

# PORTABLE STRIP JOINERS

BEHLEN® JOINER

- *Easy to position and use.*
- *Produces a tight, self-locking stitch.*
- *Stitches any width coil from 2" to 72".*
- *No contamination by foreign metal.*



The Portable Strip Joiner by Behlen is ideally suited for repairing broken strips in continuous strip process lines or as the basic joiner in narrow width process lines. Each unit is completely portable and can be easily positioned with an overhead crane, fork lift or any other convenient means. Total weight of the unit is approximately 400 pounds.

All portable units have a 24" throat section with a single die set located in the opening of the "C" frame. The die set is composed of one lower and two upper punches that produce a single self-locking stitch. These are the same patented punches as used on Behlen's stationary Strip Joining Presses. Normal line tension locks each stitch in place and remains smooth for roller line operations.

To make a connection, a series of stitches is made in the over-lapped ends of the strips, starting as close to the center as possible and moving out toward the outside edge. The joiner is then moved to the opposite side of the strip to complete the stitching process. Additional rows of stitching may be added to meet line tension requirements. The Behlen stitching process utilizes only the metal in the coils, thus eliminating contamination by a foreign metal and allowing easy reprocessing of the stitched section.

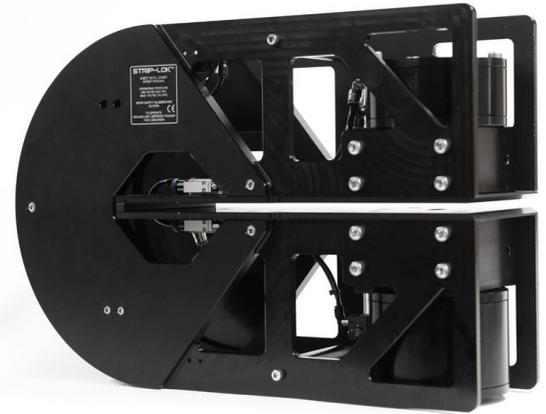
Electric driven pump unit is standard. These units are capable of connecting any thickness of two strips up to 0.80" (2mm) each with limited use up to 0.100" (2.5mm) each. Portable Strip Joiners can join steel, aluminum or any other metal up to 100,000 PSI (690 Mpa) UTS and in coil widths from 2" (51mm) to 72" (1830mm).



# STRIP-LOK™ SHEET METAL JOINER

The STRIP-LOK™ Sheet Metal Joiner is a portable strip-joining machine driven by compressed air. The main use for STRIP-LOK™ joiners is repairing strip tear off situations on modern steel strip processing lines such as continuous galvanizing and paint coil coating lines. Already used by major coil processing plants around the globe, the STRIP-LOK™ Sheet Metal Joiner is highly appreciated and valued. Repeatable, strong connections can be achieved with a total sheet thickness up to 1.8mm (0.07").

	Long Reach Heavy Gauge Low Pressure
Air Pressure, kPa	350 - 500
Weight, kg	18.4
Dimensions	485 (L) 165 (W) 425 (H)
Throat Depth, mm	300
Throat Opening, mm	8
Maximum Strip Thickness	At 450+ kPa Soft Iron 2 @ .9mm Hard Iron 2 @ .6mm



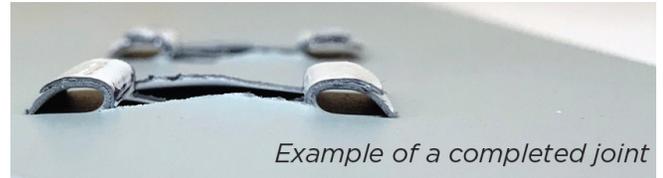
Operation is very clean and quiet as the STRIP-LOK™ Joiner does not require any consumables other than two pieces of Strip to be joined and no blank is produced.

## Principles of operation

The Joint is achieved by mechanically punching a square hole through the sheets to be joined and folding the flared strip back onto itself. Apart from requiring an external compressed air source the STRIP-LOK™ Joiner is fully self contained. The STRIP-LOK™ Joiner is activated as soon as the trigger is pressed and an automatic cycle of punching and flattening the two layers of metal strip will then commence. The joining cycle will immediately stop as soon as the trigger is released.

## Joint Strength

The strength of each joint depends upon the gauge and properties of the metal being connected. As a general rule, 20 punches on each side of .4mm soft iron sheets provide a tensile force of approximately 25kN (5620 lbf).



*Example of a completed joint*



## Long-Reach Heavy Gauge STRIP-LOK™ Joiner

Designed for wide strip, the LRHG Model has a reach of 300mm from the strip edge. It is not necessary to have individual joints across the entire width of the strip. Considerable stability is created in a joint of two overlapping sheets via a reasonable overlap region in the order of 700mm or more. This unit can be used to join strip widths up to 1500mm.



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