



Grasp the Fine Adjustment and pull the excess chain through the Block Chain Dog of the Main Block to snug the chain around the pipe.



Adjust the Jackbars as needed around the pipe for proper support and tighten thumbscrew on Jackbar to hold the Jackbar in place.



Check all Jackscrews to make sure they do not extend past the part of the Jackbar that contacts the pipe.



## ALIGNMENT AND REFORMING CHAIN CLAMPS

(Continued.)



Rotate the Fine Adjustment Handle to tighten the clamp on the pipe.



Adjust the Jackscrew Swivel Pads to make direct contact with the pipe.



Rotate the Fine Adjustment Handle enough to open that the clamp can be moved over the end of the pipe.



Center the clamp over the joint to be welded and tighten the Fine Adjustment.



Backoff the Jackscrew in the Universal Jackbar in the Main Block and turn the Jackbars 1 to 2 full turns to tighten and insert the pipe or fitting into the clamp.



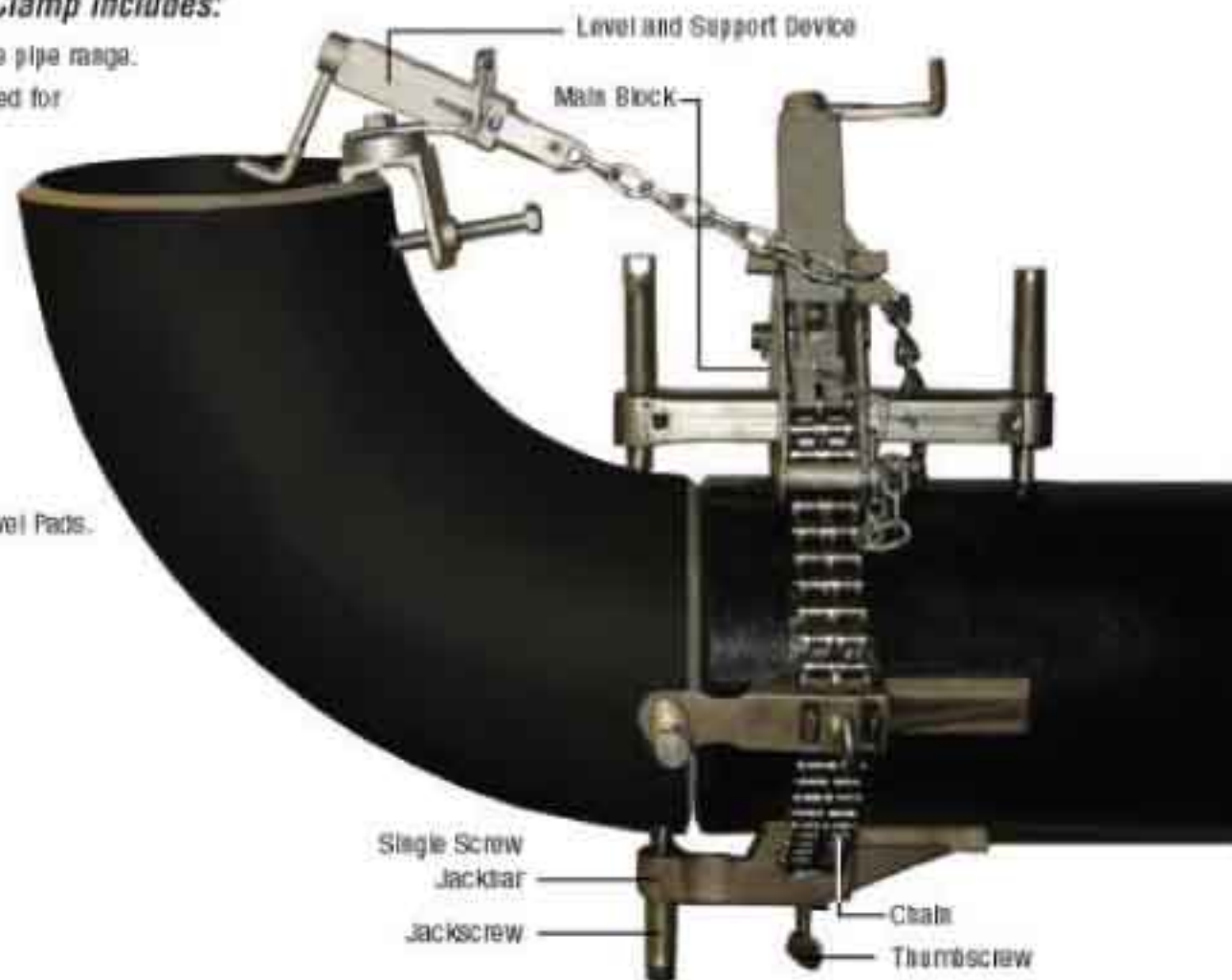
Tighten or loosen the Jackscrews as needed to obtain the proper "Hi-Lo"™ of the inside or outside diameter of the pipe.



## Single Jackscrew Chain Clamp

### Single Jackscrew Chain Clamp Includes:

- Length of Chain required for the pipe range.
- Single Jackscrew Jackbars listed for the pipe range.
- Main Block.
- Fine Adjustment.
- Level and Support Device.
- Jackscrew Wrench.
- Storage Box.
- Parts and Operating Manual.
- Carbon or Stainless Steel Spacing Screws (Optional).
- Jackscrews available with Swivel Pads.



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

The Single Jackscrew Chain Clamp reforms the mating side of the weld gap only, and is capable of "reforming up to Schedule 40 Pipe". The Jackscrews of the Jackbar exert pressure on the high points of the mating pipe eliminating "High-Lo"™ as pipe and fittings are aligned. Pipe wall thickness to "Schedule 80 can be aligned" with the Single Jackscrew Chain Clamp. The Level and Support Device of the Chain Clamp allows the pipe, elbow, tee, flange and other fittings to be held safely and securely in place during the alignment and welding process. For Stainless Steel or specialty alloy applications replace the chain of the standard Chain Clamp with Stainless Steel Chain. Available in steel and Stainless Steel models to fit pipe from 1" / 25mm to 54" / 1372mm.

- **ACCURATE** – The Single Screw Jackbars, spaced around the circumference of the pipe, provides precise alignment of the inside or outside diameter of the mating pipe to the main pipe within 1/64 of an inch.

- **PRECISELY ALIGNS** pipe wall thickness to Schedule 80.
- **EFFORTLESSLY REFORMS** mating pipe wall thickness to Schedule 40 Pipe.
- **SAFE** – Elbows, tees, flanges and other fittings can be supported with the Level and Support Device reducing the risk of back injury.
- **VERSATILE** – The Clamp will align and reform pipe, elbows, tees and other fittings.
- One Chain Clamp covers the range of Eight (8) Cage Clamps.
- Pipe and other fittings can be fully welded without removal of the clamp.
- The Jackscrew Pads independently pivot to handle uneven surfaces.
- An Add-On Jackbar can be added if pressure needs to be applied between the Clamp Jackbars.
- Spacing Screws can be added for precise weld gap adjustment.



## Single Jackscrew Chain Clamp



Single Jackscrew Jackbar



The "High-Lo"<sup>™</sup> of the pipe can be effortlessly reformed to meet the inside or outside diameter of the mating pipe with Jackscrews in the Jackbar.

### Single Jackscrew Chain Clamp - Specifications

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

SS - Indicates Clamp is for Stainless Steel application.

(See Inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)

#### Warning:

The clamp should never be used as the sole support of the pipe.

The clamp should never be used to lift the pipe.

#### Danger:

Do not exceed pipe size range listed prior to contacting the Mathey Dearman Sales Department.

Do not use any other type of chain than those listed above prior to contacting Mathey Dearman Sales Department.

Use of chain not supplied with clamp by Mathey Dearman, Inc. will VOID the Warranty of the clamp.

### Single Jackscrew Chain Clamp Kit (Less Chain)

Model	Pipe Size Range	Reforms Pipes to Schedule*	Aligns Pipe to Schedule*	Type of Chain Required	Chain Length Required Ft. / M	Estimated Shipping Weight Lbs. / Kg
D231-Kit	1-8 / 25-203	40	80	1	3 / 1	19 / 9
D232-Kit	4-16 / 102-406	40	80	2	5 / 1.5	59 / 27

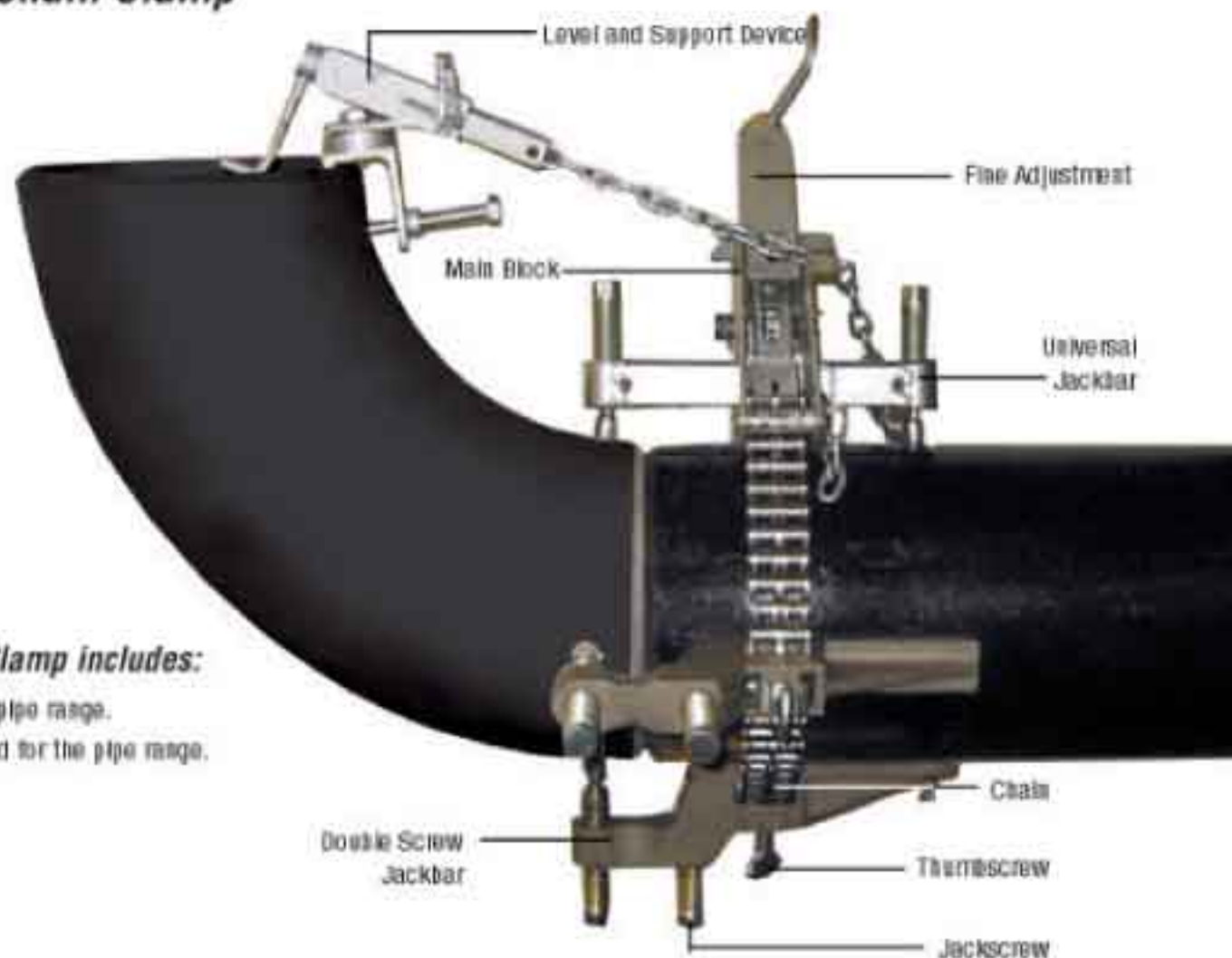
\* Calculations are based on pipe with a yield strength of 45,000lbs. / 20,412kg.

Clamp Kit consists of Main Block, Fine Adjustment, Level and Support, Single Jackscrew Jackbars for its range, Storage Box and Operating Manual.

1. 40-2: Riveted Nickel Plated Roller or 40-2: Riveted Stainless Steel Roller Chain (ANSI#: 40-2R or equal)
2. 60-2: Riveted Nickel Plated Roller or 60-2: Riveted Stainless Steel Roller Chain (ANSI#: 60-2R or equal)



## Double Jackscrew Chain Clamp



### Double Jackscrew Chain Clamp includes:

- Length of Chain required for the pipe range.
- Double Jackscrew Jackbars listed for the pipe range.
- Main Block.
- Fine Adjustment.
- Level and Support Device.
- Jackscrew Wrench.
- Storage Box.
- Parts and Operating Manual.
- Carbon or Stainless Steel Spacing Screws (Optional).
- Jackscrews available with Swivel Pads.

All Double Jackscrew Chain Clamps come with Level and Support Device.

The Double Jackscrew Chain Clamp "reforms Schedule 40 Pipe" located on either side of the joint to be welded. The Jackscrews of the Jackbar exert pressure on the high points of both sides of the weld joint to eliminate "High-Lo"™. Pipe wall thickness "up to Schedule 80 can be aligned" with the Clamp. The Level and Support Device of the Chain Clamp allows the pipe, elbow, tee, flange and other fittings to be held safely and securely in place during the alignment and welding process. For Stainless Steel or specialty alloy applications replace the chain of the standard Chain Clamp with Stainless Steel Chain. Available in steel and Stainless Steel models to fit pipe from 1" / 25mm to 54" / 1372mm.

- **CRUCIAL ALIGNMENT** – The Double Jackbars, spaced around the outside diameter of the pipe, provide concise alignment and reforming of the internal or external diameters of both pipes within 1/64 of an inch.
- **EXTRA CLEARANCE** – Double Jackscrew Jackbar has extra clearance under the Jackbar to better facilitate Tig Welding Torch.

- **SAFE** – Elbows, tees and other fittings can be held safely and securely in place during alignment with the Level and Support Device.
- **VERSATILE** – The Chain Clamp can be used to support, align, and reform elbow, tees and other fittings that cage clamp can not manage. One Chain Clamp covers the range of Eight (8) CageClamps.
- **READILY REFORMS** pipes on both sides of the weld joint to Schedule 40 Pipe and ALIGNS Schedule 80 Pipes, elbows, tees and other fittings.
- **FLAWLESSLY ALIGNS** pipe wall thickness to Schedule 80.
- Complete welding of the pipe and fittings can be accomplished without removal of the clamp.
- Add-On Jackbar can be added if pressure needs to be applied between the Clamp Jackbars.
- Jackscrew Pads independently pivot to handle uneven surfaces.
- Spacing Screws can be added for precise weld gap adjustment.



## Double Jackscrew Chain Clamp



Double Jackscrew Jackbar

### Double Jackscrew Chain Clamp – Specifications

Model	Number of Jackbars	Pipe Size Range (In./mm)	Reforms Pipes to Schedule*	Aligns Pipes to Schedule	Estimated Shipping Weight (lbs./kg)
D250	3	1-8 / 25-203	40	80	27 / 12
D250SS	3	1-8 / 25-203	40	80	27 / 12
D249	7	4-16 / 102-406	40	80	72 / 33
D249SS	7	4-16 / 102-406	40	80	72 / 33
D295	6	10-36 / 254-914	40	80	144 / 67
D295SS	6	10-36 / 254-914	40	80	144 / 67
D236	13	10-54 / 254-1372	40	80	180 / 82
D236SS	13	10-54 / 254-1372	40	80	180 / 82

SS - indicates Clamp is for Stainless Steel application.

(See Inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)

### Double Jackscrew Chain Clamp Kit (Less Chain)

Model	Pipe Size Range	Reforms Pipes to Schedule*	Aligns Pipe to Schedule*	Type of Chain Required	Chain Length Required Ft. / M	Estimated Shipping Weight Lbs. / Kg
D250-KR	1-8 / 25-203	40	80	1	3 / 1	19 / 9
D249-KR	4-16 / 102-406	40	80	2	5 / 1.5	59 / 27

\* Calculations are based on pipe with a yield strength of 45,000lbs. / 20,412kg.

Clamp Kit consists of Main Block, Fine Adjustment, Level and Support, Double Jackscrew Jackbars for its range, Storage Box and Operating Manual.

1. 40-2: Riveted Nickel Plated Roller or 40-2: Riveted Stainless Steel Roller Chain (ANSI#: 40-2R or equal)
2. 60-2: Riveted Nickel Plated Roller or 60-2: Riveted Stainless Steel Roller Chain (ANSI#: 60-2R or equal)

### **Warning:**

The clamp should never be used as the sole support of the pipe.

The clamp should never be used to lift the pipe.

### **Danger:**

Do not exceed pipe size range listed prior to contacting the Mathey Dearman Sales Department.

Do not use any other type of chain than those listed above prior to contacting Mathey Dearman Sales Department.

Use of chain not supplied with clamp by Mathey Dearman, Inc. will VOID the Warranty of the clamp.



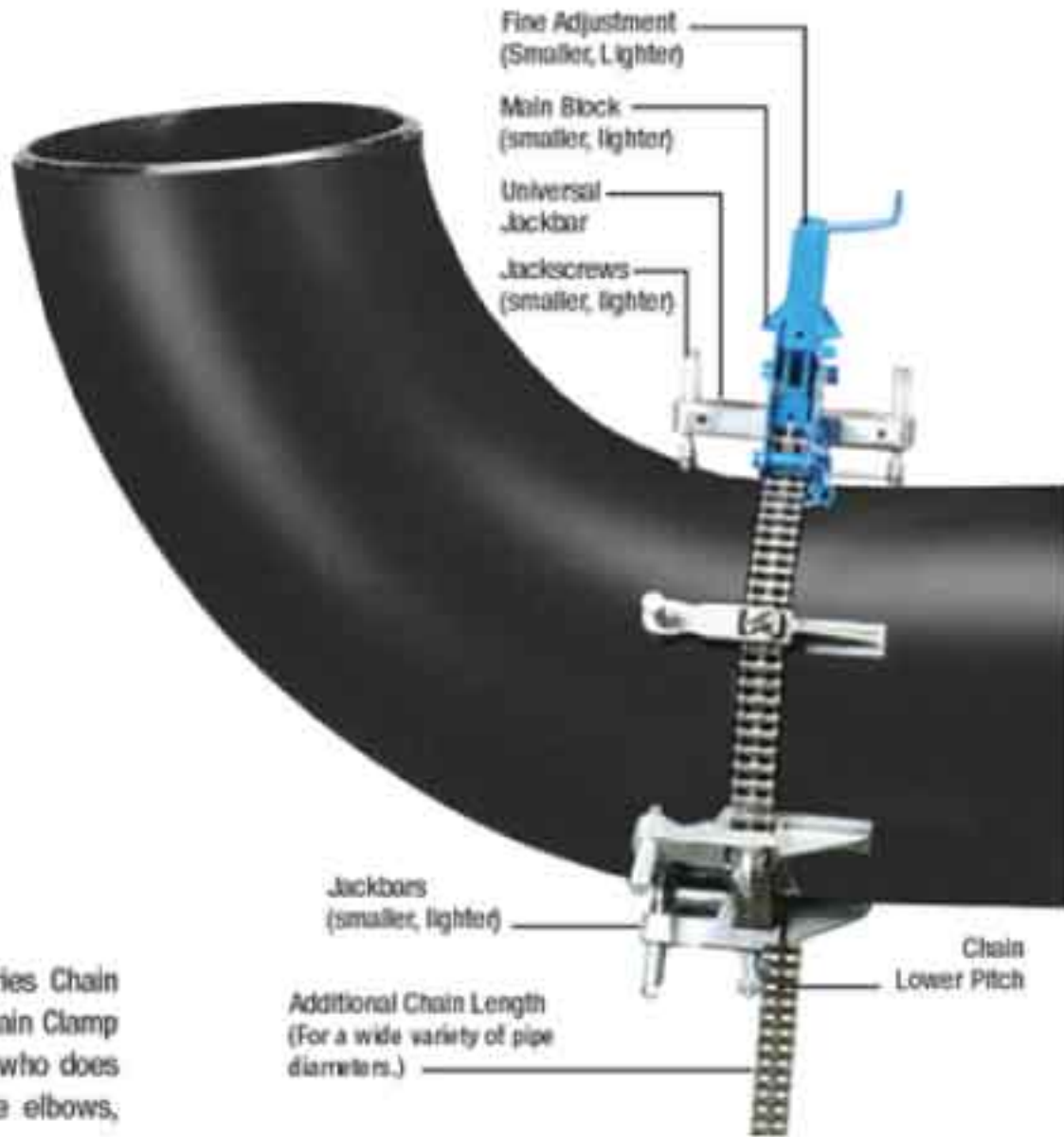
## Dearman Light Chain Clamp

### Single and Double Jackscrew Light Chain Clamps include:

- Length of Chain required for the pipe range.
- Single or Double Jackscrew Jackbars listed for the pipe range.
- Main Block.
- Fine Adjustment.
- Level and Support Device (Level and Support Device not included with D231-LT and D231-LTSS.)
- Jackscrew Wrench.
- Storage Box (Storage Box not included with D231-LT and D231-LTSS.)
- Parts and Operating Manual.
- Carbon or Stainless Steel Spacing Screws (Optional).
- Jackscrews available with Swivel Pads.



The Dearman Light Series Chain Clamps are the ideal Chain Clamp for the welder or fitter who does not need to reform the elbows, tees or other fittings.



The Dearman Light Series of Chain Clamps are durable and versatile as the Original Dearman Chain Clamp "aligns up to Schedule 40 Pipe". The Jackscrews in the Jackbar give the welder the ability to obtain the optimum fit-up of the pipes or fittings to be joined. The Light Weight Clamp can be rapidly adjusted to any pipe diameter by pulling the chain through the Main Block. Precision outside or inside diameter alignment can be quickly obtained without operator fatigue. The Level and Support Device assists the welder in holding and accurately positioning pipe or fittings for welding. Available in steel and stainless steel models for pipe 1" to 36" / 25mm to 1372mm in diameter.

- **ACCURATE** – The Jackbars, spaced around the circumference of the pipe, provide concise alignment of the pipe internal or external diameters within 1/64 of an inch.
- **LESS FATIGUE** – The Lightweight Dearman Light Chain Clamp is best tool for alignment of pipes and fittings when reforming is not required.
- **THINK LIGHT** – The 1" – 12" / 25 – 305mm Dearman Light. The Clamp weighs 50% less than the 8" / 203mm hand lever cage clamp.

- **SAFE** – Elbows, tees, flanges and other fittings can be held safely and securely in place during alignment with the Level and Support Device.
- **VERSATILE** – One Chain Clamp covers the average range of Eleven (11) Cage Clamps.
- **SAVE** – The Dearman Light Chain Clamp costs 50% less than the Cage Clamp for the same pipe range.
- Spacing Screws can be added for precise weld gap adjustment.
- **PRECISELY ALIGNS** pipe wall thickness to Schedule 40 and reforms pipes to Schedule 20 Pipe.
- Complete welding of the pipe and fittings can be accomplished without removal of the Clamp.
- Add-On Jackbar can be added to most models when pressure needs to be applied between the Clamp Jackbars.
- Jackscrew Pads independently pivot to handle uneven surfaces.
- Spacing Screws can be added for precise weld gap adjustment.



## Dearman Light Chain Clamp

### Dearman Light Single Jackscrew Chain Clamp

Model	Number of Jackbars	Pipe Size Range (in./mm)	Reforms Pipes to Schedule*	Aligns Pipes to Schedule	Estimated Shipping Weight (lbs./kg)
D231-LT	5	1-12 / 25-305	20	40	13 / 6
D231-LTSS	5	1-12 / 25-305	20	40	13 / 6
D232-LT	7	4-20 / 102-508	20	40	31 / 14
D232-LTSS	7	4-20 / 102-508	20	40	31 / 14
D233-LT	10	6-36 / 152-914	20	40	84 / 38
D233-LTSS	10	6-36 / 152-914	20	40	84 / 38

\* Calculations are based on pipe with a yield strength of 45,000lbs / 20,412kg.  
SS - Indicates Clamp is for Stainless Steel application.

(See inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)

### Dearman Light Double Jackscrew Chain Clamp

Model	Number of Jackbars	Pipe Size Range (in./mm)	Reforms Pipes to Schedule*	Aligns Pipes to Schedule	Estimated Shipping Weight (lbs./kg)
D249-LT	7	4-20 / 102-508	20	40	36 / 17
D249-LTSS	7	4-20 / 102-508	20	40	36 / 17
D235-LT	10	6-36 / 152-914	20	40	90 / 41
D235-LTSS	10	6-36 / 152-914	20	40	90 / 41

\* Calculations are based on pipe with a yield strength of 45,000lbs / 20,412kg.  
SS - Indicates Clamp is for Stainless Steel application.

(See inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)

### Dearman Light Single Jackscrew Chain Clamp Kit (Less Chain)

Model	Pipe Size Range	Reforms Pipes to Schedule*	Aligns Pipe to Schedule*	Type of Chain Required	Chain Length Required Ft. / M	Estimated Shipping Weight Lbs. / Kg
D231-LTKR	1-12 / 25-305	20	40	1	4 / 1.2	10 / 5
D232-LTKR	4-20 / 102-508	20	40	2	7 / 2.1	25 / 11
D233-LTKR	6-36 / 152-914	20	40	2	10 / 3	89 / 40

### Dearman Light Double Jackscrew Chain Clamp Kit (Less Chain)

Model	Pipe Size Range	Reforms Pipes to Schedule*	Aligns Pipe to Schedule*	Type of Chain Required	Chain Length Required Ft. / M	Estimated Shipping Weight Lbs. / Kg
D249-LTKR	1-12 / 25-305	20	40	1	7 / 2.1	29 / 13
D235-LTKR	4-20 / 102-508	20	40	2	10 / 3	70 / 32

\* Calculations are based on pipe with a yield strength of 45,000lbs. / 20,412kg.

Clamp Kit consists of Main Block, Fine Adjustment, Level and Support, Dearman Light Single Jackscrew Jackbars / Double Light Jackscrew Jackbars for its range, Storage Box and Operating Manual.

- 1, 40-2: Riveted Nickel Plated Roller or 40-2: Riveted Stainless Steel Roller Chain (ANSI#: 40-2R or equal)
- 2, 60-2: Riveted Nickel Plated Roller or 60-2: Riveted Stainless Steel Roller Chain (ANSI#: 60-2R or equal)



When reforming is not required, one Dearman Light Chain Clamp covers an average range of Ten (10) Cage Type Chain Clamps at One-Half (1/2) the price.

#### **Warning:**

The clamp should never be used as the sole support of the pipe.

The clamp should never be used to lift the pipe.

#### **Danger:**

Do not exceed pipe size range listed prior to contacting the Mathey Dearman Sales Department.

Do not use any other type of chain than those listed above prior to contacting Mathey Dearman Sales Department.

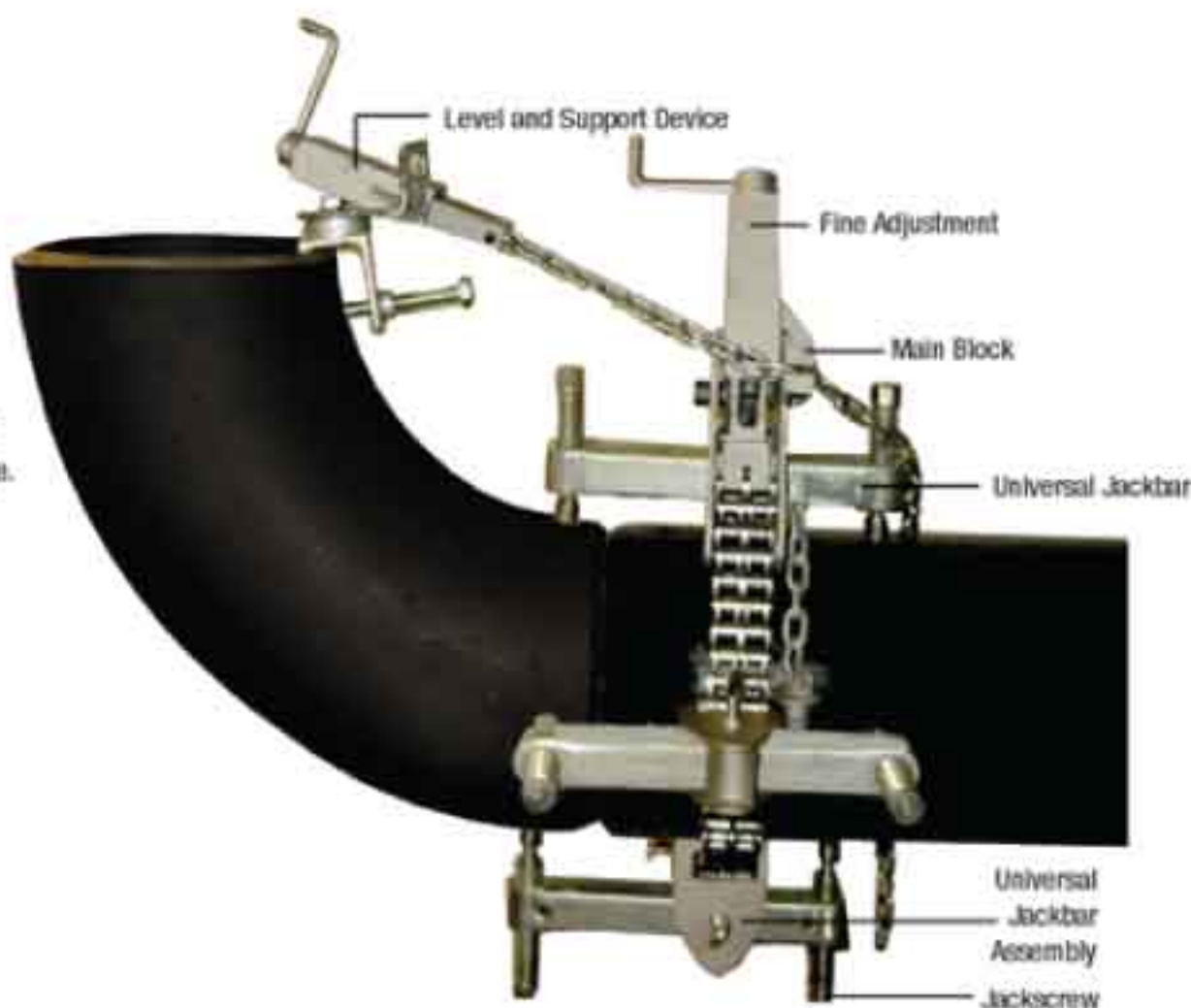
Use of chain not supplied with clamp by Mathey Dearman, Inc. will VOID the Warranty of the clamp.



## Universal Chain Clamp

### Universal Chain Clamps include:

- Length of Chain required for the pipe range.
- Universal Jackbars listed for the pipe range.
- Main Block.
- Fine Adjustment.
- Level and Support Device.
- Jackscrew Wrench.
- Storage Box.
- Parts and Operating Manual.
- Carbon or Stainless Steel Spacing Screws (Optional)
- Jackscrews available with Swivel Pads.



Complete welding and grinding of the pipe and fittings can be performed without removal of the Universal Clamp.

The Universal Chain Clamps are as tough and versatile as the Original Dearman Chain Clamp. The Universal Jackbar's design gives the welder the ability to accurately fit-up and in addition weld and grind the pipe without removal of the clamp. The Level and Support Device of the Chain Clamp allows the pipe, elbow, tee, flange and other fittings to be held safely and securely in place during the alignment and welding process. For Stainless Steel or specialty alloy applications replace the chain of the standard Chain Clamp with Stainless Steel Chain. Available in steel and Stainless Steel models to fit pipe from 1" / 25mm to 54" / 1372mm.

- **PRECISE** – Jackbars, spaced around the diameter of the pipe, provide support and concise alignment of the pipe internal or external diameter within 1/64 of an inch.

- **SAFE** – Jackbars can be moved backward and forward in the Jackbar Holder as needed for extra support under elbows, tees and other fittings.
- **VERSATILE** – One Chain Clamp covers the range of Eight (8) Cage Clamps.
- **REFORMS** pipes to Schedule 20 Pipe and aligns pipes to Schedule 40.
- Complete welding and grinding of the pipe and fittings can be performed without removal of the clamp.
- Add-On Jackbar can be added to most models when pressure needs to be applied between the Clamp Jackbars.
- Jackscrew Pads independently pivot to handle uneven surfaces.
- Spacing Screws can be added for precise weld gap adjustment.



## Universal Chain Clamp



Universal Jackbar



The Universal Chain Clamp Jackbars will slide backward and forward in the Holder Block as needed to provide more or less support under mating pipes, elbows, tees and other fittings.

### Universal Chain Clamp – Specifications

Model	Number of Jackbars	Reforms Pipe To Schedule*	Aligning Pipe To Schedule	Pipe Size Range (In./mm)	Estimated Shipping Weight (lbs./kg)
02250	3	20	40	1-8 / 25-203	25 / 11
02250SS	3	20	40	1-8 / 25-203	25 / 11
02249	7	20	40	4-16 / 102-406	70 / 32
02249SS	7	20	40	4-16 / 102-406	70 / 32
02235	8	20	40	10-36 / 254-914	145 / 65
02235SS	8	20	40	10-36 / 254-914	145 / 65

SS - Indicates Clamp is for Stainless Steel application.

(See Inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)

### Universal Chain Clamp Kit (Less Chain)

Model	Pipe Size Range	Reforms Pipes to Schedule*	Aligns Pipe to Schedule*	Type of Chain Required	Chain Length Required Ft. / M	Estimated Shipping Weight Lbs. / Kg
02250-KIT	1-8 / 25-203	20	40	1	3 / 1	19 / 9
02249-KIT	4-16 / 102-406	20	40	2	5 / 1.5	59 / 27

\* Calculations are based on pipe with a yield strength of 45,000lbs. / 20,412kg.

Clamp Kit consists of Main Block, Fine Adjustment, Level and Support, Universal Jackscrew Jackbars for its range, Storage Box and Operating Manual.

1. 40-2: Riveted Nickel Plated Roller or 40-2: Riveted Stainless Steel Roller Chain (ANSI#: 40-2R or equal)
2. 60-2: Riveted Nickel Plated Roller or 60-2: Riveted Stainless Steel Roller Chain (ANSI#: 60-2R or equal)

#### **Warning:**

The clamp should never be used as the sole support of the pipe.

The clamp should never be used to lift the pipe.

Use of chain not supplied with clamp by Mathey Dearman, Inc. will VOID the Warranty of the clamp.

#### **Danger:**

Do not exceed pipe size range listed prior to contacting the Mathey Dearman Sales Department.

Do not use any other type of chain than those listed above prior to contacting Mathey Dearman Sales Department.

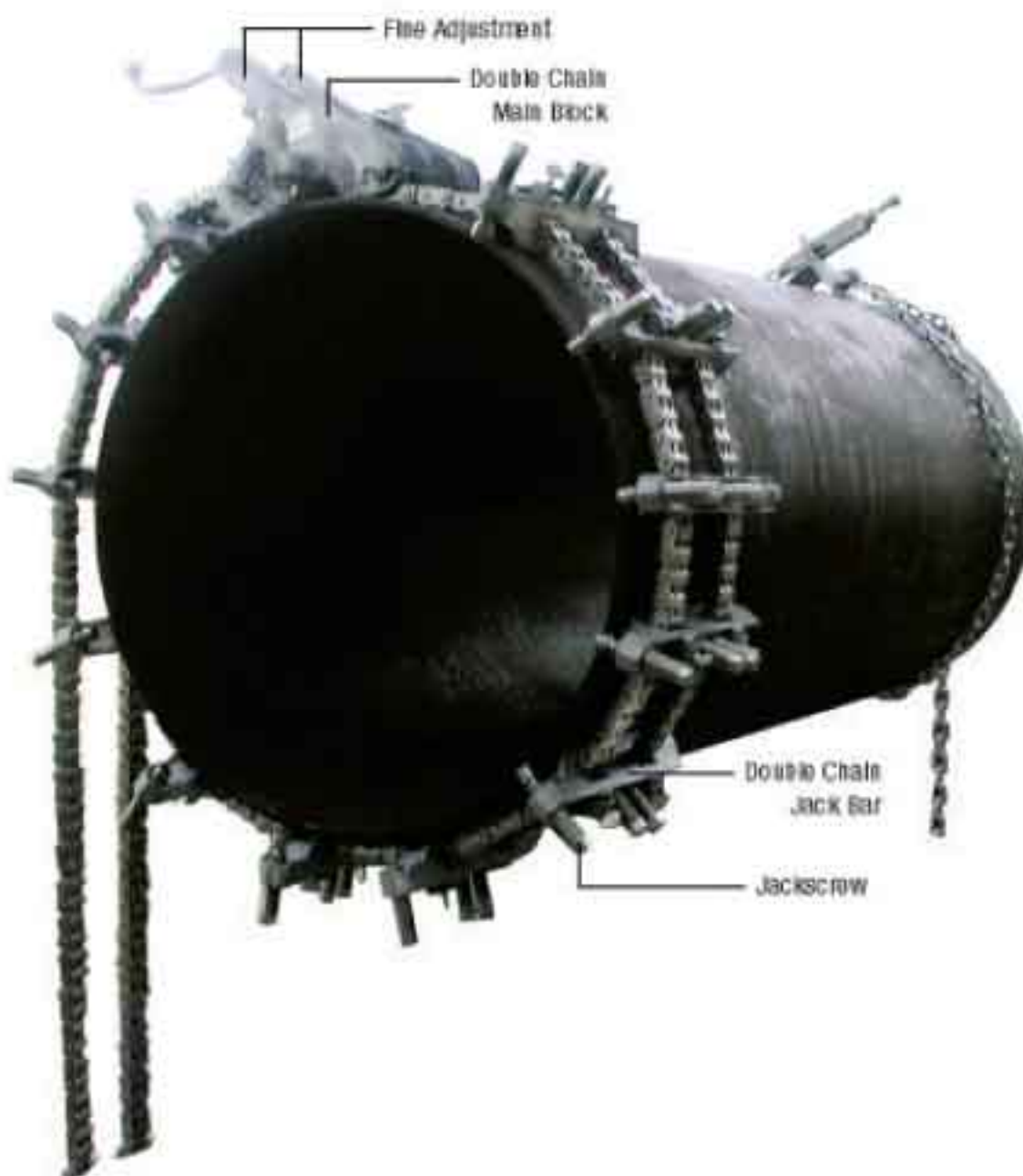


## Double Chain Clamp

### Double Chain Clamp - D251 Series

#### Double Chain Clamps include:

- Length of Chain required for the pipe range.
- Universal Jackbars listed for the pipe range.
- Main Block.
- Two (2) Fine Adjustments.
- D251-1036, D251-1036SS, D251-1048, D251-1048SS, D251-1054 and D251-1054SS Supplied with Level and Support Device. (Larger Clamps supplied with Come-A-Long.)
- Jackscrew Wrench.
- Operating Instructions.
- Carbon or Stainless Steel Spacing Screws (Optional).
- Jackscrews available with Swivel Pads.



The Double Chain Clamp is a heavy-duty vessel clamp designed for the alignment and reforming of large pipes and vessels. The Clamp will align and reform pipes or vessels 20' / 6M with "Schedule 80" wall thickness. Where no reforming is required, pipe over Schedule 80 can be aligned with the Double Chain Clamp.

The Extra Heavy-Duty Jackbar and Main Block provide the brute strength to accomplish almost any reforming job. Models 10" to 36" thru 10" to 54" come with Level and Support. All other Models come with cable hoist. The Double Chain Clamp is available for steel and stainless steel models. All Clamps are shipped in a wooden storage crate.

- **PRECISION ALIGNMENT** of large heavy wall pipe or vessels.
- **EXTREMELY TOUGH** Jackbars form pipe to the desired shape.
- **ADAPTABLE** – Chain and Jackbar can be added or removed for different diameters.
- Jackscrew Pads independently pivot to handle uneven surfaces.



Large pipe or tube shells can be aligned, reformed and welded without removal of the Double Chain Clamp, thereby increasing quality of the welding process.



## Double Chain Clamp

### Double Chain Clamp – Specifications

Part Number	Number of Main Blocks	Number of Jackbars	Reforms Pipe To Schedule*	Aligns Pipe To Schedule	Pipe Size Range (in./mm)	Estimated Shipping Weight (lbs./kg)
D251-1036	1	8	80	120	10-36 / 254-914	320 / 99
D251-1036SS	1	8	80	120	10-40 / 254-914	320 / 99
D251-1048	1	12	80	120	10-48 / 254-1219	278 / 125
D251-1048SS	1	12	80	120	10-48 / 254-1219	278 / 125
D251-1054	1	14	80	120	10-54 / 254-1372	300 / 135
D251-1054SS	1	14	80	120	10-54 / 254-1372	300 / 135
D251-1060	1	16	80	120	10-60 / 254-1524	328 / 148
D251-1060SS	1	16	80	120	10-60 / 254-1524	328 / 148
D251-1072	1	20	80	120	10-72 / 254-1829	387 / 174
D251-1072SS	1	20	80	120	10-72 / 254-1829	387 / 174
D251-1084	1	24	80	120	10-84 / 254-2134	442 / 199
D251-1084SS	1	24	80	120	10-84 / 254-2134	442 / 199
D251-1096	2	28	80	120	10-96 / 254-2438	498 / 224
D251-1096SS	2	28	80	120	10-96 / 254-2438	498 / 224
D251-10108	2	32	80	120	10-108 / 254-2743	554 / 248
D251-10108SS	2	32	80	120	10-108 / 254-2743	554 / 248
D251-10120	2	36	80	120	10-120 / 254-3048	610 / 275
D251-10120SS	2	36	80	120	10-120 / 254-3048	610 / 275
D251-1011F	2	39	80	120	10-132 / 254-3353	660 / 297
D251-1011FSS	2	39	80	120	10-132 / 254-3353	660 / 297
D251-1012F	2	42	80	120	10-144 / 254-3715	710 / 320
D251-1012FSS	2	42	80	120	10-144 / 254-3715	710 / 320
D251-1014F	3	48	80	120	10-168 / 254-4267	810 / 365
D251-1014FSS	3	48	80	120	10-168 / 254-4267	810 / 365
D251-1016F	3	54	80	120	10-192 / 254-4877	910 / 410
D251-1016FSS	3	54	80	120	10-192 / 254-4877	910 / 410
D251-1018F	3	60	80	120	10-216 / 254-5486	1010 / 455
D251-1018FSS	3	60	80	120	10-216 / 254-5486	1010 / 455
D251-1020F	3	66	80	120	10-240 / 254-6096	1110 / 500
D251-1020FSS	3	66	80	120	10-240 / 254-6096	1110 / 500

\* Calculations are based on pipe with a yield strength of 45,000lbs / 20,412kg.  
SS - Indicates Clamp is for Stainless Steel application.

(See inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)



Double Chain Jackbar

**Heavy-Duty Double Chain Jackbars apply pressure where needed.**

**Warning:**

The clamp should never be used as the sole Support of the Pipe.

The clamp should never be used to lift the pipe.

Use only chain purchased from Mathey Dearman, Inc. as some manufacturers' roller chain *cannot be used* with the clamp.

Use of chain not supplied with clamp by Mathey Dearman, Inc. will VOID the Warranty of the clamp.



## Hydraulic Double Chain Clamp

Part No. D251



### DO YOU WANT A CLAMP WITH ADDED STRENGTH?

The Hydraulic Double Chain Clamp has a Power Hydraulic Tensioning Mechanism incorporated into its design. The Hydraulic Cylinder of the Hydraulic Tensioning Mechanism, which has a 5" / 127mm stroke, applies up to 10,000 lbs. / 4535kg of tension to the Standard Double Chain Clamp. Rapid and effortless tension can be applied to Double Chain Clamp to close it on the pipe. Hydraulic pressure is supplied to the Cylinder by a hand pump with reservoir. The Clamp is specifically designed to "align pipe up to Schedule 120" and "reform pipe to Schedule 80".

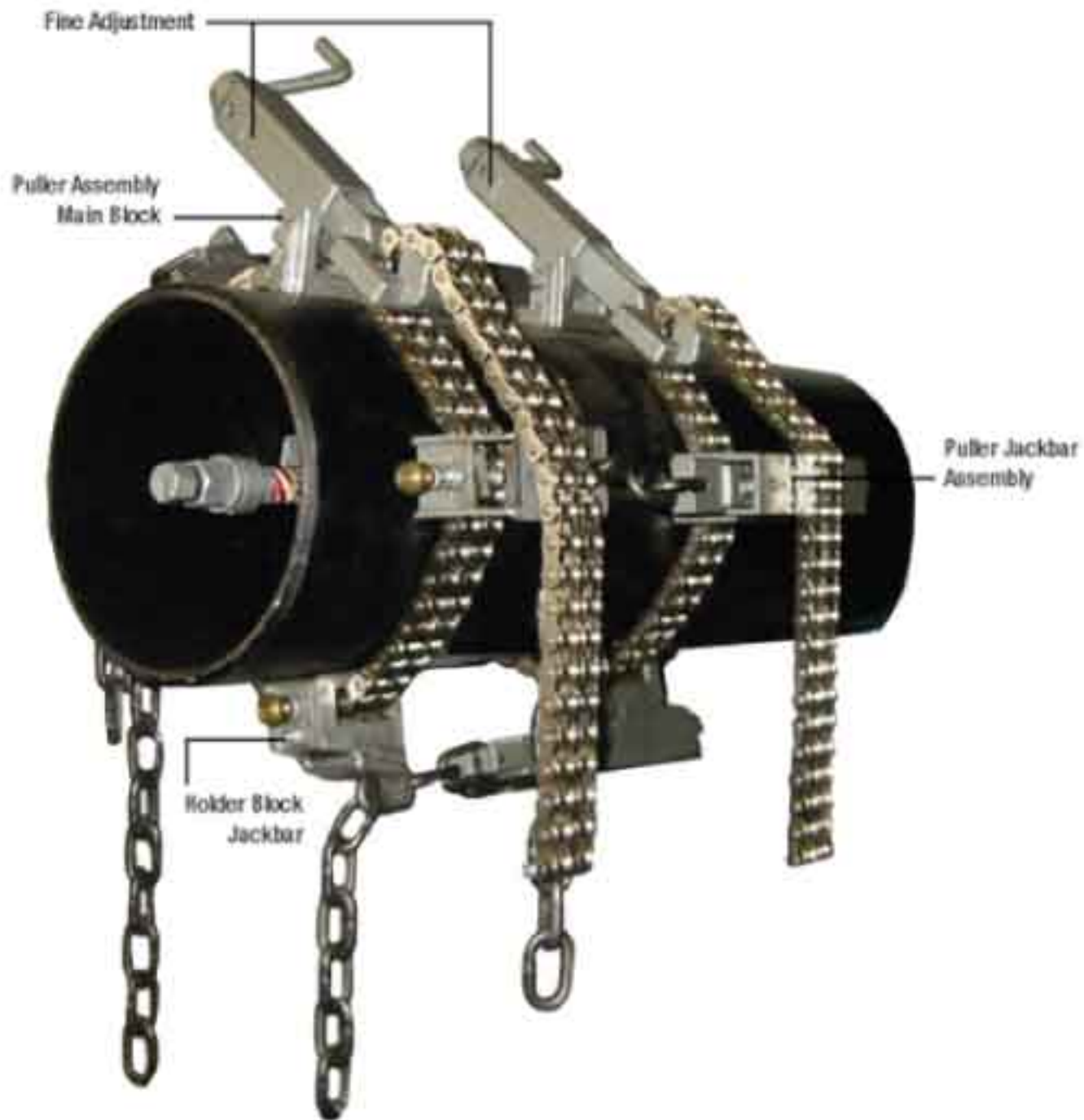
### D251 Series Hydraulic Closure Mechanism

Part Number	Description	Estimated Shipping Weight Lbs. / Kg
00580	D251 Hydraulic Closure Mechanism	43 / 20
0104-KIT	Hydraulic Kit includes Manual Hydraulic Pump, Reservoir and Hoses needed for operation.	12 / 5

The Hydraulic Closure Mechanism can be added to an existing or purchased Double Chain Clamp.



## Pipe Puller



The Pipe Puller holds pipe ends together and maintains a minimum welding gap between pipe ends and a consumable welding insert. By evenly spacing several puller assemblies around the pipe circumference, pressure can be applied where needed to remove unwanted gaps between pipe ends and the welding insert. Root Pass or Complete Weld can be made while the Pipe Puller is in place.

### Pipe Puller – Specifications

Part Number	Pipe Puller Range	Estimated Shipping Weight (lbs./kg)
D100PP	2-8 / 51-203 (carbon steel)	20 / 9
D100PP-SS	2-8 / 51-203 (Stainless Steel)	20 / 9



The Pipe Puller grasps and accurately holds pipe ends together insuring an even gap around the pipe circumference.



## Chain Clamp Parts

### Jackbars

All Single and Double Jackbars and Universal Holder Blocks are Investment Cast Stainless Steel.

Part Number	Original Chain Clamp	Original Chain Clamp Range (in./mm)	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range (in./mm)	Estimated Shipping Weight (lb./kg)
<b>Mini-Fit Single Screw Jackbar</b>					
DKL-523	D230, D230-A	1-8 / 25-203 (carbon steel)	D231-LT	1-12 / 25-305 (carbon steel)	1 / .5
DKL-523S	D230SS, D230-ASS	1-8 / 25-203 (Carbon or Stainless Steel)	D231-LTSS	1-12 / 25-305 (carbon or Stainless Steel)	1 / .5
<b>Single Screw Jackbar</b>					
DA-500S	D231, D231SS	1-8 / 25-203 (Carbon or Stainless Steel)	D232-LT, D232-LTSS	4-20 / 102-508 (carbon or Stainless Steel)	2 / 1
DB-500S	D232, D232SS	4-16 / 102-406 (Carbon or Stainless Steel)	D232-LT, D232-LTSS, D233-LT, D233-LTSS	6-36 / 152-914 (carbon or Stainless Steel)	3 / 1.4
DC-500S	D233, D233SS, D234, D234SS	10-54 / 254-914 10-54 / 254-1372 (Carbon or Stainless Steel)			4 / 1.8
<b>Double Screw Jackbar</b>					
DA-600S	D240, D240SS	1-8 / 25-203 (Carbon or Stainless Steel)	D240-LT, D240-LTSS	4-20 / 102-508 (carbon or Stainless Steel)	3 / 1.4
DB-600S	D240, D240SS	4-16 / 102-406 (Carbon or Stainless Steel)	D235-LT, D235-LTSS	6-36 / 152-914 (carbon or Stainless Steel)	4 / 1.8
DC-600S	D235, D235SS, D236, D236SS	10-54 / 254-914 10-54 / 254-1372 (Carbon or Stainless Steel)			5 / 2.3
<b>Universal Jackbar</b>					
DA-800	D2250	1-8 / 25-203 (Carbon Steel)			2 / .5
DB-800	D2249	4-16 / 102-406 (Carbon Steel)			3 / 1.4
DC-800	D2235	10-54 / 254-914 (Carbon Steel)			4 / 1.8
<b>Double Chain Jackbar</b>					
DD-500		D251 Series Carbon Steel			7 / 3.2
DD-500S		D251 Series Stainless Steel			7 / 3.2
<b>Add-On Jackbar</b>					
DA-900		1 - 8 (25 - 204) Carbon Steel or Stainless Steel			3 / 1
DB-900		4-16 (102 - 406) Carbon Steel or Stainless Steel			3 / 1
DC-900		10 - 54 (254 - 1372) Carbon Steel or Stainless Steel			5 / 2
<b>Jack Screws</b>					
DA-501	DA-100, DA-100LT, DA-500S, DB-500S	1 - 8 (25 - 204)	5/8" - 11NC X 3 1/4 lg.		.2 / .1
DA-701	DB-100, DB-100LT, DA-600S, DB-600S, DA-800, DB-800, DA-900, DB-900	4 - 16 (102 - 406)	5/8" - 11NC x 4"lg.		.25 / .11
DC-501	DC-100, DC-500S, DC-600S, DC-800, DC-900, DB-100, DD-100S, DD-500	10 - 54 (254 - 1372)	7/8" - 9nc x 4 1/2" lg.		.6 / .27



Mini-Fit Single Screw Jackbar



Single Screw Jackbar



Double Screw Jackbar



Universal Jackbar



Double Chain Jackbar



Add-On Jackbar



Jack Screw



## Chain Clamp Accessories

### Chain Clamp Parts

#### Main Block - Fine Adjustment - Level and Support

Part Number	Single, Double and Universal Chain Clamp	Pipe Size Range in. / mm.	Estimated Shipping Weights lbs. / kgs.
<b>Main Block</b>			
DA-100	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 / 25 - 203	3 / 1.4
DA-100LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 / 102-508	3 / 1.4
DB-100	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 / 102-406	7 / 3
DB-100LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 / 152 - 914	7 / 3
DC-100	D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS, D2235, D2235SS	10 - 36 / 254 - 914	13 / 6
DD-100	All Series 251 (Carbon Steel)	10' - 20' / 254 - 6096	25 / 11
DD-100S	All Series 251 (Stainless Steel)	10' - 20' / 254 - 6096	25 / 11
<b>Fine Adjustment</b>			
DA-200	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 / 25 - 203	1 / .45
DA-200LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 / 102-508	1 / .45
DB-200	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 / 102 - 406	3 / 1.4
DB-200LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 / 152 - 914	3 / 1.4
DC-200	D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS, D2235, D2235SS, D251 Series	10 - 36 / 254 - 914	4 / 1.8
<b>Level and Support Device</b>			
DA-400S	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 / 25 - 203	2 / 1
DA-400SLT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 / 102-508	2 / 1
DB-400S	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 / 102 - 406	5 / 2.3
DB-400SLT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 / 152 - 914	5 / 2.3
DC-400	D233, D234, D235, D236, D2235, D251 Series (Carbon Steel)	10 - 36 / 254 - 914	14 / 6.4
DC-400S	D233SS, D234SS, D235SS, D236SS, D2235SS, D251 Series (Stainless Steel)	10 - 36 / 254 - 914	14 / 6.4



The frame of the Main Block that contacts the pipe is made of stainless steel. The Chain Dog, located in the Main Block, contacts the roller of the chain preventing the chain from becoming disengaged.



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



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



## Chain Clamp Accessories

### Spacing Screws

The Spacing Screw is used to obtain a precise weld gap between pipes or other fittings. Spacing Screw Assemblies are available for steel and stainless steel applications. When ordering Spacing Screws—one spacing screw should be ordered for each Jackbar and one should be ordered for the Main Block.

#### Spacing Screws for Single and Double Screw Jackbar

Part Number	Type	Single and Double Main Block Universal Jackbar Chain Clamp	Estimated Shipping Weight Lbs. / Kg
DA-570	Carbon Steel	D231, D249-LT, D232-LT, D250	.25 / .11
DA-570S	Stainless Steel	D231SS, D232-LTSS, D249-LTSS, D250SS	.25 / .11
DB-570	Carbon Steel	D232, D233-LT, D249, D235-LT	.35 / .16
DB-570S	Stainless Steel	D232SS, D233-LTSS, D235-LT, D249SS	.35 / .16
DC-570	Carbon Steel	D233, D234, D235, D236	.47 / .18
DC-570S	Stainless Steel	D233SS, D234SS, D235SS, D236SS	.47 / .18

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

Part Number	Type	Single and Double Main Block Universal Jackbar Chain Clamp	Estimated Shipping Weight Lbs. / Kg
DA-870	Carbon Steel	D231, D232-LT, D249-LT, D250, D2250	.2 / .09
DA-870S	Stainless Steel	D231SS, D232-LTSS, D249-LTSS, D250SS, D2250SS	.2 / .09
DB-870	Carbon Steel	D232, D233-LT, D249, D235-LT, D2249	.3 / .14
DB-870S	Stainless Steel	D232SS, D233-LTSS, D249SS, D235-LTSS, D2249SS	.3 / .14
DC-870	Carbon Steel	D233, D234, D235, D236, D2235	.3 / .14
DC-870S	Stainless Steel	D233SS, D234SS, D235SS, D236SS, D2235SS	.3 / .14



The Spacing Screw, when mounted to the Jackbars of the Clamp, permits the welders to obtain and hold a precise weld gap while adjusting the pipe or fitting "Hi-Lo"™.



Main Block (Universal Jackbar) Spacing Screw Assembly

Jackbar Spacing Screw Assembly

### Chain Clamp Storage Boxes

Part Number	For Models	Clamp Size	Dimensions In. / mm	Estimated Shipping Weight Lbs. / Kg
DB01	D231, D231S	1"-8" (25-203mm) Single Jackscrew	16 x 7 x 7.5 / 406 x 178 x 191	4.2 / 1.9
	D232-LT, D232-LTSS	4"-20" (102-508mm) Light Single Jackscrew		
DB02	D232, D232SS, D249, D249SS	4"-18" (102-466mm) Single and Double Jackscrew	29 x 10 x 13.75 / 773 x 254 x 348	26 / 12
	D2235, D2236SS, D2249, D2249SS	4"-18" (102-466mm) and 10"-36" (254-914mm) Universal Jackscrew		
	D233, D233SS, D235, D235SS	10"-36" (254-914mm) Single and Double Jackscrew		
	D234, D234SS, D236, D226SS	10"-54" (254-1372mm) Single and Double Jackscrew		
DB03	D250, D250S	1"-8" (25-203mm) Double Jackscrew	26 x 8.5 x 8.75 / 508 x 216 x 222	8 / 4
	D2250, D2250SS	1"-8" (25-203mm) Universal Jackscrew		
	D249-LT, D249-LTSS	4"-18" (102-466mm) Light Double Jackscrew		

Durable Chain Clamp Storage Boxes are available in Three (3) sizes. The Storage Boxes come standard with a lifting handle(s), lockable hasp and a baked enamel finish.





## Chain Clamp Accessories

### Chain and Connecting Links

All Carbon Roller Chain is nickel-plated. Use only Chain and Connecting Links purchased from Mathey Dearman. Use of Chain not supplied will **VOID** the Warranty of the Clamp.

#### Chain and Connecting Links

Part Number	Original Chain Clamp	Classic (Standard) Chain Clamp Range (in./mm)	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range (in./mm)	Estimated Shipping Weight (lb./kg)
<b>Chain</b>					
DA-300	D230, D230-A, D231, D250, D2250,	1-8 / 25-203 (Carbon Steel)	D231-LT, D249-LT	4-20 / 102-508 (Carbon Steel)	1 / 0.5
DA-300S	D230SS, D230SSS, D230SSS, D230-ASS, D231SS	1-8 / 25-203 (Stainless Steel)	D231-LTSS, D249-LTSS	4-20 / 102-508 (Stainless Steel)	1 / 0.5
DB-300	D232, D248, D2248	4-16 / 102-406 (Carbon Steel)	D232-LT, D235-LT	6-36 / 152-914 (Carbon Steel)	2 / 1
DB-300S	D232SS, D232SSS, D248SS	4-16 / 102-406 (Stainless Steel)	D232-LTSS, D235-LTSS	6-36 / 152-914 (Stainless Steel)	2 / 1
DC-300	D233, D234, D235, D236, D2235, D251-Series (Carbon Steel)	10-36 / 254-914 10-54 / 254-1372 (Carbon Steel)			4 / 1.8
DC-300S	D233SS, D234SS, D235SS, D236SS, D2235SS, D251-Series (Stainless Steel)	10-36 / 254-914 10-54 / 254-1372 (Stainless Steel)			4 / 1.8
<b>Connecting Link</b>					
DA-301	D230, D230-A, D231, D250, D2250, D2250SS, D231SS	1-8 / 25-203 (Carbon Steel)	D231-LT, D232-LT, D232-LTSS, D248-LT	4-20 / 102-508 (Carbon Steel)	.1 / .05
DA-301S	D230SS, D250SS	1-8 / 25-203 (Stainless Steel)	D231-LTSS, D248-LTSS	4-20 / 102-508 (Stainless Steel)	.1 / .05
DB-301	D232, D232SS, D248, D2248	4-16 / 102-406 (Carbon Steel)	D232-LT, D233-LT, D235-LT	6-36 / 152-914 (Carbon Steel)	.1 / .05
DB-301S	D232SS, D248SS, D2248SS	4-16 / 102-406 (Stainless Steel)	D235-LTSS	6-36 / 152-914 (Stainless Steel)	.1 / .05
DC-301	D233, D234, D235, D236, D2235, D251-Series (Carbon Steel)	10-36 / 254-914 10-54 / 254-1372 (Carbon Steel)			.3 / .1
DC-301S	D2235SS, D233SS, D234SS, D235SS, D236SS	10-36 / 254-914 10-54 / 254-1372 (Stainless Steel)			.3 / .1



Three (3) Different Sizes of Roller Chain are used in the Mathey Dearman Single and Double Jackscrew, Universal and Dearman Light Chain Clamp to insure the maximum amount of safety is provided for the welder. The Roller Chain is available in Stainless Steel and Carbon Steel.



Connecting Links

**Warning:** When the range of the Chain Clamp is extended beyond the working range; it severely affects the reforming capability and the capacity of the Chain Clamp. Mathey Dearman, Inc. will **NOT** WARRANTY OR ACCEPT LIABILITY for any Clamp that is extended beyond the normal operating range of the Clamp.

**Warning:** Use only chain purchased from Mathey Dearman, as some manufacturers' roller chain **cannot be used** with the Mathey Dearman Chain Clamp.

Use of chain not supplied with clamp by Mathey Dearman, Inc. will VOID the Warranty of the clamp.

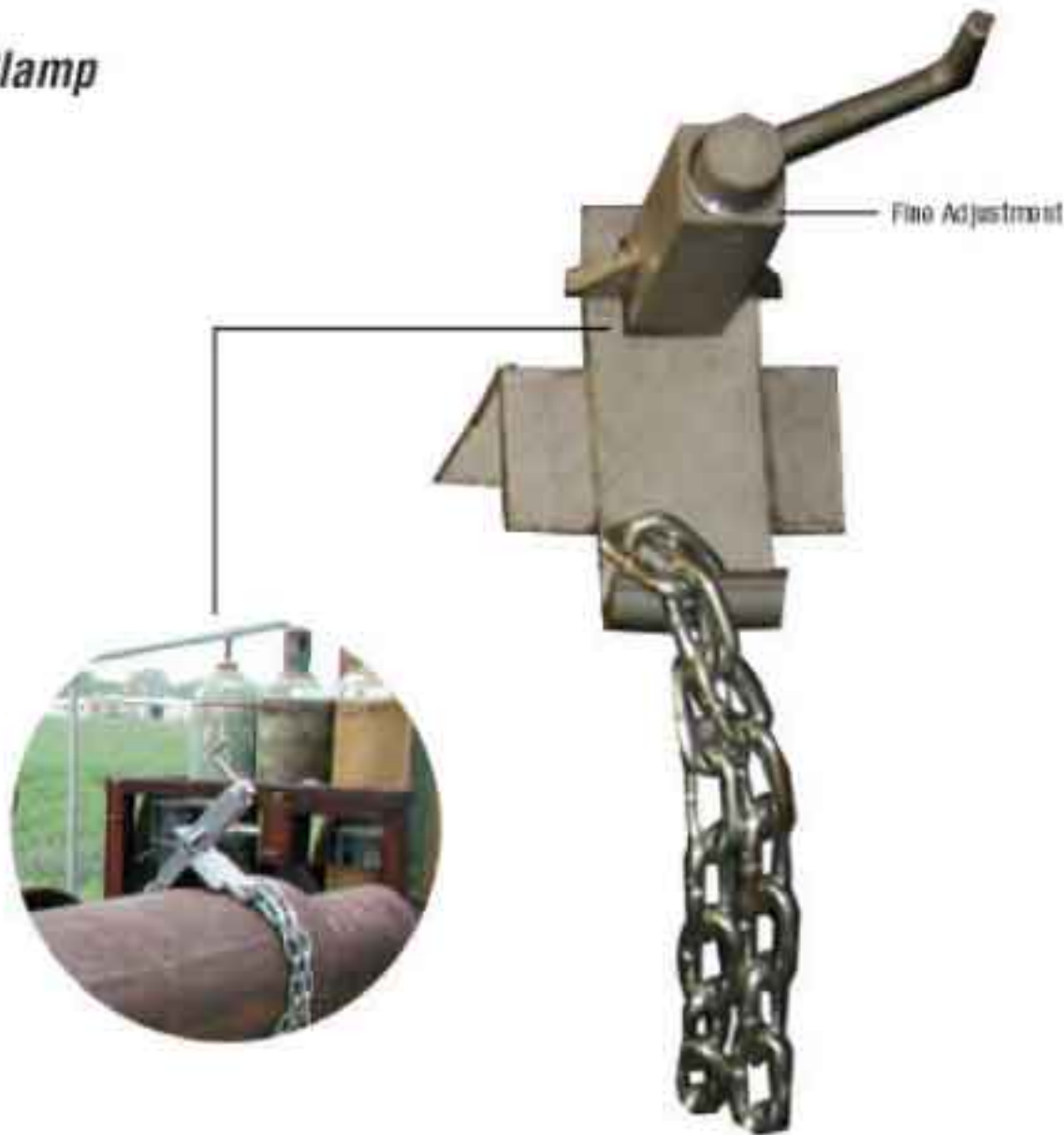
### How to Determine Length of Chain to Extend the Range of a Chain Clamp.

- Step 1:** Customer has D249 / range: 4"-16" / 102mm-405mm  
Length of Chain is: 60" / 1524mm
- Step 2:** Multiply the diameter of the pipe that you wish to align by 3.1416 = pipe circumference (i.e.: 20" / 506mm pipe diameter x 3.1416) = 62.8" / 1595mm
- Step 3:** Subtract the length of chain noted on the D249 Clamp used in Step 1. 60" / 1524mm  
2.8" / 71mm
- Step 4:** Roundup the amount of chain needed to the next whole foot. 1' / 305mm of chain required

**NOTE:** A Connecting Link is needed to join chain ends together. A Jackbar should be added for each foot of chain added to the Chain Clamp.



## Hold Down Clamp



**H**old Down Clamps safely secure the pipe to the Mathey Dearman Jackstand or table for the fit-up of tees, elbows, flanges and other fittings.

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

The Crank Shaft Mechanism takes up the slack in the chain to hold the pipe safely and securely with the chain being placed at the base of the V-Head of the Jackstand, and not through the legs.

**Warning:** For use of the Hold Down Clamp - *do not* run chain through legs of jackstands. Chain should be wrapped around the pipe.

### Hold Down Clamp – Specifications

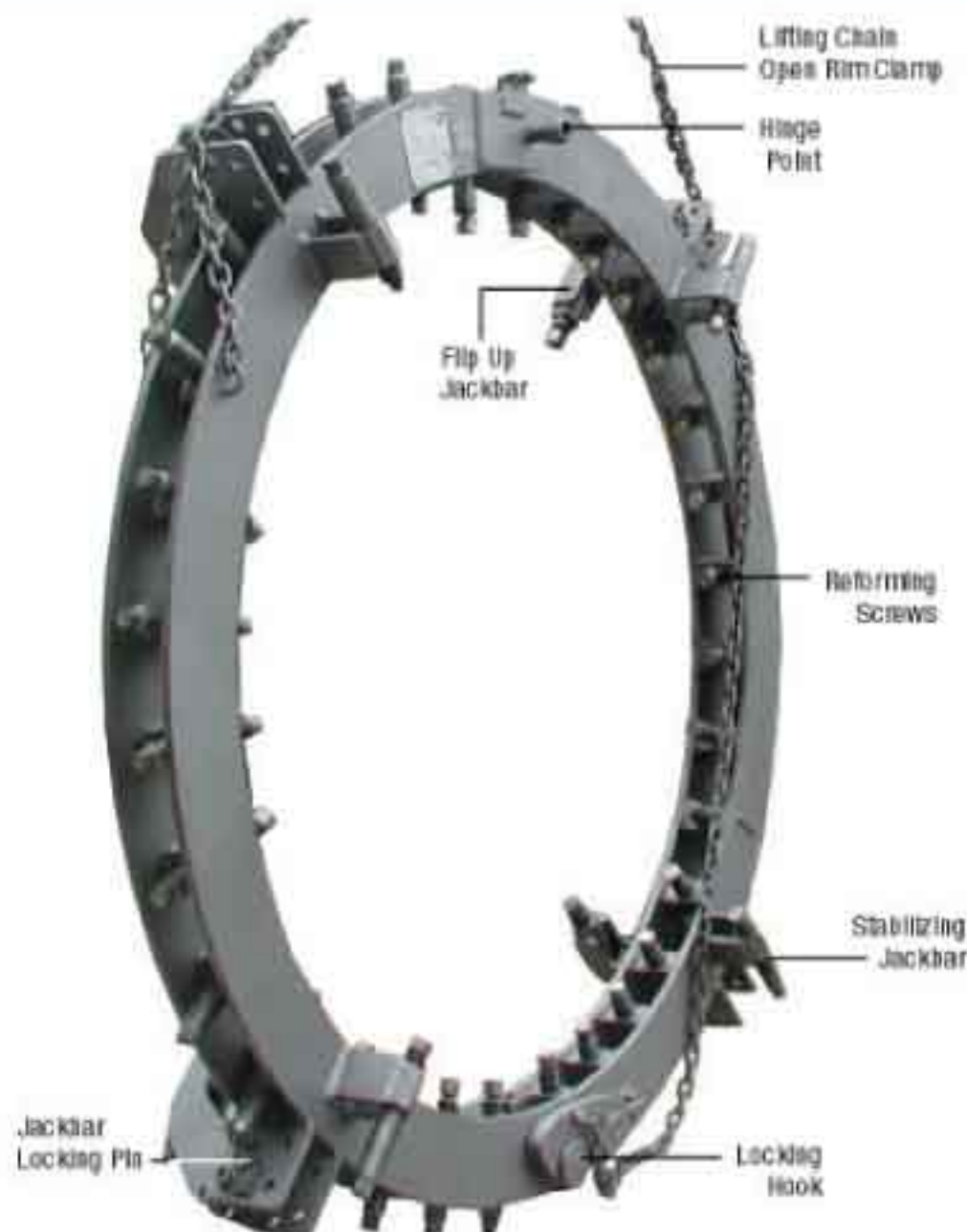
Part Number	Pipe Diameter (In./mm)	Estimated Shipping Weight (lbs./kg)
D244	2-16 / 51-406	5 / 2
D245	10-48 / 254-1219	14 / 6.4



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



## Rim Clamps



**R**im Clamps are **"THE CLAMPS WITH MUSCLE"** for tough reforming jobs. Jackscrews apply pressure on specific high points to precisely reform and align the pipe or shells. Ideal for applications that require 100% weld and grind without releasing clamping pressure to prohibit cracking of partially completed welds. The Clamp can also be used to round the pipe or shell on which it is placed. All surfaces of the Rim Clamp, that contact the pipe, are made of stainless steel for nuclear and other similar applications. The Clamp will reform pipes or shells to Schedule 80 and handles out of round conditions up to 2" / 51mm.

Contact Mathey Dearman for a quotation on sizes larger than 72" / 1829mm.

- **EXTREMELY ACCURATE** fit-up on large diameter pipe or shells.
- **HI-LO™** – handles out-of-round conditions up to 2" / 51mm.
- **EASY ALIGNING AND REFORMING** - Pressure can be applied to the high point of the pipe or vessel to reform it to the required shape.
- **VERSATILE** – The clamp can be used for steel or stainless steel applications.



The 14" to 16" / 356mm to 406mm and larger Rim Clamp will open and close over the pipe minimizing risk or injury to the operator.



## Rim Clamps

The Mathey Dearman Rim Clamp aligns and reforms straight pipes and pipe fittings for welding. The Rim Clamp is designed to reform one section of pipe or fitting to match another section of pipe or to match up to a fitting.

The Jackscrews, placed around the clamp, can be tightened or loosened to shape the pipe or to match the pipe or fitting to be welded. The pipes or pipe to fitting can be completely welded

without removal of the clamp. The clamp is equipped with Four (4) Stabilizing Jackbars on the rear of the clamp to stabilize the clamp on the pipe. The Four (4) Moveable Jackbars on the front of the clamp are used to position and hold the pipe or fitting in alignment for welding. These moveable Jackbars can be rotated away from the pipe or fitting to facilitate grinding.



Back off all Jackscrews except the Two (2) located on either side of the hinge point. These Two (2) Jackscrews will help center the clamp on the pipe.



Unlatch the Latch Hook and lift the clamp by the chain attached to the hook to open the clamp.



Lower the clamp on the pipe so that the moveable Jackbars extend about Two (2) inches / 50mm beyond the end of the pipe.



As the clamp is lowered on the pipe, the lifting chain tension subsides and the clamp closes around the pipe automatically locking the Latch Hook.



Adjust the Jackscrews, located in the Rim Clamp Ring, at the 12, 3, 6, and 9 o'clock position until the clamp is centered on the pipe.



Adjust Four (4) Stabilizing Jackbars until they contact the pipe to stabilize the clamp.



## Rim Clamps



Adjust the Two (2) Lower Flip Up Jackbars on the front of the clamp so the mating pipe is in near alignment.



Remove the Locking Pin Assemblies from the Two (2) Upper Moveable Jackbars and rotate them backward and install the Locking Pin.



Lower the second pipe or fitting into the clamp until it makes contact with the Two (2) Lower Moveable Jackbars.



Remove the Locking Pin Assemblies from the Two (2) Upper Moveable Jackbars and rotate them back into position and reinstall the Locking Pins. Tighten the moveable Jackbar Jackscrew against the pipe or fitting.



Use the Jackscrews of the clamp to shape the pipe so that it matches the "Hi-Lo"™ of the mating pipe or fitting. The Jackbars are shaped to permit full circle welding without removal of the clamp.



The Moveable Jackbar can be rotated rearward to permit grinding of the weld joint if required.



## Rim Clamp

### Rim Clamp – Specifications

Model	Pipe Size Range (in./mm)	Reforms Pipe To Schedule*	Aligns Pipe To Schedule	Shipping Dimensions (in./mm)	Estimated Shipping Weight (lbs./kg)
D711-0400	4-6 / 102-152	80	120	18 x 18 x 11 / 2 / 45.7 x 45.7 x 292	40 / 18
D711-0608	6-8 / 152-203	80	120	18 x 18 x 11 / 2 / 45.7 x 45.7 x 292	50 / 23
D711-0810	8-10 / 203-254	80	120	23 x 23 x 12 / 2 / 58.4 x 58.4 x 310	70 / 32
D711-1012	10-12 / 254-305	80	120	23 x 23 x 12 / 2 / 58.4 x 58.4 x 318	90 / 41
D711-1214	12-14 / 305-356	80	120	34 x 32 x 12 / 86.4 x 81.3 x 305	120 / 54
D711-1416	14-16 / 356-508	80	120	40 x 48 x 20 / 1016 x 1219 x 508	190 / 86
D711-1618	16-18 / 406-457	80	120	40 x 48 x 20 / 1016 x 1219 x 508	240 / 108
D711-1420	14-20 / 356-508	80	120	40 x 48 x 20 / 1016 x 1219 x 508	280 / 126
D711-1824	18-24 / 457-610	80	120	40 x 48 x 20 / 1016 x 1219 x 508	350 / 158
D711-2026	20-26 / 508-660	80	120	40 x 48 x 20 / 1016 x 1219 x 508	360 / 162
D711-2228	22-28 / 559-711	80	120	40 x 48 x 20 / 1016 x 1219 x 508	380 / 171
D711-2632	26-32 / 660-813	80	120	44 x 48 x 20 / 1118 x 1219 x 508	400 / 180
D711-3038	30-36 / 762-914	80	120	44 x 48 x 20 / 1118 x 1219 x 508	420 / 189
D711-3440	34-40 / 864-1016	80	120	54 x 54 x 20 / 1372 x 1372 x 508	450 / 203
D711-3844	38-44 / 965-1118	80	120	58 x 58 x 20 / 1473 x 1473 x 508	490 / 221
D711-4248	42-48 / 1067-1219	80	120	62 x 62 x 20 / 1524 x 1524 x 508	510 / 230
D711-4450	44-50 / 1118-1270	80	120	62 x 37 x 24 / 1575 x 940 x 610	610 / 275
D711-4652	46-52 / 1168-1321	80	120	66 x 38 x 24 / 1676 x 991 x 610	610 / 275
D711-5056	50-56 / 1270-1422	80	120	70 x 41 x 24 / 1778 x 1041 x 610	660 / 306
D711-5460	54-60 / 1372-1524	80	120	74 x 42 x 24 / 1880 x 1067 x 610	750 / 338
D7115864	58-64 / 1473-1626	80	120	78 x 45 x 24 / 1981 x 1143 x 610	820 / 369
D711-6268	62-68 / 1575-1727	80	120	84 x 44 x 24 / 2134 x 1219 x 610	880 / 396
D711-6672	66-72 / 1676-1829	80	120	88 x 49 x 24 / 2184 x 1245 x 610	950 / 428

\* Calculations are based on pipe with a yield strength of 45,000psi / 20,412 kg.

(See Inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)

**Warning:** The Clamp should never be used as the sole support of the pipe.



The Jackar can rotate out of position for alignment, welding and grinding without removal of the clamp.



The Rim Clamp reforms pipe or tube shell up to Schedule 80 with out-of-road condition up to 2" / 50mm.



## Mega Rim Clamp



Part No.  
D711-xxx

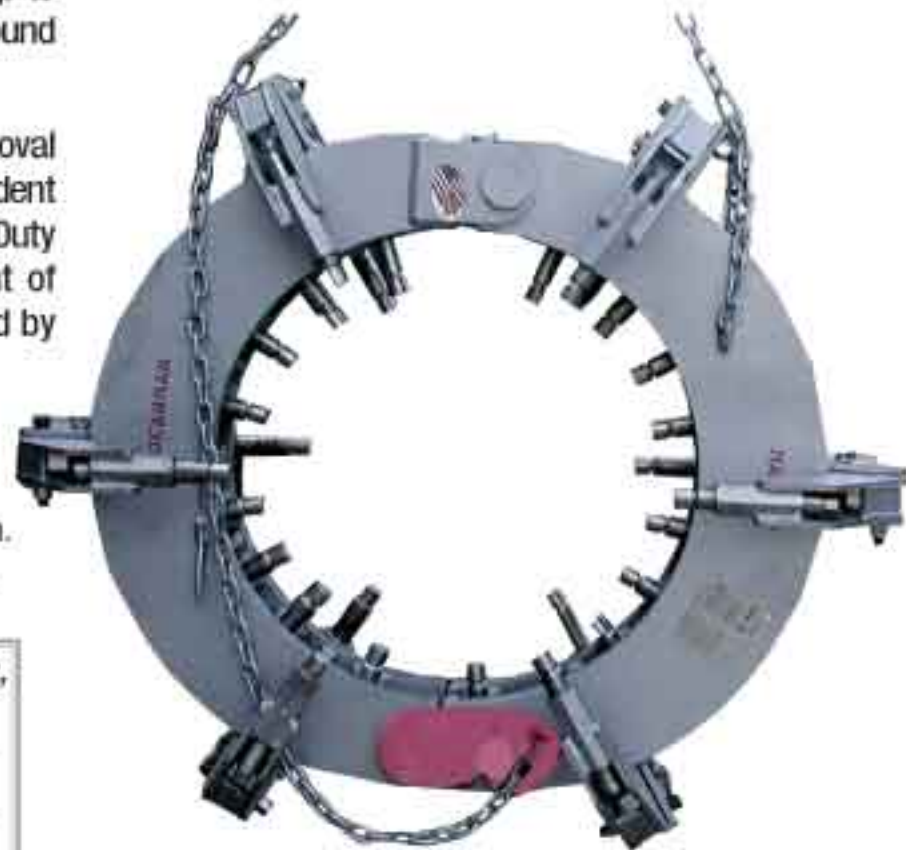
**N**EW - AND ESPECIALLY ENGINEERED 'MEGA RIM CLAMP' for aligning and reforming pipe with a high tensile strength (up to 65,000 lbs.), such as P91 Pipe, for wall thickness up to 7/8" / 22mm. The Mega Rim Clamp will handle out-of-round conditions up to 2" / 51mm.

The specially designed MEGA RIM CLAMP incorporates oval shaped, heavy-duty side-walls, Jackscrews with independent pivoting pads to handle uneven surfaces, extra Heavy-Duty Latching Mechanism and Extended Jackbars. The amount of added Stabilizer Bars and Flip-Up Jackbars are determined by the tensile strength of the pipe.

- **EXTRA HEAVY-DUTY REFORMING** – Reformers High Tensile strength pipes up to 65,000lbs.
- **HI-Lo™** – Handles up to a 2" / 51mm out-of-round condition.
- **VERSATILE** – Engineered based on customers application.

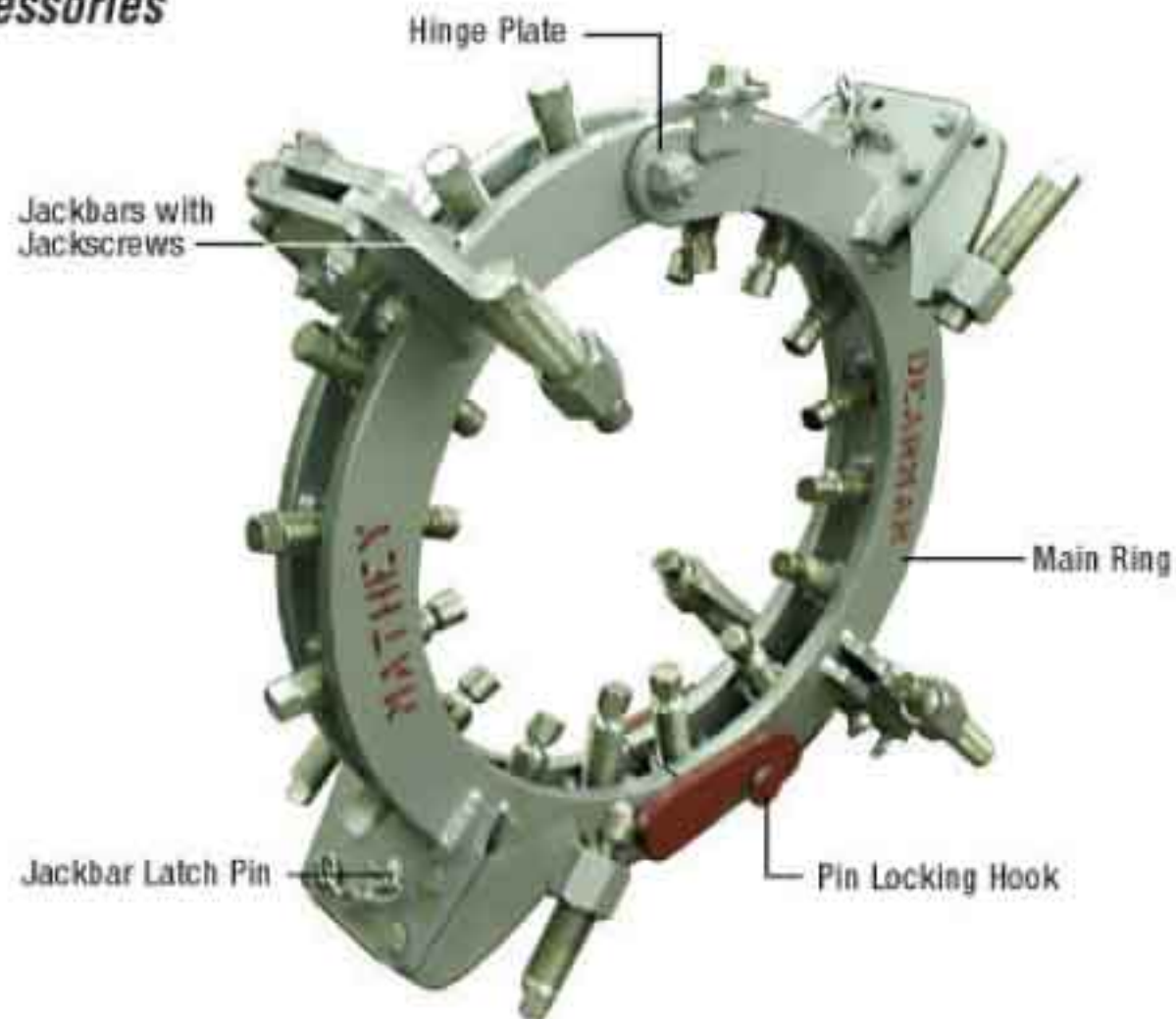
*In order to specify the Mega Rim Clamp for your process, please provide us with the following information:*

1. Pipe Diameter (Inches or Millimeters) \_\_\_\_\_
2. Pipe Wall Thickness (Inches or Millimeters) \_\_\_\_\_
3. Pipe Tensile Strength or Type Material \_\_\_\_\_
4. Horizontal or Vertical Application \_\_\_\_\_
5. Specify in Fahrenheit \_\_\_\_\_ or Celsius \_\_\_\_\_





## Rim Clamp Accessories



### Parts Description

Assembly/Parts Description	Rim Clamp Size (in./mm)	Estimated Shipping Weight (lbs./kg)
<b>Jackbars</b>		
DR-300	4-14 / 102 - 356	2 / 1
DR-700	14-72 / 356 - 1829	10 / 4.5
<b>Jackscrews</b>		
DC-501	4-14 / 102 - 356	.6 / 2.7
DR-500	14-72 / 356 - 1829	2 / 1
<b>Wrenches</b>		
D900-002 (3/4" / 19mm)	4-14 / 102 - 356	1 / .5
D900-003 (7/8" / 22.2mm)	14-72 / 356 - 1829	1 / .5
<b>Level and Support Device</b>		
DA-400S*	4-8 / 102 - 203	2 / 1
DB-400S*	4-20 / 102 - 508	5 / 2
DC-400	18-72 / 457 - 1829	14 / 6
DC-400S*	18-72 / 457 - 1829	14 / 6



## Cage Clamps



Rapid alignment can be achieved with the Hand Lever Cage Clamp.  
A Clamp is needed for each pipe size to be aligned.

Cage Clamps are available in several types and models for pipes 2" to 60" / 51mm to 1524mm. Clamps are available in Hand Lever, Ratchet, and Hydraulic Model with either a Tack Type or No Tack Cross Bar. The Clamp is used to rapidly align one diameter of pipe only. The Cage Clamp is not designed to reform the pipe. The Clamp can be used for one diameter of pipe only. If the OD of the pipe varies more than  $\pm 3/16$  of the Clamp, the pipes will not be align accurately.

- **QUICK** – The Cage Clamp is the way to go when aligning One (1) pipe size at a time.
- **EFFICIENCY** – The Cage Clamp works efficiently when only aligning pipe with no reforming required.

Straight Cross Bars of the Tack Type Clamp have flared ends so pipes can be moved easily into position and clamped. When the pipe has been tack welded, the clamp is removed from the pipe and the weld is completed.



No Tack Cross Bars are arched to permit a full circle to be completed without removal of the Clamp. The No Tack Clamp is used to make the welding more efficient and to insure a quality weld.





## Cage Clamps

### Hand Lever Cage Clamp

Rapid pipe alignment can be achieved with the Hand Lever Cage Clamp. A Clamp is needed for each size pipe to be aligned.



Cage Clamp, Hand Lever Tack Type

Hand Lever Tack Model	Hand Lever No Tack Model	Pipe Size Range (in./mm)	Tack Model Estimated Shipping Weight (lbs./kg)	No Tack Model Estimated Shipping Weight (lbs./kg)
01-0500-001	-	2 / 51	12 / 5	-
01-0500-002	-	3 / 76	17 / 8	-
01-0500-003	01-0500-N03	3.5 / 89	19 / 9	18 / 8
01-0500-004	01-0500-N04	4 / 102	19 / 9	20 / 9
01-0500-005	01-0500-N05	5 / 127	32 / 15	32 / 15
01-0500-006	01-0500-N06	6 / 152	32 / 15	32 / 15
01-0500-008	01-0500-N08	8 / 203	33 / 15	32 / 15
01-0500-010	01-0500-N10	10 / 254	51 / 23	51 / 23
01-0500-012	01-0500-N12	12 / 305	53 / 24	54 / 25
01-0500-014	01-0500-N14	14 / 356	70 / 32	66 / 30
01-0500-016	01-0500-N16	16 / 406	102 / 46	102 / 46
01-0500-018	01-0500-N18	18 / 457	110 / 50	107 / 49
01-0500-020	01-0500-N20	20 / 508	120 / 54	117 / 53
01-0500-022	01-0500-N22	22 / 559	125 / 57	124 / 56
01-0500-024	01-0500-N24	24 / 610	126 / 57	128 / 58
01-0500-026	01-0500-N26	26 / 660	130 / 59	138 / 62
01-0500-028	01-0500-N28	28 / 711	148 / 67	158 / 72
01-0500-030	01-0500-N30	30 / 762	160 / 73	185 / 88
01-0500-032	01-0500-N32	32 / 812	168 / 76	206 / 93
01-0500-034	01-0500-N34	34 / 864	174 / 79	213 / 97
01-0500-036	01-0500-N36	36 / 914	180 / 82	227 / 103
01-0500-038	01-0500-N38	38 / 965	255 / 116	238 / 108
01-0500-040	01-0500-N40	40 / 1016	298 / 135	262 / 119
01-0500-042	01-0500-N42	42 / 1067	308 / 140	280 / 127
01-0500-048	01-0500-N48	48 / 1219	348 / 158	338 / 153
01-0500-054	01-0500-N54	54 / 1372	395 / 179	350 / 159
01-0500-060	01-0500-N60	60 / 1524	445 / 202	377 / 171

Clamps with Stainless Steel contact point or for odd-size pipe available on request.

**Note:** Using wedges to reform pipe will void Clamp Warranty.



The Hand Lever Cage Clamp, most popular of the cage style clamps, is a field proven product for the alignment of smaller diameter pipes.



## Cage Clamps

### Ratchet Handle Cage Clamp



Ratchet Handle

*Handle must be ordered separately.*

### Ratchet Handle Lever Cage Clamp

The Ratchet Cage Clamp provides the extra force needed to align large pipe diameters. The Ratchet Closure Mechanism makes it easy to align large pipes. The clamp is available for 14" to 60" / 356 to 1524mm pipe. A standard 1" Ratchet Wrench fits all clamp sizes.



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

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

**Note:** Using wedges to reform pipe will void Clamp Warranty.

### Ratchet Handle Cage Clamp Specifications

Ratchet Tack Model	Ratchet No Tack Model	Pipe Size Range (in./mm)	Tack Model Estimated Shipping Weight (lbs./Kg)	No Tack Model Estimated Shipping Weight (lbs./Kg)
01-0500-R06	-	6 / 152	40 / 18	-
01-0500-R08	-	8 / 203	41 / 19	-
01-0500-R10	-	10 / 254	60 / 27	-
01-0500-R12	-	12 / 305	70 / 32	-
01-0500-R14	01-0500-RN14	14 / 356	80 / 36	70 / 32
01-0500-R16	01-0500-RN16	16 / 406	102 / 46	102 / 46
01-0500-R18	01-0500-RN18	18 / 457	110 / 50	108 / 48
01-0500-R20	01-0500-RN20	20 / 508	120 / 54	111 / 50
01-0500-R22	01-0500-RN22	22 / 559	125 / 57	115 / 52
01-0500-R24	01-0500-RN24	24 / 610	126 / 57	122 / 55
01-0500-R26	01-0500-RN26	26 / 660	130 / 59	138 / 63
01-0500-R28	01-0500-RN28	28 / 711	148 / 67	154 / 70
01-0500-R30	01-0500-RN30	30 / 762	160 / 73	160 / 73
01-0500-R32	01-0500-RN32	32 / 813	165 / 75	174 / 78
01-0500-R34	01-0500-RN34	34 / 864	165 / 75	179 / 81
01-0500-R36	01-0500-RN36	36 / 914	165 / 75	185 / 84
01-0500-R38	01-0500-RN38	38 / 965	165 / 75	255 / 116
01-0500-R40	01-0500-RN40	40 / 1016	165 / 75	258 / 125
01-0500-R42	01-0500-RN42	42 / 1067	165 / 75	308 / 140
01-0500-R48	01-0500-RN48	48 / 1219	165 / 75	310 / 150
01-0500-R54	01-0500-RN54	54 / 1372	165 / 75	340 / 154
01-0500-R60	01-0500-RN60	60 / 1524	165 / 75	370 / 168
01-0500-R01	-	Ratchet Handle	6 / 3	



## Cage Clamp

### Hydraulic Cage Clamp



The Hydraulic Cage Clamp produces the extra strength necessary for aligning large pipe diameters. Due to the design of the Hydraulic Closure Mechanism, pipes can be effortlessly aligned. The Hydraulic Closure Mechanism also permits the rapid release of the clamp from the pipe. The clamp is available for 16" to 60" / 406 to 1524mm pipe.



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

### Hydraulic Tack Type Cage Clamp

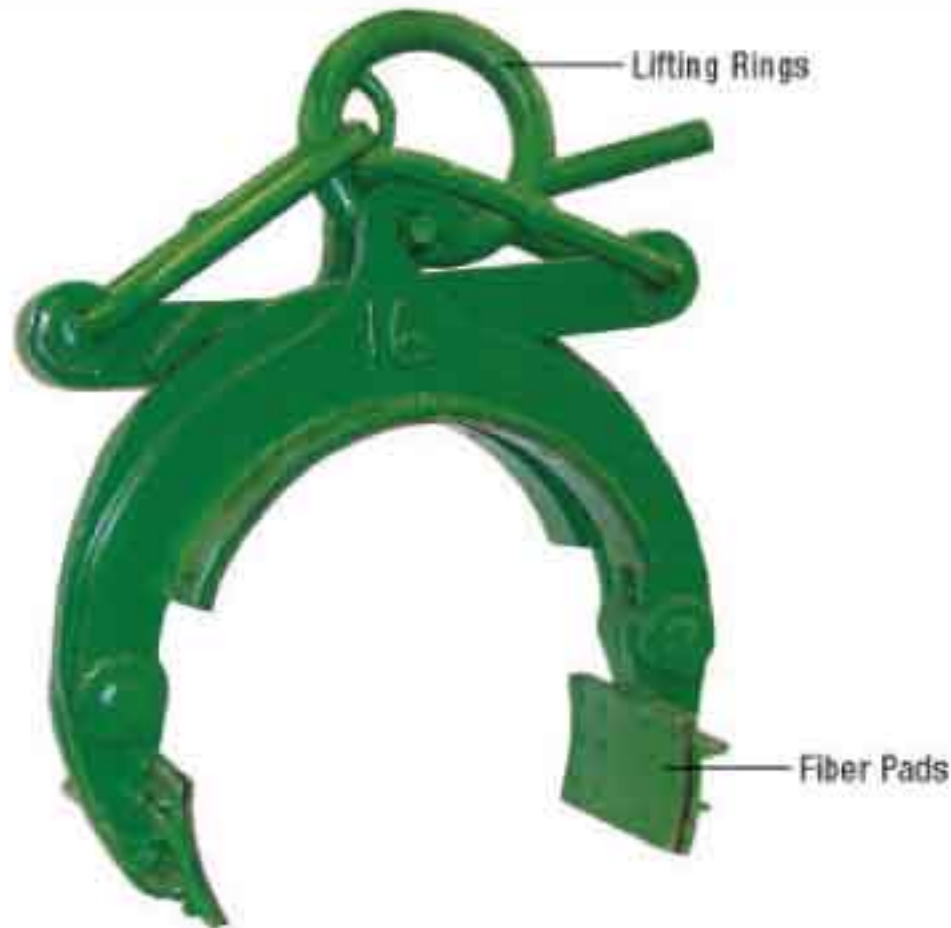
Hydraulic Tack Model	Hydraulic No Tack Model	Pipe Size Range (in./mm)	Tack Model Estimated Shipping Weight (lbs./kg)	No Tack Model Estimated Shipping Weight (lbs./kg)
01-0500-H16	01-0500-HH16	16 / 406	125 / 52	124 / 56
01-0500-H18	01-0500-HH18	18 / 457	130 / 58	127 / 58
01-0500-H20	01-0500-HH20	20 / 508	138 / 63	135 / 62
01-0500-H22	01-0500-HH22	22 / 559	140 / 64	142 / 64
01-0500-H24	01-0500-HH24	24 / 610	148 / 67	148 / 68
01-0500-H26	01-0500-HH26	26 / 660	150 / 68	157 / 71
01-0500-H28	01-0500-HH28	28 / 711	154 / 70	162 / 74
01-0500-H30	01-0500-HH30	30 / 762	165 / 75	166 / 75
01-0500-H32	01-0500-HH32	32 / 813	175 / 79	177 / 80
01-0500-H34	01-0500-HH34	34 / 864	190 / 86	186 / 84
01-0500-H36	01-0500-HH36	36 / 914	192 / 87	240 / 109
01-0500-H38	01-0500-HH38	38 / 965	205 / 120	244 / 111
01-0500-H40	01-0500-HH40	40 / 1016	295 / 134	280 / 127
01-0500-H42	01-0500-HH42	42 / 1067	320 / 145	300 / 136
01-0500-H48	01-0500-HH48	48 / 1219	344 / 156	325 / 147
01-0500-H54	01-0500-HH54	54 / 1372	380 / 172	345 / 156
01-0500-H60	01-0500-HH60	60 / 1524	445 / 202	375 / 170
01-0500-H01	01-0500-H01	Hydraulic Jack	20 / 9.07	-

Clamps with Stainless Steel contact point or for odd-size pipe available on request.

**Note:** Using wedges to reform pipe will void Clamp Warranty.



## Pipe Tongs



Use the Mathey Dearman Pipe Tongs to conveniently grasp the pipe to move it into the trench or about the pipe yard. The Lifting Ring closes the Clamp securely so that it can be safely moved. The pads of the Pipe Tong are made of rubber and cotton mater to avoid contamination of stainless and other specialty alloys. The Tongs are available for 2" to 36" / 51mm to 914mm steel, stainless steel and other specialty alloy pipes and fittings.



The Fiber Pad of the Automatic Pipe Tong allows the pipe to be firmly grasped, safely lifted and lowered into the trench.

### Tongs for Steel Pipe

Model	Pipe Size (in./mm)	Max. Capacity (lbs./kg)	Estimated Shipping Weight (lbs./kg)
01-0788-002	2 / 51	2000 / 900	43 / 9
01-0788-003	3 / 76	2000 / 900	46 / 21
01-0788-004	4 / 102	2500 / 1125	47 / 21
01-0788-006	6 / 152	3000 / 1350	56 / 25
01-0788-008	8 / 203	3500 / 1575	75 / 34
01-0788-0010	10 / 254	4000 / 1800	83 / 42
01-0788-012	12 / 305	4000 / 1800	100 / 45
01-0788-014	14 / 356	4000 / 1800	118 / 53
01-0788-016	16 / 406	4000 / 1800	147 / 66
01-0788-018	18 / 457	4500 / 2025	175 / 79
01-0788-020	20 / 508	5000 / 2250	219 / 99
01-0788-022	22 / 559	5000 / 2250	232 / 104
01-0788-024	24 / 610	5000 / 2250	255 / 115
01-0788-026	26 / 660	5500 / 2475	345 / 142
01-0788-030	30 / 762	6000 / 2700	400 / 200
01-0788-032	32 / 813	6500 / 2925	516 / 232
01-0788-034	34 / 864	7500 / 3375	587 / 264
01-0788-036	36 / 914	10000 / 4500	626 / 283

**Warning:** Do not use tongs for loads that exceed their Specified Maximum Capacity.



## Small Diameter Clamps

### Accu-Fit Clamps



Accu-Fit Aligning  
Pipe



Accu-Fit with  
Accu-Fit Stand  
D240-ST



Orbital Welder on  
Accu-Fit w/ Accu-Fit Stand  
D240-ST

**N**o Clamp makes a more clean and precise alignment of small diameter thin wall pipe and tubes than the Accu-Fit Clamp. Made of high-purity stainless steel, the Clamp aligns the pipes or tubes so that the welder can complete flawless welds. The Jaws of the Clamp work independently of each other so pipes or tubes can be aligned concentrically to each other regardless of diameter. The Clamp offers sufficient clearance for most Orbital-Welding Heads. The Clamp will align pipe to Schedule 20 and is ideal for GTAW welding; also useful for GMAW and other types of welding.

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



A miniature version of the Dearman Classic Clamp, the Mini-Fit Clamp, is small enough to fit in the welder's tool box, yet tough enough to align pipes to Schedule 30.



**Small Diameter Clamps**  
**Angler Clamp**



Accu-Fit Variable  
Angle Clamp  
D240-RA

**A**ngler has all of the sensational features of the Accu-Fit *plus* the ability to align small diameter thin wall pipe and tubes at angles to 90 Degrees included. Degree Indicator, located on the base of the clamp, is graduated in 5 Degree increments. The angler aligns pipes, tubes and fittings 3/8" to 2 3/4" / 9 to 113mm in diameter with a wall thickness not to exceed Schedule 20.

When the angle of clamping is set on Zero (0), the Accu-Fit Stand may be used to stabilize the clamp.

**NOTE:** To insure accurate aligning, the alignment of the pipes or tubes should always be checked with a Mathey Dearman Protractor.



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

**Accu-Fit and Accu-Fit Variable Specifications**

Part Number	Pipe Size Range (in./mm)	Distance between Jaws (in./mm)	Distance from Base to Center of Jaws (in./mm)	Estimated Shipping Weight (lbs./kg)
D240 (Stainless Steel)	3/8-2 3/4 / 9-81	2 7/8 / 73	3 9/16 / 90.5	5 / 2
D240-RA (Stainless Steel)	3/8-2 3/4 / 9-81	2 7/8 / 73	3 9/16 / 90.5	6 / 2
D240-2 (Stainless Steel)	2-4 1/2 / 51-114	4 7/8 / 121	5 1/4 / 133	14 / 6
Accu-Fit Stands				
D240-ST	Stand for D240			2 / 1
D240-2-ST	Stand for D240-2			2 / 1
D240-RA	Stand for D240-RA			2 / 1

**NOTE:** Clamp is designed to align the pipe or tubing ends and NOT to be used to support the weight of the pipe, tube or fitting.



## Small Diameter Clamps

### EZ-Fit



**EZ**-Fit Model of the clamps was specifically designed for the welder that needs a Clamp to adjust "Hi-Lo"<sup>™</sup> and does not need to reform the pipe. The Clamp is ideal for a wide range of small diameter pipe and tubing applications.

The Precision Cast Alloy Steel Clamps are designed not to flex when working on larger diameter pipe. Great for the critical alignment pipe to pipe, pipe to elbow or pipe to tee. Stainless Steel Shoes and Thumb Screws (included with clamp) eliminate contamination risk during fit-up of stainless steel and other special alloy pipes and fittings.

- **FAST EASY SET-UP** – Clamp can be slid over the end of the pipe or the crank handle and can be turned for fast easy alignment.
- **NO TRAINING** – Clamp requires no skill or training to operate.
- **ADAPTABLE** – Clamp can be used on stainless steel or specialty alloy pipe or tubing within its clamping range.
- **HI-LO<sup>™</sup>** – The Wing Screws are turned in or out to adjust pipe **HI-LO<sup>™</sup>**.



Stainless Steel Shoes  
(Included.)



## Small Diameter Clamps

### EZ-Fit



The EZ-Fit Clamp can accurately align pipe to pipe and pipe to elbow or pipe to tee as well as aligning to different diameters of pipe.

#### EZ-Fit Specifications

Part Number	Pipe Size Range (In./mm)	Estimated Shipping Weight (lbs./kg)
E-Z2SS	1 - 2.5 / 25-64	4 / 2
E-Z4SS	2.5 - 4.5 / 64-114	7 / 3
E-Z8SS	5 - 8 / 127 - 203	14 / 6
E-Z12SS	9 - 12 / 229 - 305	22 / 10



## Small Diameter Clamps

### Mini-Fit Clamp



Aligns pipes to Schedule 40  
Reforms pipes to Schedule 10



Mini-Fit Single Screw Jackbar  
The end of the Jackscrew is round to reduce the risk of marring the pipe.

#### Mini-Fit Chain Clamps include:

- Length of Chain required for the pipe range.
- Single Screw Jackbars listed for the pipe range.
- Jackbar Main Block.

The Mini Fit is an excellent tool for aligning random lots of small tubes, pipes and fitting up to Schedule 40. The Clamp is extremely lightweight and easy to set up and adjust. The Clamp is small enough to fit in the Welder's Toolbox and requires no tools for operation. The ingenious adaptation of our patented Chain Clamp design is perfect for light-duty applications. The Mini Fit will align 3/4" to 8" / 19 to 203mm carbon or stainless steel pipes with a wall thickness up to Schedule 40.

- **LIGHTWEIGHT** adaptation of standard Chain Clamp is perfect for light-duty applications.
- **SAVE** – Has the range of Seven (7) Cage Clamps.
- **ACCURATELY** aligns any pipe or tube within its range.
- Clamps available in steel, stainless steel and specialty alloys.
- Depending on pipe size, the DA-800 Add-On Jackbar can be added when pressure needs to be applied between the Clamp Jackbars.

#### Mini Fit – Specifications

Model	Pipe Size Range (In./mm)	Number of Jackbars	Reforms Pipe To Schedule*	Aligns Pipe To Schedule	Estimated Shipping Weight lbs./kg
D230-A	3/4-4 / 19-102	2	10	40	6 / 3
D230	3/4-8 / 19-203	2	10	40	7 / 3.2
D230-ASS	3/4-4 / 19-102	2	10	40	6 / 3
D230-SS	3/4-8 / 19-203	2	10	40	7 / 3.2

\* Calculations are based on pipe with a yield strength of 45,000lbs / 20,412kg.  
SS - Indicates Clamp is for Stainless Steel application.

(See Inside Back Cover for the wall thickness of commercial pipe in inches for a particular pipe schedule.)



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



**Manual Internal Alignment Clamp**  
**Hydraulic Internal Alignment Clamp**



**Manual Internal Alignment Clamps include:**

- Crank Handle with 49 Feet/15M of reach rods.
- Clamp with copper back-up ring available on request.



**Hydraulic Internal Alignment Clamps include:**

- Crank Handle with 49 Feet/15M of reach rods.
- Control End.
- Hook End.
- Clamp with copper back-up ring available on request.

**R**ugged yet simple, the Mathey Dearman Manual and Hydraulic Internal Alignment Clamps are an excellent tool to use when aligning pipes of the same diameter, when an air or hydraulic power source is not available. The Internal Clamp allows an automatic welder to be used as the outside of the pipe is obstructed.

**Manual and Hydraulic Internal Alignment Clamps** allow the operator to put pressure on the inner wall of the pipes through a heavy-duty jack box for alignment of the pipe weld joint.

A crank handle with 49ft. / 15M of reach rods come furnished with the clamp for pulling the clamp between pipe joints.

- **PRECISION MANUFACTURED** for a specific inside diameter.
- **LESS EFFORT** – Toggle design allows operator to put pressure to the pipe inner wall.
- **NO EXTERNAL POWER SOURCE.**

**Sizes and Weights of Hydraulic and Manual Internal Clamps**

Size in./mm	Part Number Manual Model	Part Number Hydraulic Model	Weight lbs./kg
10 / 254	05-0120-010	05-0119-010	163 / 74
12 / 305	05-0120-012	05-0119-012	195 / 88
14 / 356	05-0120-014	05-0119-014	210 / 95
16 / 406	05-0120-016	05-0119-016	242 / 110
18 / 457	05-0120-018	05-0119-018	268 / 122
20 / 508	05-0120-020	05-0119-020	283 / 128
22 / 559	05-0120-022	05-0119-022	301 / 137
24 / 610	05-0120-024	05-0119-024	339 / 154
26 / 660	05-0120-026	05-0119-026	360 / 163
28 / 711	05-0120-028	05-0119-028	400 / 182
30 / 762	05-0120-030	05-0119-030	420 / 191
32 / 813	05-0120-032	05-0119-032	450 / 204
34 / 864	05-0120-034	05-0119-034	522 / 237
36 / 914	05-0120-036	05-0119-036	585 / 270



## Internal Pneumatic Alignment Clamp

### Air Powered Clamp



#### Internal Pneumatic Clamp include:

- Comes with 40 Feet/12M of reach rods.
- Clamp with copper back-up ring available on request.
- Air Hose.
- Control End.
- Hook End.

The Air Powered Clamps come available in sizes 6" - 60" / 164-1524mm. Clamps of this size will cover two pipe sizes by use of conversion kits. Standard clamps are adjustable up to 1/2" / 13mm wall thickness, modified clamps are available for heavier wall pipe. A Powered Travel Drive is available on models 10"-60" / 273-1524mm. For efficient operation, the compressed air pressure should be 180-200 PSI / 12.4-13.8 BAR. Maximum safe working pressure is 225 PSI / 15.5 BAR.

Both Non Self-Propelled and Self-Propelled Clamps require compressed air. For sizes 6"-60" / 164-1524mm Non Self-Propelled (Pull Type) requires a 25 CFM Compressor. For sizes 12"-26" / 324-660mm Self-Propelled Clamps require a 40 CFM Compressor.

- **PRECISION MANUFACTURED.**
- **ADDITIONAL** Reach Rod.
- Cement Mortar Lining **COMPATIBILITY.**
- Vertical operation facility.
- Stainless Steel pipe capability.
- De-icers.
- Storage Skid.
- Dual Skid Drive, capability of 3.5 Degree Grade.

#### Non Self-Propelled (Pull Type)

Model	Pipe Size (in./mm)	Length (in./mm)	Width (in./mm)	Height (in./mm)	Weight (lbs./kg)	Cube (ft./m)
AOLC 6	6 / 164	42 / 1067	5.5 / 139	7 / 177	98 / 44	2 / .06
AOLC 8	8 / 219	47 / 1194	7.5 / 190	9 / 229	120 / 54	2 / .06
AOLC 10	10 / 273	57 / 1440	9.25 / 235	10.5 / 267	175 / 79	3.2 / .09
AOLC 12-14	12-14 / 324-356	58 / 1473	12.5 / 318	14 / 358	225 / 102	5.9 / .17
AOLC 16-18	16-18 / 408-457	70 / 1778	16 / 406	17.5 / 445	418 / 190	11.3 / .32

#### Non Self-Propelled (Line Travel)

Model	Pipe Size (in./mm)	Length (in./mm)	Width (in./mm)	Height (in./mm)	Weight (lbs./kg)	Cube (ft./m)
AOLC 10	10 / 273	62 / 1575	10 / 254	11.5 / 292	300 / 136	4.1 / .12
AOLC 12-14	12-14 / 324-356	90 / 2286	12 / 305	13.5 / 345	355 / 161	8.4 / .24
AOLC 16-18	16-18 / 408-457	115 / 2921	16 / 406	17.5 / 445	552 / 250	18.6 / .53
AOLC 20-22	20-22 / 508-559	115 / 2921	18.5 / 469	20 / 508	625 / 284	24.6 / .68
AOLC 24-26	24-26 / 610-660	104 / 2641	24 / 610	25.5 / 648	825 / 420	36.8 / 1.04



# PIPE ALIGNING AND REFORMING CLAMPS EXPLAINED

The pipe clamping systems available today are safe, accurate, and designed for just about every application.



*Chain clamp is used to align and hold in position 48-in. pipe for welding.*

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

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

The welding distributor must have sources for companies to purchase the proper

Story based on information provided by Mathew Dearman ([www.mathew.com](http://www.mathew.com)), Tulsa, Okla.  
Published July 2003 *Welding Journal* - Reprint with permission of *Welding Journal*



clamping equipment to align pipes and fittings faster without sacrificing the safety of the welder.

### Clamps to Fit the Application

Five different types of alignment clamps are on the market to cover every aspect of pipe and fitting alignment and reforming needs of companies. Whether the workplace is a small tube or large vessel, a clamp is available to fit the customer's requirements. Clamps are available to internally or externally align pipe or shell diameters from  $\frac{3}{8}$  in. to 20 ft (9.5 mm to 6 m). Clamps are available to reform pipes or tubes with a wall thickness up to Schedule 80 with an out-of-round condition up to 2 in.

Clamping systems are available for all the purposes listed below.

- 1) To align and reform the mating side of the weld joint.
- 2) To align and reform both sides of the weld joint.
- 3) To align and reform pipes, tubes, elbows, tees, flanges, and other fittings.
- 4) For rounding pipes.
- 5) To hold tubes in position for orbital welding.
- 6) Pneumatic or hydraulic internal alignment clamps to align the interior of pipe or fittings.
- 7) For full-circle welding of the pipe without removal of the clamp.
- 8) To hold pipe ends against a consumable welding insert.
- 9) To hold pipes in place on jack stands.
- 10) For carbon steel, stainless steel, and other specialty alloys.

### Types of Clamping Systems Available

Chain-type clamps align and reform pipe diameters as small as 1 in. (25 mm) and as large as 20 ft (6 m). Chain clamps allow pipe, elbow, tee, flange, and other fittings to be held safely and securely in place during the alignment and welding process. Each style of chain clamp is designed to reform multiple pipe sizes. Most manufacturers of this style clamp have enough clearance under the jack-bar to permit the use of a gas metal arc welding gun or gas tungsten arc welding torch. The inside or outside of the pipe can be aligned with these clamps. Accessories such as level and support devices assist the welder in holding and accurately positioning pipe or fittings for welding. Other accessories such as spacing screws will allow the operator to accurately adjust the weld root opening without risk of injury.

Cage clamps are available for pipe sizes 2 to 60 in. (51 to 1524 mm). These cable or rigid frame clamps are designed for rapidly aligning the outside diameter and come in two basic styles. The "tack type" cage clamp

When proper clamping devices are employed, the operator is able to safely and precisely align and reform the pipe or fittings.

is used to align pipes for tack welding. The "no-tack" type allows the joint to be completely welded without removal of the clamp. These clamps are designed to align only one pipe size per clamp. The clamps are available in hand lever, ratchet, and hydraulic models.

Full-circle steel-type clamps are available for pipe sizes 6 to 72 in. (152 to 1829 mm) and have multiple contact points to handle aligning, reforming, or rounding applications. These clamps are designed to put pressure on the high point of the pipe or shell and bring them into alignment. The welder is able to do a 100% weld and grind without removal of this type of clamp.

Frame-type clamping devices that make three-point contact with the pipe are available for pipe sizes 1 to 14.5 in. (25 to 368 mm). These clamps adjust from one pipe size to another by means of a T-handle located at the top of the clamp. A range of three or four pipe sizes can be covered with one clamp. The clamps can be used to align the inside or outside of carbon steel or stainless steel pipes. These clamps are used for aligning the pipes and not for reforming the pipe wall.

Some small precision clamps, with a pipe range from  $\frac{3}{8}$  to 12 in. (9.5 to 305 mm), have jaws that work independently of each other. They align and securely hold two sections of small diameter steel or stainless steel pipe or tubing for autogenous welding. The radial clearance and distance between the jaws is such that most orbital welding heads will fit between them. Pipes or tubes align with the clamps. The clamps are available in both carbon steel and stainless steel to complete welds on small diameter steel and stainless steel pipes and tubes.

Internal hydraulic and pneumatic alignment clamps are used mainly for pipeline applications and are available for pipe sizes 6 to 60 in. (152 to 1524 mm). These clamps cover a range of one to six pipe sizes, depending upon the make and model. These clamps allow a full circle to be completed without obstruction. An automated welding

system used in conjunction with the clamp increases productivity, lowers weld rejects, and reduces operator fatigue.

### Safety Considerations

Pipe clamping devices help speed the aligning process, lowering operator fatigue. These clamping devices eliminate hydraulic jacks, come-a-longs, and weld-on lugs, which can be an extreme safety hazard to all personnel involved in the aligning and reforming process. When proper clamping devices are employed, the operator is able to safely and precisely align and reform the pipe or fittings. Needless cutting and regrinding are not required because the two pipes or fittings are mated correctly the first time.

Prior to operating the equipment, it should be checked for proper operation and any required maintenance. If an air, hydraulic, or electrical power source powers the tool, it should be disconnected from the equipment prior to inspection or maintenance. The tool should never be used if it is not in proper working order.

The maintenance area should be kept as clean as possible to prevent foreign debris, such as sand, grinding dust, or metal shavings, from being introduced into the final assembly as subcomponents are installed. High-temperature grease, such as gun grease, that is not water-soluble should always be used to lubricate the components of the tool. Lithium grease is not recommended.

Clamps used to align and/or reform pipes and fittings are some of the most misunderstood and misused pieces of equipment. Due to the weights and tensile strengths of pipes, it is extremely important that operators receive adequate training on the reforming and aligning of pipes to fittings, valves, and flanges. Personnel who use makeshift devices or the incorrect clamp for an application cause many accidents.

### Know Your Needs

The following points should be considered when selecting a clamp:

- Diameter of the pipe
- Pipe wall thickness
- Tensile strength
- Type of material
- Need for alignment and reforming
- Operator fatigue

The customer service departments of clamping device manufacturers are always available to assist the welding distributor in selecting the right clamp to fit the customer's application. ♦





More Ways to Help Welders and Pipefitters • More Ways to Help Welders and Pipefitters • More Ways to Help Welders and Pipefitters

Discover our complete line of **NEW and INNOVATIVE PRODUCTS**. Since our beginning—our **MISSION** at Mathey Dearman has been to be the **INDUSTRY LEADER**. We have always implemented strategies for ourselves to set the standard for others to follow. As in the past, our goal is to design **NEW and INNOVATIVE PRODUCTS** that will benefit you. Please review our **Customer Ratings** on these exclusive Mathey Dearman Products.

Please browse our website ([www.mathey.com](http://www.mathey.com)) for complete catalog information on all of our products or contact our **Sales Department** with your next requirements. Mathey Dearman can also be contacted through our **Live Chat Line** on our Website from 8:00am to 5:00pm Central Standard Time. The **Literature Line** is open Twenty Four (24) hours a day - Seven (7) days a week. (*We ship domestically and internationally.*)

### Customer Rating

Application	Accu-Fit	EZ-Fit	Mini-Fit	Dearman Light Single Jackscrew	Dearman Light Double Jackscrew	Original Single Jackscrew	Original Double Jackscrew	Universal Chain Clamp	Double Chain Camp	Rim Clamp	Tack Type Cage Clamp	Tack Type Cage Clamp
Clearance Under Jackscrew for Working	☆☆☆	☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆☆☆
Clamps a Range of Four (4) Pipe Sizes	☆☆☆☆	☆☆☆☆	N/A	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆
Clamps a Range of More Than Four (4) Pipe Sizes	☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆	☆☆
Pipe or Tube can be Welded with Removal of the Clamp	☆☆☆☆	☆☆☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆☆☆
Align Small Diameter Thin Wall Tubing	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆	☆☆	☆☆
Can Adjust for Pipe High Low	N/A	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆
Align Schedule 40 Pipe	☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆
Referenc Schedule 40 Pipe	☆☆	☆☆	☆☆	☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆
Align Schedule 80 Pipe	☆☆	☆☆	☆☆	☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆
Referenc Schedule 80 Pipe	☆☆	☆☆	☆☆	☆☆	☆☆	☆☆	☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆
Additional Jackscrew can be Added Without Removal of Clamp	☆☆	☆☆	☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆	☆☆	☆☆
Model Available for Stainless Steel and Other Specialty Alloys	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆	☆☆

☆☆☆☆☆☆ Best  
 ☆☆☆☆☆ Better  
 ☆☆☆☆ Average  
 ☆☆ Below Average  
 ☆ Worse  
 NA Not Applicable

### Pipe Condition

Application	Accu-Fit	E-Z Fit	Mini-Fit	Dearman Light Single Jackscrew	Dearman Light Double Jackscrew	Original Single Jackscrew	Original Double Jackscrew	Universal Chain Clamp	Double Chain Clamp	Rim Clamp	Cage Clamp
Align Small Diameter Thin Wall Tubing	☆☆☆☆	☆☆☆☆	☆☆☆	☆☆☆	☆☆☆	☆☆	☆☆	☆☆	NR	NR	NR
Align 1" to 2" / 25mm to 50mm Diameter Schedule 40 Pipe	NR	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	NR	☆☆☆☆	☆☆☆☆
Referencing 1" to 2" / 25mm to 50mm Diameter Schedule 40 Pipe	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR	NR	☆☆☆☆	☆☆☆☆
Align 1" to 2" / 25mm to 50mm Diameter Schedule 80 Pipe	NR	☆☆	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR	NR	☆☆☆☆	NR
Referencing 1" to 2" / 25mm to 50mm Diameter Schedule 80 Pipe	NR	NR	NR	NR	NR	NR	NR	NR	NR	☆☆☆☆	NR
Align 2" to 36" / 50mm to 914mm Diameter Schedule 40 Pipe	NR	NR	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆	☆☆☆☆
Referencing 2" to 36" / 50mm to 914mm Diameter Schedule 40 Pipe	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR	☆☆☆☆	☆☆☆☆	NR
Align 2" to 36" / 50mm to 914mm Diameter Schedule 80 Pipe	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR	☆☆☆☆	☆☆☆☆	☆☆☆☆
Referencing 2" to 36" / 50mm to 914mm Diameter Schedule 80 Pipe	NR	NR	NR	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR
Align 36" to 54" / 914mm to 1372mm Large Diameter Schedule 40 Pipe	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR	☆☆☆☆	☆☆☆☆	☆☆☆☆
Referencing 36" to 54" / 914mm to 1372mm Large Diameter Schedule 40 Pipe	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR	☆☆☆☆	☆☆☆☆	NR
Align 36" to 54" / 914mm to 1372mm Large Diameter Schedule 80 Pipe	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR	☆☆☆☆	☆☆☆☆	NR
Referencing 36" to 54" / 914mm to 1372mm Large Diameter Schedule 80 Pipe	NR	NR	NR	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR
Align above 54" / 1372mm Diameter Schedule 40 Pipe	NR	NR	NR	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	☆☆☆☆
Referencing above 54" / 1372mm Diameter Schedule 40 Pipe	NR	NR	NR	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR
Align above 54" / 1372mm Diameter Schedule 80 Pipe	NR	NR	NR	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR
Referencing above 54" / 1372mm Diameter Schedule 80 Pipe	NR	NR	NR	NR	NR	NR	NR	NR	☆☆☆☆	☆☆☆☆	NR

☆☆☆☆☆☆ Best  
 ☆☆☆☆☆ Better  
 ☆☆☆☆ Average  
 ☆☆ Below Average  
 ☆ Worse  
 NR Not Recommended





# Let Mathey Dearman Help You Select the Right Clamping Equipment for Your Project.

More Ways to Help Welders and Pipefitters • More Ways to Help Welders and Pipefitters • More Ways to Help Welders and Pipefitters

Please fill out the following questionnaire so that the clamping experts at Mathey Dearman, Inc. can help you select the right equipment.

Company Name \_\_\_\_\_  
 Your Name \_\_\_\_\_ Title \_\_\_\_\_  
 Address \_\_\_\_\_ City/State \_\_\_\_\_ Zip Code \_\_\_\_\_  
 Phone # (\_\_\_\_) \_\_\_\_\_ Fax # (\_\_\_\_) \_\_\_\_\_ Email \_\_\_\_\_

- Briefly describe what you are trying to accomplish. \_\_\_\_\_
- How is the pipe, flange, elbow, tee or other fitting currently being aligned and/or reformed? \_\_\_\_\_
- Please Check (✓) boxes which apply to your application.

Pipe Size (in./mm)	Schedule					Other	Type Material		Reform		Align		Type of Alignment		Backup Required		Aligning Flange	
	10	20	40	80	120		Ferrous	Non-Ferrous	Yes	No	Yes	No	Internal	External	Yes	No	Yes	No
Example: 8" (203mm)			✓				✓			✓	✓		✓		✓		✓	
	10	20	40	80	120													
	10	20	40	80	120													
	10	20	40	80	120													
	10	20	40	80	120													
	10	20	40	80	120													
	10	20	40	80	120													

- Type of Pipe / Plate: Seamless  Has Seam  Spiral Welded  Plate
- Clearance around pipe: 0"-6" / 0-152mm  6"-8" / 152-203mm  10"-12" / 254-305mm   
 Clearance is no problem  Other (Please list and specify whether inches or millimeters) \_\_\_\_\_
- The alignment will be: Pipe to Pipe  Pipe to Elbow  Pipe to Tee  Pipe to Flange   
 Other (Please Explain) \_\_\_\_\_
- If the pipe is out of round, by how much:  
 1/4" / 6mm  1/2" / 13mm  3/4" / 19mm  1" / 25mm  1 1/2" / 38mm  2" / 51mm   
 If the pipe out of round condition is more than 2" / 51mm, please specify how much. \_\_\_\_\_
- Which welding process is being used: Mig  Tig  Submerged Arc  Stick
- What is most important to you? (Please indicate the order of priority with (1) most important and (7) the least important.)  
 Versatility  Weight  Ease of Use  Minimum Set-up   
 Efficiency  Accuracy  Cost
- Are these pipes, flanges, elbows or tees being welded to a welding code? Yes  No   
 If for a code weld, please specify: ANSI  AWS  ASME  Other (Please list) \_\_\_\_\_
- If ordering an Internal Pneumatic or Hydraulic Pipe Clamp or Pipe Bender, would you also like for us to quote the power source? Yes  No
- This inquiry is for: Immediate Purchase  Future Project  General Information
- Would you like to be kept informed about new products? Email  Fax  Mail
- Would you like a factory representative to visit you to discuss the project or demonstrate the equipment?  
 Yes  No
- What is the best time to call? \_\_\_\_\_





# CREDIT APPLICATION

Call: 1.800.725.7311  
Fax: 1.918.447.0188

Order Pending  Yes  No

1. First Name: \_\_\_\_\_ Last Name: \_\_\_\_\_ Title: \_\_\_\_\_
2. Company Name: \_\_\_\_\_ Name of Managing Director: \_\_\_\_\_  
Name of Sales Manager: \_\_\_\_\_ Account Payable Manager: \_\_\_\_\_
3. Main Office Address: \_\_\_\_\_  
Street / City / State / Zip Code
4. Mailing Address: \_\_\_\_\_  
Street / City / P.O. Box / State / Zip Code
5. Shipping Address: \_\_\_\_\_  
Street / City / State / Zip Code
6. Phone: \_\_\_\_\_ Fax: \_\_\_\_\_ Email: \_\_\_\_\_
7. Type of Business  Industrial Supply  Welding Distributor  Other (explain) \_\_\_\_\_
8. How many years in business? \_\_\_\_\_ 9. What major manufacturers do you represent? \_\_\_\_\_
10. Yearly Sales \_\_\_\_\_ 11. How many store locations do you have? \_\_\_\_\_  
(Please send a list of store locations and managers.)
12. Tax Exempt Number \_\_\_\_\_ 13. Which State? \_\_\_\_\_
14. Credit Reference: Anticipated Credit Requirement of: \$ \_\_\_\_\_

Company Name	Company Name	Company Name
Address	Address	Address
Phone	Phone	Phone
Contact /Acct. #	Contact /Acct. #	Contact /Acct. #

15. Bank Reference (Should be in relation to Credit Reference in Number 14 above.)  
We authorize you, our bank reference, to release credit information regarding the following accounts to Mathey Dearman, Inc.
- |                  |                 |         |
|------------------|-----------------|---------|
| Bank Name        | Banking Officer | Address |
| City             | State Zip       | Phone   |
| Checking Acct. # | Loan Acct. #    |         |

### Authorization & Agreement to Release Credit Information

Mathey Dearman, Inc., is hereby authorized to obtain credit and/or financial information from my/our bank(s), other financial institutions or commercial firms with which I/we have done business. It is understood that any such credit and/or financial information will be held in strict confidence and used only for consideration of this application.

Upon approval of this application, it is agreed that all purchases will be paid in full and in accordance with the terms of the sales net 30 days from date of invoice. Should I/we not pay Mathey Dearman, Inc. according to terms, it is understood that credit privileges may be withdrawn. Should Mathey Dearman, Inc. find it necessary to obtain assistance in collecting any past due balance, I / We agree to pay all reasonable attorney fees, collection agency fees and/or court cost necessary to collect past due amounts. Past Due Accounts are charged interest. This offer is limited only to these terms.

Signature of Authorized Officer \_\_\_\_\_ Name (Please Print) \_\_\_\_\_  
Title \_\_\_\_\_ Date \_\_\_\_\_





# ORDER FORM

Call: 1.800.725.7311  
Fax: 1.918.447.0188

**Ordered By:**

Company Name \_\_\_\_\_  
 First Name \_\_\_\_\_ Last Name \_\_\_\_\_  
 Address \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Country \_\_\_\_\_ Last Name \_\_\_\_\_  
 Phone \_\_\_\_\_ Contact Person \_\_\_\_\_

**Ship To: (Only if different from "Ordered By")**

Company Name \_\_\_\_\_  
 First Name \_\_\_\_\_ Last Name \_\_\_\_\_  
 Address \_\_\_\_\_  
 City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_  
 Country \_\_\_\_\_

Part Number	Description	Qty	Total	US\$

**Method of Payment: All prices stated in US Dollars**

**Charge to My (Check one):**  
 MasterCard  
 Visa  
 American Express  
 Check or Money Order

**Ship My Order**  
 Parcel Post  
 UPS 3 Day Select  
 UPS Next Day  
 Regular UPS  
 UPS 2 Day  
 Other: \_\_\_\_\_

Enclosed (US Funds Only)

**Total Price of Items:** \_\_\_\_\_  
 Tax (OK only) \_\_\_\_\_  
 USA SPH (See Below) \_\_\_\_\_  
**Total** \_\_\_\_\_

\*See Below

\*If weight and size permits - we will ship UPS.  
 Charges for freight will be added to your order.  
 Please check:  if you want us to call before your freight is shipped.

Credit Card Number \_\_\_\_\_  
 \_\_\_\_\_  
 Expiration Date \_\_\_\_ / \_\_\_\_  
 Company Name \_\_\_\_\_  
(Fill in company name if Company Credit Card.)

X \_\_\_\_\_  
Signature of person on Credit Card (as shown on Credit Card)

X \_\_\_\_\_  
Please Print Your Name Here

Title \_\_\_\_\_

I would prefer to order from my own supply store.  
 Please forward this order to:

\_\_\_\_\_ Company Name  
 \_\_\_\_\_ Address  
 \_\_\_\_\_ City State Zip  
 \_\_\_\_\_ Phone Number

—Thank You For Your Order—





## Mathey Dearman, Inc. Warranty

If any merchandise sold hereunder (except merchandise manufactured by other persons or firms) by Mathey Dearman, Inc. (the "Company") is not in accordance with specifications shown on the order within customarily accepted tolerances, or is defective on account of workmanship or material, and if such merchandise is returned at the customer's expense and risk, to the Company's manufacturing facility (or at the Company's option, is returned to a repair facility authorized by the Company), within ninety (90) days after the Company's date of shipment thereof, the Company will, at its option, replace or repair the merchandise. This agreement, however, is upon the conditions: (A) That the customer promptly notify the Company in writing of any claim under this agreement, setting forth in detail any such claimed defect. (B) That the Company be afforded a reasonable opportunity to examine the merchandise and to investigate the claimed defect at the Company's manufacturing facility or at an authorized repair facility, the Company shall not be, in any event, liable for damages beyond the price paid by the customer for such defective merchandise, specifically but without limitation, the Company may fulfill its obligations under this Agreement by tendering such purchase price at any time. THE COMPANY SHALL NOT BE LIABLE FOR CONSEQUENTIAL, INCIDENTAL, PUNITIVE, OR EXEMPLARY DAMAGES. This agreement does not obligate the Company to bear any transportation charges in connection with the replacement or the repair of defective merchandise. As to any item manufactured by other persons or firms, the Company agrees to present a request for adjustment for repair to such manufacturer, and the customer agrees that the liability of the Company shall not exceed any adjustment with respect to which such manufacturer accepts responsibility. THE ABOVE AGREEMENT IS IN LIEU OF ALL WARRANTIES, EXPRESSED OR IMPLIED AND IT IS AGREED THAT THERE IS NO EXPRESSED OR IMPLIED WARRANTY BY THE COMPANY AS TO THE FITNESS, MERCHANTABILITY CAPACITY, OR EFFICIENCY OF ANY MERCHANDISE SOLD, AND THAT THERE ARE NO ORAL OR WRITTEN EXPRESSED OR IMPLIED WARRANTIES MADE IN CONNECTION WITH ANY SALE BY THE COMPANY. No modification or addition to this agreement, either before or after the contract of sale, shall be made except on written authority of the President or Vice President of the Company.

### Force Majeure

Mathey Dearman, Inc. shall not be liable for any delay in or impairment of the performance resulting in total or in part from Acts of God, labor disruptions, laws, inability to procure product, shortages of supplies or raw materials, civil war or other act of hostility or any other circumstances beyond the control of Mathey Dearman, Inc.

### Quotations

Quick and accurate quotations on orders of any size are available upon request. Please contact Mathey Dearman, Inc. Sales Department 1 (800) 725-7311, (918) 447-1288 or fax (918) 447-0188 - or email us at: [www.sales@mathey.com](mailto:www.sales@mathey.com).

### Technical Support

Our knowledgeable and skilled staff is eager to assist you in your search for solutions. Please contact Mathey Dearman, Inc. Sales Department 1 (800) 725-7311 or (918) 447-1288. Mathey Dearman can also be contacted through our Live Chat Line on our Website from 8:00am to 5:00pm Central Standard Time. The Live Chat Line is open Twenty Four (24) hours a day - Seven (7) days a week.

### Catalogue Errors

All information in the catalogue has been carefully checked for accuracy. Errors and omissions occasionally occur and therefore are subject to correction. We regret any inconvenience.

### Terms and Billing Options

Net 30 days on approved open account from date of invoice. In addition to open accounts, we accept cash, C.O.D., wire transfer, letter of credit and credit card (Visa, MasterCard and American Express).

### Cancellation

Any cancellation must be approved by Mathey Dearman, Inc., and may be subject to restocking or other charges.

### Sales Tax

Mathey Dearman, Inc. is required to charge state and local taxes for shipment within Oklahoma only on any items for which a sales tax exemption certification has not been provided.

### Freight Policy

Unless otherwise stated, freight and shipping fees will be charged for shipments to a customer's place of business anywhere in the contiguous United States, using a carrier of the customer's choice. Other terms apply to Alaska, Hawaii, Puerto Rico, and export orders.

Any extra charges incurred for additional services and special handling by the customer's carrier, must be paid by the consignee.

Title and risk of loss will be passed to the customer upon tender of the shipment to the carrier. If the product is damaged in transit, consignee must file the claim with the carrier. Do not return the damaged product to Mathey Dearman, Inc. without filing the freight claim, if consignee is responsible for the freight.

### Returns and Warranty Repairs

#### Returns

To return products for credit or warranty repair, you must call Mathey Dearman Inc. at (918) 447-1288 for a Return Goods Authorization (RGA) number. No returns will be accepted without a RGA number. Please print the RGA number on the outside of the box and include with the returned product a copy of your invoice or packing list. Make sure the product is packed properly. Any damages due to improper packing will be the responsibility of the shipper. Merchandise is subject to restocking charge.

Any claims for discrepancies in shipment must be made within 7 days of receipt of merchandise. C.O.D. returns will not be accepted. Mathey Dearman, Inc. will not accept product returned for credit, which have been painted, etched or altered.

When returning products for credit or warranty repair to Mathey Dearman, Inc., ship the product to:

Mathey Dearman, Inc.  
4344 South Maybelle Ave.  
Tulsa, OK 74107





## Mathey Dearman, Inc. Warranty

(Warranty Continued.)

### Return Goods and Warranty Policies

#### In Error/Excess Items Ordered

Return goods wrongly or over-ordered will be accepted provided that:

- (1) They are normal stock items i.e. not obtained by customer on order.
- (2) They are received by Mathey Dearman in as-new condition, in their original packaging.
- (3) They have been supplied by Mathey Dearman within the previous six (6) months.
- (4) They are returned to Mathey Dearman postage paid.
  - (a) 15% handling charge will be applied for all returned goods.
  - (b) In Error, Faulty or Damaged Goods Supplied/

Claims for loss or damaged goods in transit cannot be considered *received complete and in good condition*.

#### To return goods in case (a) and (b) above:

- (1) Call your Sales Representative advising the intention to return goods with Mathey Dearman invoice, serial number and date.
- (2) You will be issued with an (RGA) Return Goods Authorization Number which must be noted on the returned package.
- (3) Returns will not be accepted without an (RGA) Return Goods Authorization.
- (4) Goods must be returned within 7 days of issue of (RGA).

When returning products for credit or warranty repair to Mathey Dearman, Inc., ship the product to:

Mathey Dearman, Inc.  
4344 South Maybelle Ave.  
Tulsa, OK 74107

### Repairs

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

When returning tools for repair to Mathey Dearman, Inc., ship the product to :

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

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

Please be advised that as of December, 2003, Mathey Dearman, Inc., implemented a \$50.00 NEW Minimum Order after Trade Discount. If an order is received for less than \$50.00, the order will be placed on "hold" and distributor will be notified in order to assist them to complete the order to satisfy their customers. If the Distributor chooses not to add items, the Distributor can still have the order processed with an additional processing fee based on actual order.

### New Expediting Shipment Policy

Mathey Dearman, Inc. now offers an additional service to our customers. Effective January 1, 2002, Mathey Dearman instituted an "Expedited Shipment Policy" for our customers that request immediate delivery if the order is placed after UPS Pickup.

Normal business hours for Mathey Dearman, Inc. are 8:00 a.m. to 5:00 p.m. (Central Standard Time). Normal UPS Shipment pickup is 3:15pm (Oklahoma time). Any orders placed after 3:25pm, that the customer requires immediate shipment, a courier will be notified at the customer's expense with an additional \$25.00 Mathey Dearman, Inc. processing fee, as well as the courier fee. Take advantage of this opportunity for Mathey Dearman to work for you and for your customers.

### Custom Tool Design

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

### Rental Policy

We offer for rent any standard Chain Clamp, Rim Clamp, or Pipe Cutting and Beveling Machine. Rental terms are available from your authorized Mathey Dearman, Inc. Distributor. A Buy-Out Option is available for Distributors wishing to purchase rental equipment. Contact Mathey Dearman, Inc. distributor for details or contact Mathey Dearman, Inc. Sales Department for the nearest authorized Mathey Dearman, Inc. Distributor at (800) 725-7311 or (918) 447-1288.





More Ways to Help Welders and Pipefitters • More Ways to Help Welders and Pipefitters • More Ways to Help Welders and Pipefitters

## COMMERCIAL PIPE SIZES AND WALL THICKNESS

Pipe Size In Inches	O.D. In Inches	Nominal Wall Thickness For								
		Sched. 10	Sched. 20	Sched. 40	Extra Strong	Sched. 80	Sched. 120	Sched. 140	Sched. 160	XX Strong
1/8	0.405	-	-	0.068	0.095	0.095	-	-	-	-
1/4	0.540	-	-	0.088	0.119	0.119	-	-	-	-
3/8	0.675	-	-	0.091	0.126	0.126	-	-	-	-
1/2	0.840	-	-	0.109	0.147	0.147	-	-	0.188	0.294
3/4	1.050	-	-	0.113	0.154	0.154	-	-	0.219	0.308
1	1.315	-	-	0.133	0.179	0.179	-	-	0.250	0.358
1 1/4	1.660	-	-	0.140	0.191	0.191	-	-	0.250	0.382
1 1/2	1.900	-	-	0.145	0.200	0.200	-	-	0.281	0.400
2	2.375	-	-	0.154	0.218	0.218	-	-	0.344	0.436
2 1/2	2.875	-	-	0.203	0.276	0.276	-	-	0.375	0.532
3	3.5	-	-	0.216	0.300	0.300	-	-	0.438	0.600
3 1/2	4.0	-	-	0.226	0.318	0.318	-	-	-	-
4	4.5	-	-	0.237	0.337	0.337	0.438	-	0.531	0.664
4 1/2	5.0	-	-	-	0.355	-	-	-	-	0.710
5	5.563	-	-	0.258	0.375	0.375	0.500	-	0.625	0.750
6	6.625	-	-	0.280	0.432	0.432	0.562	-	0.710	0.864
7	7.625	-	-	-	0.500	-	-	-	-	0.875
8	8.625	-	0.250	0.322	0.500	0.500	0.710	0.812	0.096	0.875
9	9.625	-	-	-	0.500	-	-	-	-	-
10	10.75	-	0.250	0.365	0.500	0.594	0.844	1.000	1.125	1.000
11	11.75	-	-	-	0.500	-	-	-	-	-
12	12.755	-	0.250	0.046	0.500	0.688	1.000	1.125	1.312	1.000
14 O.D.	14.0	0.250	0.312	0.438	0.500	0.750	1.094	1.250	1.406	-
16 O.D.	16.0	0.250	0.312	0.500	0.500	0.844	1.219	1.438	1.594	-
18 O.D.	18.0	0.250	0.312	0.562	0.500	0.938	1.375	1.562	1.781	-
20 O.D.	20.0	0.250	0.375	0.594	0.500	1.031	1.500	1.750	1.969	-
22 O.D.	22.0	0.250	0.375	-	0.500	1.125	1.625	1.875	2.125	-
24 O.D.	24.0	0.250	0.375	0.688	0.500	1.218	1.812	2.062	2.344	-
26 O.D.	26.0	0.312	0.500	-	0.500	-	-	-	-	-
28 O.D.	28.0	0.312	0.500	-	0.500	-	-	-	-	-
30 O.D.	30.0	0.312	0.500	-	0.500	-	-	-	-	-
32 O.D.	32.0	0.312	0.500	0.688	0.500	-	-	-	-	-
34 O.D.	34.0	0.312	0.500	0.688	0.500	-	-	-	-	-
36 O.D.	36.0	0.312	0.500	0.750	0.500	-	-	-	-	-
42 O.D.	42.0	0.312	-	-	0.500	-	-	-	-	-
48 O.D.	48.0	-	-	-	0.500	-	-	-	-	-

The table lists the pipe sizes and wall thickness currently established as standard, or specifically:

1. The traditional standard weight, extra strong, and double extra strong pipe.
2. The pipe wall thickness schedules listed in American Standard B36.10, which are applicable to carbon steel and alloys other than stainless steels.
3. The pipe wall thickness schedules listed in American Standard B36.19, and ASTM Specification A409, which are applicable only to corrosion resistant material.





# MATHEY DEARMAN

Mathey Dearman has now integrated a "Live Online Support" feature directly on our website for all of our dedicated customers and distributors. This new addition opens new avenues of customer service by further helping the needs and requirements of our much appreciated patrons.

Support Hours are Monday Thru Friday from 8am to 5pm (CST)

Our commitment to you has and always shall be excellent customer service anytime you need it. Please remember we can be contacted via

Toll Free: 1-800-725-7311 Fax: 1-918-447-0188  
International: 1-918-447-1288

### Now Available!

Introducing Mathey Dearman's Newest DVD Instructional Video covering a wide range of our fine products!



Contact Mathey Dearman for Your FREE Catalog!



Visit Our Website Today: [www.Mathey.com](http://www.Mathey.com)

Now Available! Try Our New "Fax-On-Demand" System  
Request any Parts and Operating Manual and have it faxed directly to you!  
Available 7 days a week 24 Hours a day at 1-800-725-7311

Sold Exclusively Through Welding and Industrial Distributors and Suppliers.



Mathey Dearman, Inc.  
4344 S. Maybelle Ave, Tulsa, Oklahoma 74107  
WEBSITE: [WWW.MATHEY.COM](http://WWW.MATHEY.COM) - EMAIL: [SALES@MATHEY.COM](mailto:SALES@MATHEY.COM)

