

# Dyna Torque Technologies, Inc.



*Our mission is to bring innovations to the pipeline welding industry. Why work harder? Work smarter!*

**INNOVATION  
IN WELDING  
AND  
BEVELING**



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**[www.dyna-torque.com](http://www.dyna-torque.com)**  
**<https://youtube.com/user/dynatorqueinc>**



# Lonestar Single Head Automated Welding System

## Quick Specs

### Pipe Welding Applications

Pipelines  
Cross-country  
Offshore  
Shop and Field  
Fabrication

### Processes

MIG (GMAW)  
Flux-cord (FCAW)  
Pulsed MIG (GMAW-P)  
RMD

Adjustable from 4" to 120"

All Welding Positions

Factory or Narrow Gap Joint

Multiple Welding Power Sources

Light Weight, Compact, and Portable



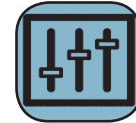
Decreases  
weld time



Increased  
safety



Consistent  
quality of  
Weld



Real Time  
Data Logging



Lonestar automated welding system is designed for pipe welding applications.

System utilizes latest technology to provide precision control of the welding parameters around the pipe.

Absolute position measurement is used to control welding parameters.

System provides digital motorized functions of controlling welding torch; up-down, left- right, lead-lag angle, and travel around the pipe.

Remote control pendant offers ease of use reducing operators learning curve.

System provides Real-Time data logging ensuring quality performance.

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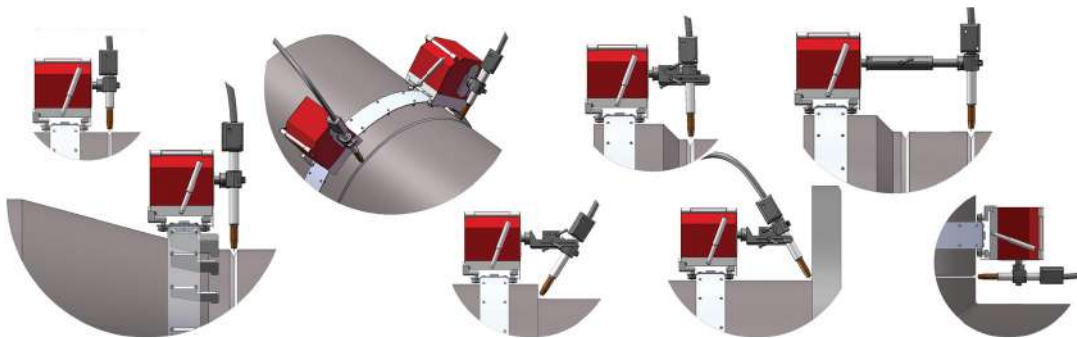
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### Controlling Features

- Risc Based Multi Processor system
- Proprietary Real-Time OS
- Real-Time Welding Data Monitoring & Acquisition
- User Friendly Remote Pendant Control
- User Friendly “Windows Style” application for PC
- Absolute Position Measurement
- Position Dependant Real-Time Parameter Control
- Automated Start/Stop Controls
- Welding Power Source and Wire Feeder Interface
- Blue Tooth Interface

### Single Head System Highlights

- FCAW, GMAW, Pulsed GMAW Welding Processes
- Water Cooled or Gas Cooled Welding Torch Options
- High Deposition Rate
- Low Repair Rate
- Light Weight, Compact, Solid, and Robust
- 24 Hours Operations- For Every Day Use
- Ability to weld All Passes and Processes with One System
- Short Training Time and Familiarization
- Ease of use, Friendly and Flexible Design
- Technical Back Up and Support



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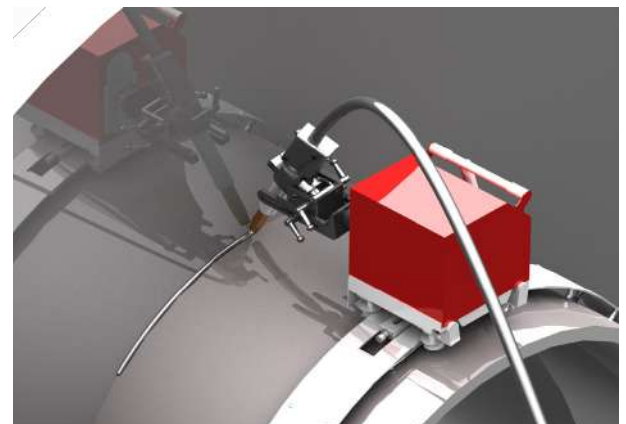
Multiple welding positions

### Technical Specifications

- Single Head Orbital Welder
- Pipe Size Range: 4” (102 mm) to 120” (3048 mm)
- Travel Speed Range: 0” - 200” (5 m)/ min
- Oscillation Speed Range: 0” - 138” (350 cm) / min
- Vertical Movement Range: 2” (51 mm) motorized
- Horizontal Movement Range: 2” (51 mm) motorized
- Head Angle Range: 26 degree (13-0-13) motorized
- Oscillated Dwell Range: 0 to 1 sec
- Position Measurement Range: 360 degree with 0.1 degree precision
- Water Cooled Welding Torch 600A / 100% Duty Cycle
- Gas Cooled Welding Torch 450A / 100% Duty Cycle
- Orbital Welder:
  - Weight: 22 lbs (10 Kg)
  - Length: 8.00” (20.3 cm)
  - Width: 8.50” (21.6 cm)
  - Height: 9.00” (23.0 cm)
- Operating Temperatures: -45 to +50 deg. C
- Clearance Required: < 40 cm

### New Features

- Separate Adjustment For Oscillation Dwell A&B
- Automates Stick Out Control
- Positive and Negative Percent Control for Travel Speed
- Adjustable Torch Control





# Lonestar Dual Head Automated Welding System

## Quick Specs

### Pipe Welding Applications

Pipelines  
Cross-country  
Offshore  
Shop and Field Fabrication

### Processes

MIG (GMAW)  
Pulsed MIG (GMAW-P)  
RMD

Adjustable from 4" to 120"

All Welding Positions

Factory or Narrow Gap Joint

Multiple Welding Power Sources

Light Weight, Compact, and Portable



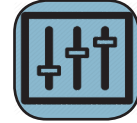
Decreases weld time



Increased safety



Consistent quality of Weld



Real Time Data Logging



Lonestar automated welding system is designed for pipe welding applications.

System utilizes latest technology to provide precision control of the welding parameters around the pipe.

Absolute position measurement is used to control welding parameters.

System provides independent digital motorized control for each welding torch which, includes oscillation and vertical movement control.

Remote control pendant offers ease of use reducing operators learning curve.

System provides Real-Time data logging ensuring quality performance.

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### Controlling Features

RISC Based Multiprocessor System  
Proprietary Real-Time OS  
Real-Time Welding Data Monitoring & Acquisition  
User Friendly Remote Pendant Control  
User Friendly "Windows Style" application for PC  
Absolute Position Measurement  
Position Dependent Real-Time Parameter Control  
Automated Start/Stop Control  
Welding Power Source and Wire Feeder Interface  
Blue Tooth interface

### Dual Head System Highlights

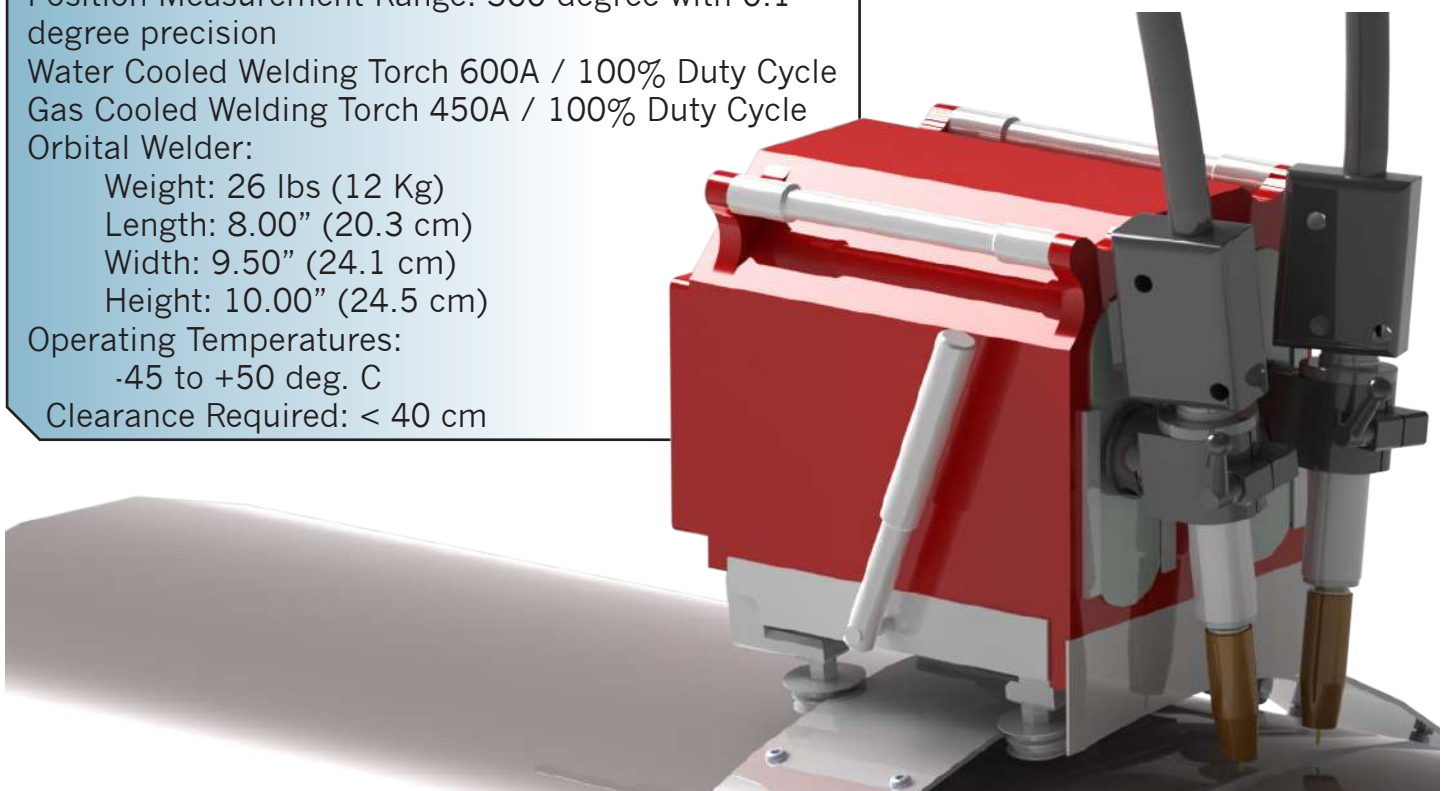
GMAW, Pulsed GMAW Welding Processes  
Water Cooled or Gas Cooled Welding Torch  
High Deposition Rate  
Low Repair Rate  
Light Weight, Compact, Solid, and Robust  
24 Hours Operations- For Every Day Use  
Ability to weld All Passes and Processes with One System  
Short Training Time and Familiarization  
Ease of use, Friendly and Flexible Design  
Technical Back Up and Support

### Technical Specifications

Dual Head Orbital Welder  
Pipe Size Range: 4" (102 mm) to 120" (3048 mm)  
Travel Speed Range: 0"- 200" (5 m)/ min  
Oscillation Speed Range: 0" - 138" (350 cm) / min  
Vertical Movement Range: 2" (51 mm) motorized  
Horizontal Movement Range: 2" (51 mm) motorized  
Head Angle Range: 30 degree (15-0-15) adjustable  
Oscillated Dwell Range: 0 to 1 sec  
Position Measurement Range: 360 degree with 0.1 degree precision  
Water Cooled Welding Torch 600A / 100% Duty Cycle  
Gas Cooled Welding Torch 450A / 100% Duty Cycle  
Orbital Welder:  
Weight: 26 lbs (12 Kg)  
Length: 8.00" (20.3 cm)  
Width: 9.50" (24.1 cm)  
Height: 10.00" (24.5 cm)  
Operating Temperatures:  
-45 to +50 deg. C  
Clearance Required: < 40 cm

### New Features

Independent Oscillation and Height Movements  
Individual Control of Welding Parameter for Both Heads





# Lonestar GTAW Automated Welding System

## Quick Specs

### Pipe Welding Applications

Pipelines  
Cross-country  
Offshore  
Shop and Field Fabrication

### Processes

Orbital  
TIG (GTAW)  
Pulsed TIG (PGTAW)

Adjustable from 4" to 120"

Integrated Wire Feeder/Spool

All Welding Positions

Factory or Narrow Gap Joint

Multiple Welding Power Sources

Light Weight, Compact, and Portable



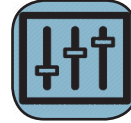
Decreases weld time



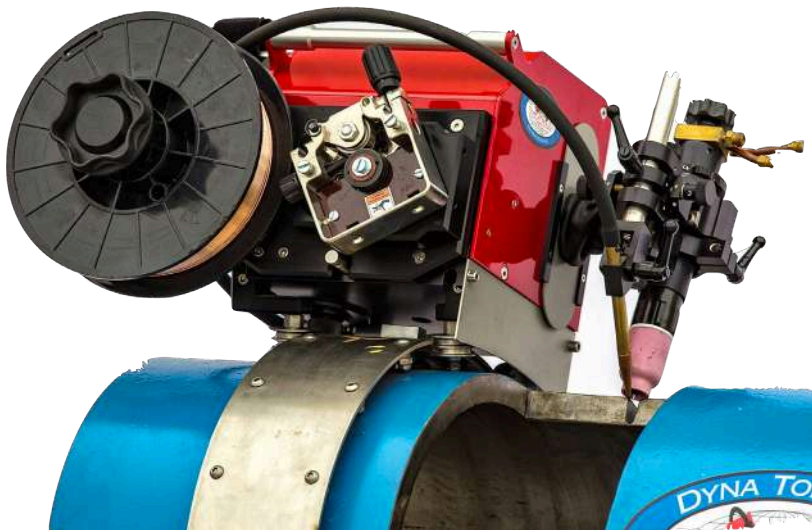
Increased safety



Consistent quality of Weld



Real Time Data Logging



Lonestar automated welding system is designed for pipe welding applications.

System utilizes latest technology to provide precision control of the welding parameters around the pipe.

Absolute position measurement is used to control welding parameters.

System provides digital motorized functions of controlling wire feed and welding torch; up-down, left-right, lead-lag angle, and travel around the pipe.

Remote control pendant offers ease of use reducing operators learning curve.

System provides Real-Time data logging ensuring quality performance.

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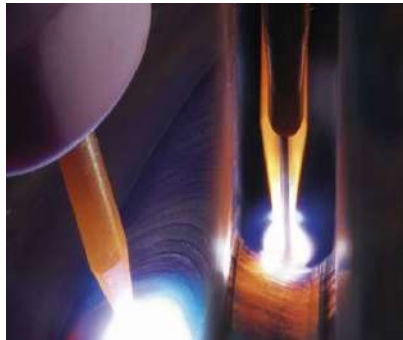
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### Controlling Features

RISC Based Multiprocessor System  
Proprietary Real-Time OS  
Real-Time Welding Data Monitoring & Acquisition  
User Friendly Remote Pendant Control  
User Friendly "Windows Style" application for PC  
Absolute Position Measurement  
Position Dependent Real-Time Parameter Control  
Automated Start/Stop Control  
Welding Power Source and Wire Feeder Interface  
Blue Tooth interface

### GTAW System Highlights

GTAW, Pulsed GTAW Welding Processes  
Water Cooled or Gas Cooled Welding Torch  
High Quality TIG welding  
Low Repair Rate  
Lightweight, Compact, Solid and Robust  
24 Hours Operations - For Every Day Use  
Ability To Weld All Passes and Processes With One System  
Short Training Time and Familiarization  
Ease of use, Friendly and Flexible Design  
Technical Backup and Support



### Technical Specifications

GTAW Orbital Welder  
Pipe Size Range : 4" (102mm) to 120" (3048 mm)  
Travel Speed Range : 0" - 200" (5m) / min  
Oscillation Speed Range : 0" - 138" (350 cm) / min  
Vertical Movement Range : 2" (51 mm) motorized  
Horizontal Movement Range : 2" (51mm) motorized  
Head Angle Range : 26 deg (13-0-13) motorized  
Oscillation Dwell Range: 0 to 1 sec  
Position Measurement Range: 360 deg with 0.1deg precision  
Orbital Welder:  
Weight: 26 lbs (12Kg) + wire spool  
Length: 12.00" (30.4cm), Width: 10.00" (24.5cm)  
Height: 10.00" (24.5cm)  
Operating Temperatures: - 45 to +50 deg C  
Clearance Required < 40 cm

### New Features

Automated Voltage Control (AVC)  
On-board wire feeder  
0-360 deg. welding parameters



# Hydraulic Pipe Facing Machine

## Model: PFM 1236



### Quick Specs

**Pipe Facing/  
Beveling Applications**  
Pipelines  
Cross-country  
Offshore  
Shop and Field  
Fabrication

Pipe Range 12" to 36" in 3 Clamp Sections  
Factory Bevel, J Bevel, and Compound Bevel  
High Speed Bevel Cutting  
Hydraulically Powered Rotation and Feed Rate  
Counterboring Solutions Available  
Easy to Set-up, Compact, and Portable  
Diesel or Electric Hydraulic Power Unit



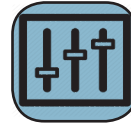
**Increases  
Productivity**



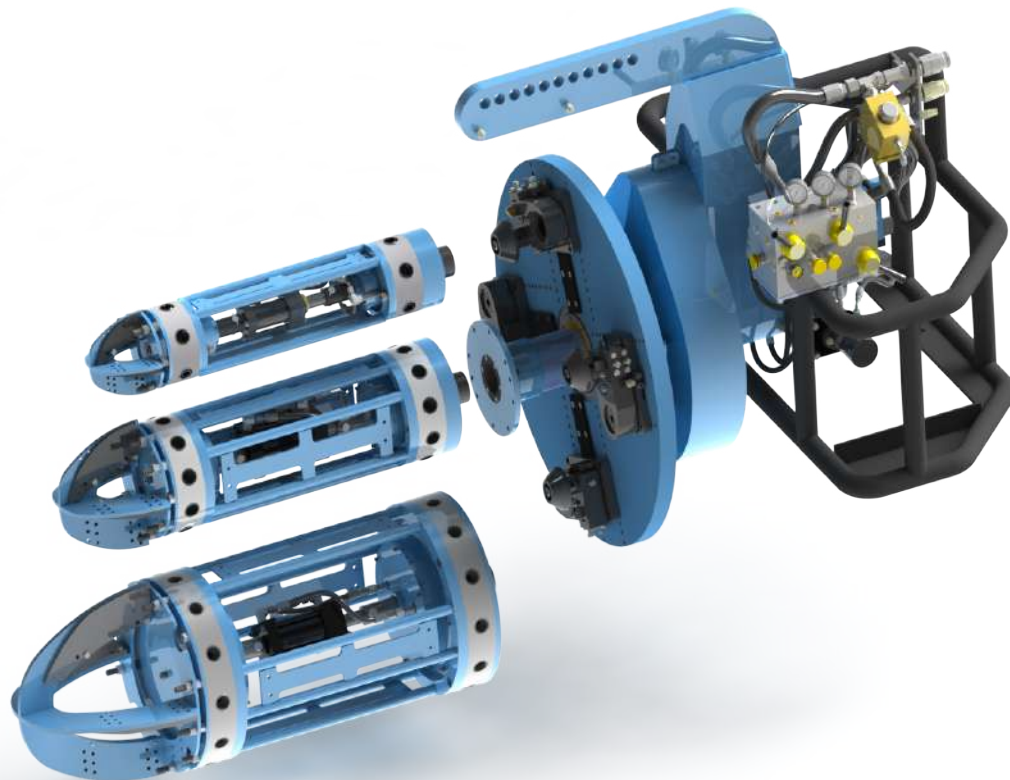
**Increased  
Safety**



**Consistent  
Quality**



**Easily  
Adjustable**



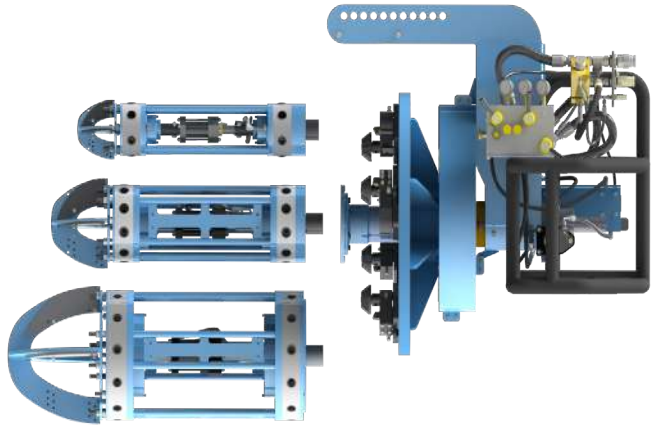
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## Pipe Facing Machine Highlights

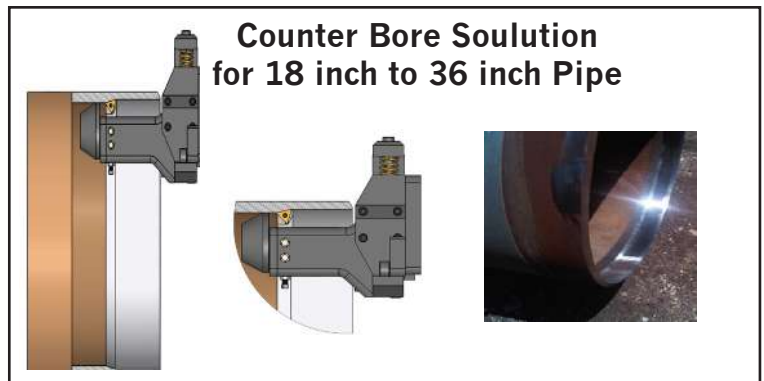
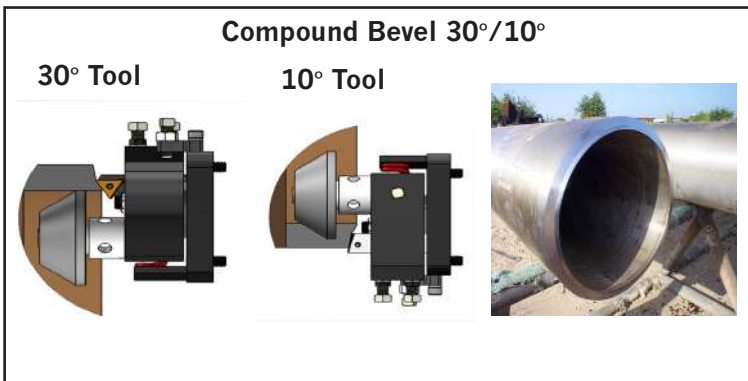
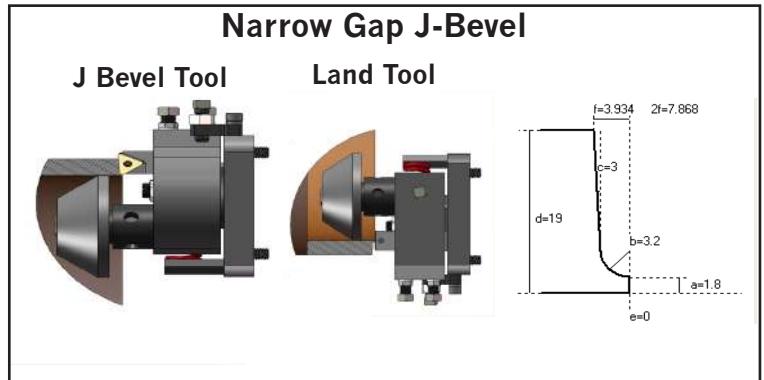
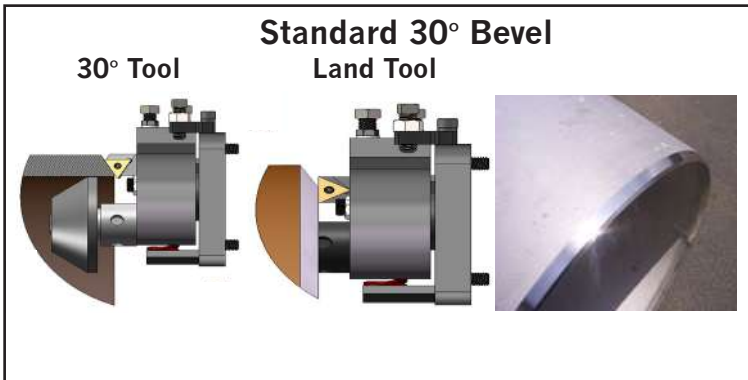
Quickly Adjustable from 12" through 36"  
 Repetitive, Concise Bevels  
 Easily sets up to any bevel configuration  
 (stick electrode including modified "J" bevel,  
 automatic welding bevel and transition  
 bevels)  
 Brush Adapters eliminate both internal and  
 external manual buffing, grinding, or sanding  
 Vickers™ Hydraulics  
 Deutz Diesel™ Power Units  
 Toshiba™ Electric Power Units



Diesel or Electric Hydraulic Power Unit

### PFM 1236 Specifications

| Drive Section            | Clamps                          |
|--------------------------|---------------------------------|
| Weight: 2450 lbs/1110 kg | 12" – 18" Clamp : 240 lb/109 kg |
| Length: 108 in/2743 mm   | 16" – 24" Clamp : 420 lb/190 kg |
| Width: 55 in/1219 mm     | 24" – 32" Clamp : 840 lb/381 kg |
| Height: 57 in/1448 mm    |                                 |



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# Hydraulic Pipe Facing Machine

## Model: PFM 3656



### Quick Specs

**Pipe Facing/  
Beveling Applications**  
Pipelines  
Cross-country  
Offshore  
Shop and Field  
Fabrication

Pipe Range 36" to 56" in 2 Clamp Sections  
Up to 2" Wall Thickness Available  
Factory Bevel, J Bevel, and Compound Bevel  
High Speed Bevel Cutting  
Hydraulically Powered Rotation and Feed Rate  
Counterboring Solutions Available  
Easy to Set-up, Compact, and Portable  
Diesel or Electric Hydraulic Power Unit



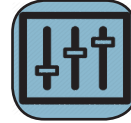
**Increases  
Productivity**



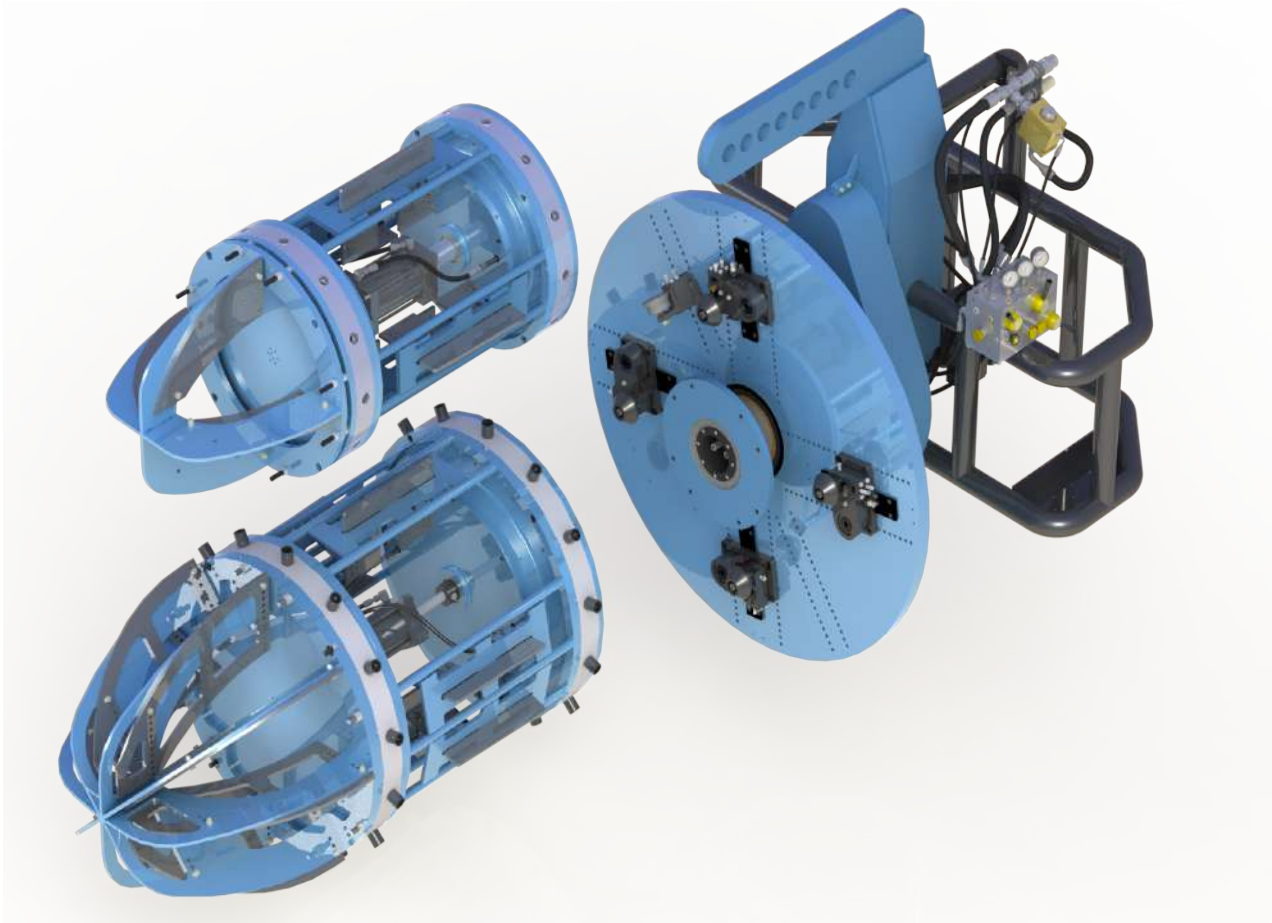
**Increased  
Safety**



**Consistent  
Quality**



**Easily  
Adjustable**

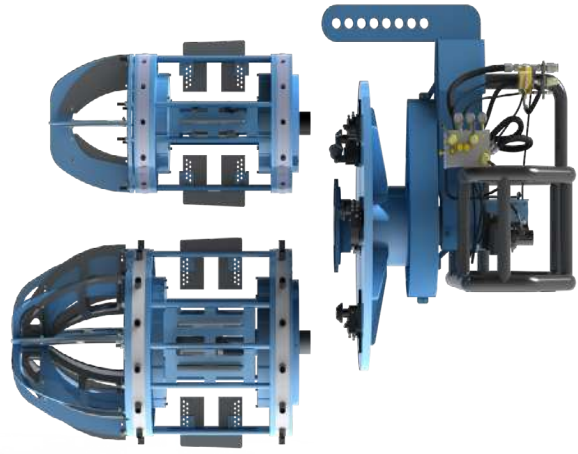


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## Pipe Facing Machine Highlights

Quickly Adjustable from 36" through 56"  
 Repetitive, Concise Bevels  
 Easily sets up to any bevel configuration  
 (stick electrode including modified "J" bevel,  
 automatic welding bevel and transition bevels)  
 Brush Adapters eliminate both internal and  
 external manual buffing, grinding, or sanding  
 Vickers™ Hydraulics  
 Deutz Diesel™ Power Units  
 Toshiba™ Electric Power Units



Diesel or Electric Hydraulic Power Unit

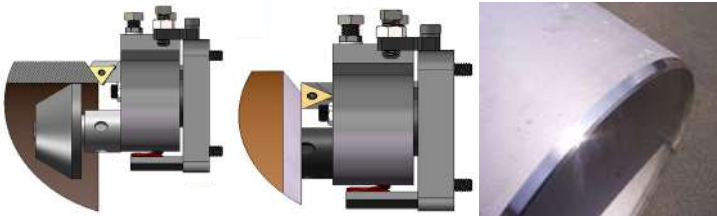
### PFM 3656 Specifications

| Drive Section            | Clamps                          |
|--------------------------|---------------------------------|
| Weight: 8450 lbs/3840 kg | 36" – 48" Clamp :1200 lb/545 kg |
| Length: 120 in/3048 mm   | 48" – 56" Clamp :1800 lb/818 kg |
| Width: 70 in/1778 mm     |                                 |
| Height: 80 in/2032 mm    |                                 |

### Standard 30° Bevel

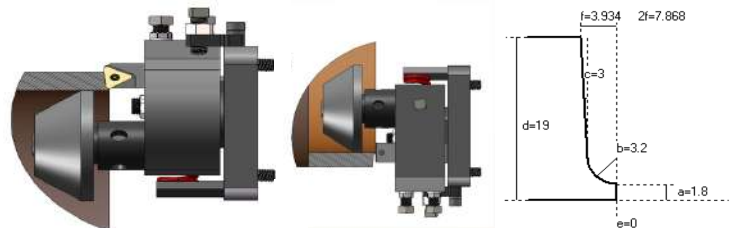
30° Tool

Land Tool



### Narrow Gap J-Bevel

Land Tool



### Compound Bevel 30°/10°

30° Tool

10° Tool



### Counter Bore Solution for 36 inch to 56 inch Pipe



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# Hydraulic Pipe Facing Machine

## Models: PFM 2436 and PFM 3648

### For Segmented Pipe Fittings



#### Quick Specs

Pipe Facing/  
Beveling Applications  
Pipelines  
Cross-country  
Shop and Field

Pipe Range 24" to 36" and 36" to 48"  
Up to 1.5" Wall Thickness Available  
Factory Bevel, Compound Bevel, Inside and  
Outside Diameter Chamfer, and Counter-bore  
Options Available  
High Speed Bevel Cutting  
Hydraulically Powered Rotation and Feed Rate  
Easy to Set-up, Compact, and Portable



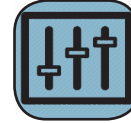
Increases  
Productivity



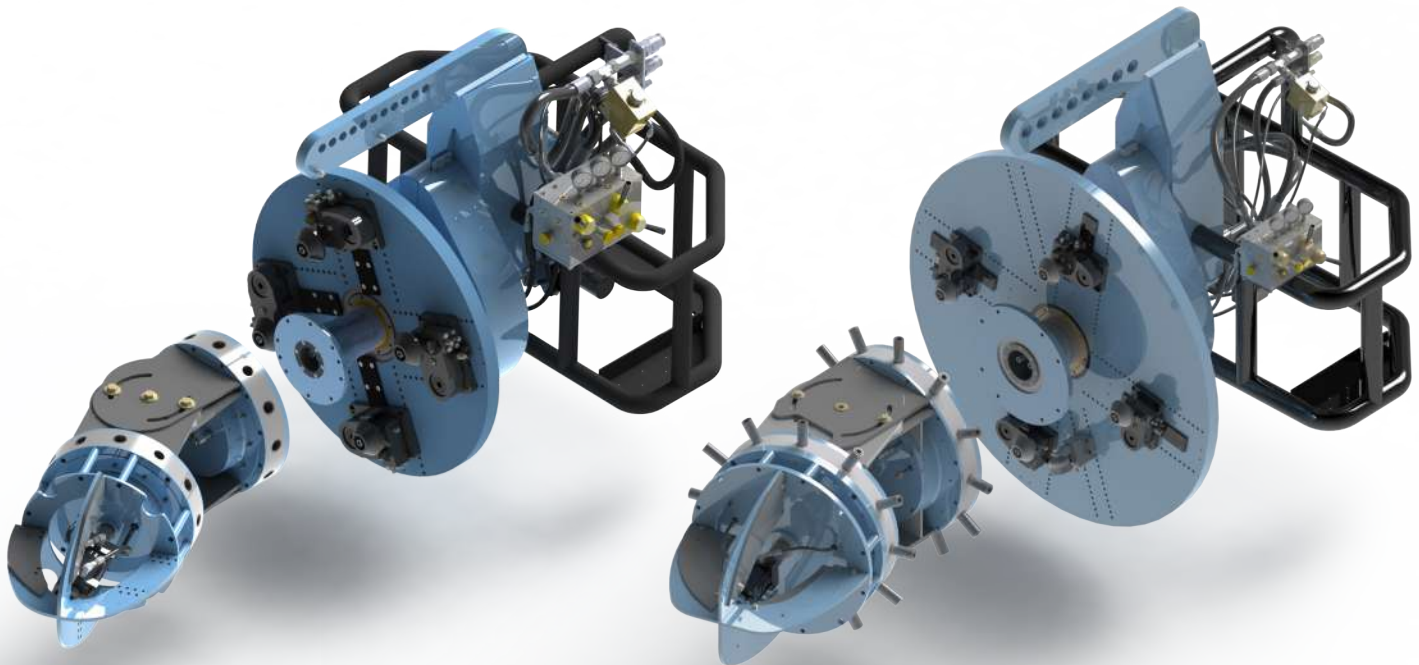
Increased  
Safety



Consistent  
Quality



Easily  
Adjustable



**FOR SEGMENTED FITTINGS - WITH ARTICULATING CLAMP**

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## Pipe Facing Machine Highlights

Quickly Adjustable from 24" to 36" and 36" to 48"  
Repetitive setup on common segmented fitting applications

Easily setup to Factory bevel profiles

Brush Adapters eliminate both internal and external manual buffing, grinding, or sanding

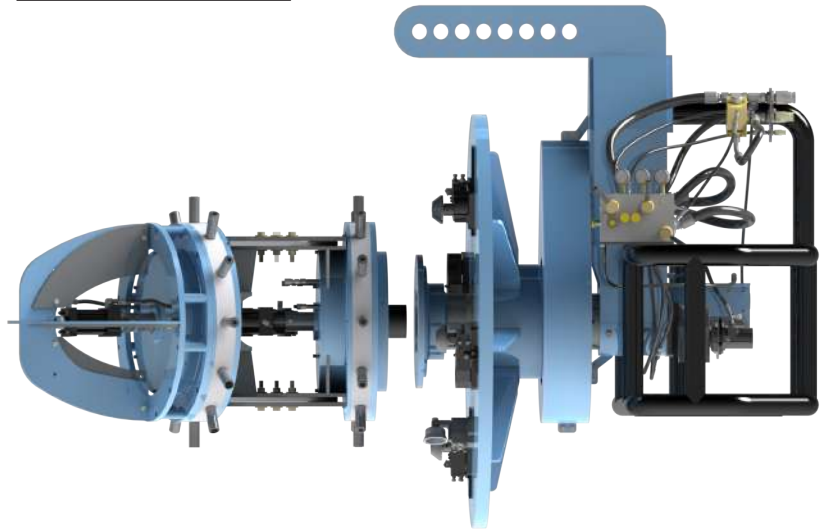
Vickers™ Hydraulics

Deutz Diesel™ Power Units

Toshiba™ Electric Power Units

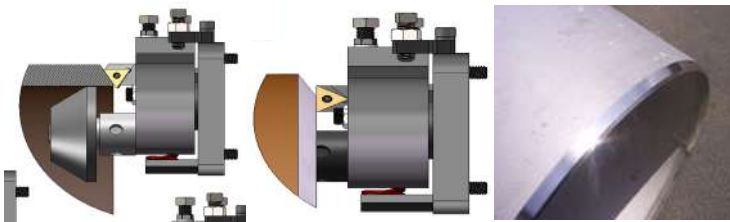
## PFM Specifications

|          |          |
|----------|----------|
| 24 to 36 | 3800 lbs |
| 36 to 48 | 8500 lbs |



30° Tool

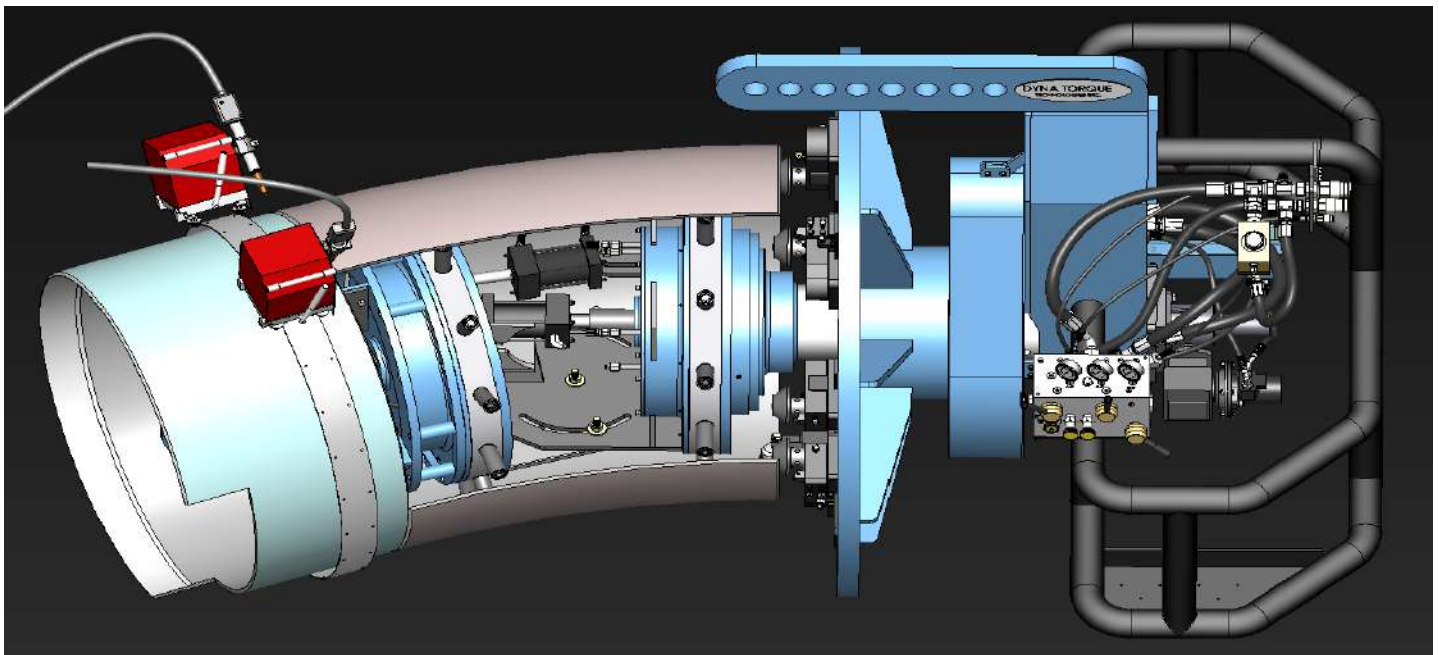
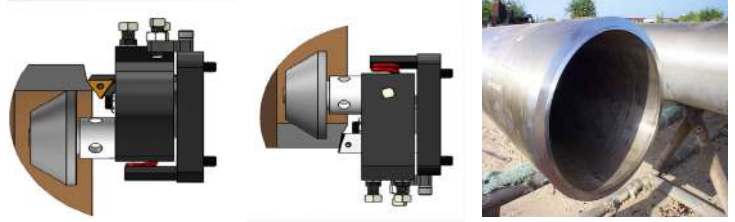
### Standard 30° Bevel Land Tool



30° Tool

### Compound Bevel 30°/10°

10° Tool



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# Hydraulic Power Pack for Pipe Facing Machines



## Quick Specs

**Pipe Facing/  
Beveling Applications**  
Pipelines  
Cross-country  
Offshore  
Shop and Field  
Fabrication

**Deutz Diesel™ Power Units**  
**Toshiba™ Electric Power Units**



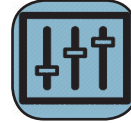
**Increases  
Productivity**



**Increased  
Safety**



**Consistent  
Quality**



**Easily  
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## Hydraulic Power Pack Highlights

Deutz Diesel™ Power Units  
Toshiba™ Electric Power Units



| Electric Power Unit |         |         |
|---------------------|---------|---------|
| Length              | 106 in  | 2692 mm |
| Width               | 43 in   | 1092 mm |
| Height              | 70 in   | 1778 mm |
| Dry Weight          | 2750 lb | 1246 kg |
| Wet Weight          | 3750 lb | 1699 kg |
| Voltage             | 240/480 | 240/480 |
| Frequency           | 60 Hz   | 60 Hz   |
| Full Load Amps      | 89 A    | 89 A    |
| Start Up Amps       | 150 A   | 150 A   |

| Diesel Power Unit        |         |         |
|--------------------------|---------|---------|
| Length                   | 106 in  | 2692 mm |
| Width                    | 43 in   | 1092 mm |
| Height                   | 70 in   | 1778 mm |
| Dry Weight               | 2900 lb | 1314 kg |
| Wet Weight               | 4700 lb | 2129 kg |
| Diesel Fuel Capacity     | 105 gal | 397 l   |
| Hydraulic Fluid Capacity | 105 gal | 397 l   |
| Diesel Consumption       | gal/hr  | l/hr    |
| Engine Horsepower        | 75 hp   | 1905 kW |



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# Internal Pneumatic Lineup Clamp



## Quick Specs

### Pipe Welding Applications

Pipelines  
Cross-country  
Offshore  
Shop and Field  
Fabrication

Available in Sizes 6'' – 60''  
Powered Travel Drive Available on Models 12'' – 60''  
Available with Copper Backing  
Each Unit Covers Two Pipe Sizes  
Available for Cross-country, Offshore, Double  
Joining, and Spool Based Operations



Decreases  
Weld Set-up Time



Increased  
Safety



Consistent  
Operation



Easily  
Adjustable



**D**yna Torque's Internal Lineup Clamps are the most versatile and user friendly clamps on the market today. Years of experience and the highest quality components are incorporated into every unit.

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<https://youtube.com/user/dynatorqueinc>



## IPLC Specifications Non Self-Propelled (Pull Type) Available with Copper Backing

| Model     | Pipe Size |         | Length |      | Width |     | Height |     | Weight |     |
|-----------|-----------|---------|--------|------|-------|-----|--------|-----|--------|-----|
|           | in        | mm      | in     | mm   | in    | mm  | in     | mm  | lbs    | kg  |
| IPLC6 AWT | 6         | 164     | 42     | 1067 | 5.5   | 139 | 7      | 177 | 98     | 44  |
| IPLC6     | 6         | 164     | 42     | 1067 | 5.5   | 139 | 7      | 177 | 98     | 44  |
| IPLC8     | 8         | 219     | 47     | 1194 | 7.5   | 190 | 9      | 229 | 120    | 54  |
| IPLC10    | 10        | 273     | 57     | 1448 | 9.25  | 235 | 10.5   | 267 | 175    | 79  |
| IPLC12-14 | 12-14     | 324-356 | 58     | 1473 | 12.5  | 318 | 14     | 356 | 225    | 102 |

## IPLC Specifications Self-Propelled (Line Travel) Available with Copper Backing

| Model     | Pipe Size |            | Length |      | Width |      | Height |      | Weight |      |
|-----------|-----------|------------|--------|------|-------|------|--------|------|--------|------|
|           | in        | mm         | in     | mm   | in    | mm   | in     | mm   | lbs    | kg   |
| IPLC10    | 10        | 273        | 62     | 1575 | 10    | 254  | 11.5   | 292  | 300    | 136  |
| IPLC12-14 | 12-14     | 324-356    | 90     | 2286 | 12    | 305  | 13.5   | 343  | 355    | 161  |
| IPLC16-18 | 16-18     | 406-457    | 115    | 2921 | 16    | 406  | 17.5   | 445  | 552    | 250  |
| IPLC20-22 | 20-22     | 508-559    | 115    | 2921 | 17    | 431  | 18.5   | 470  | 590    | 284  |
| IPLC24-26 | 24-26     | 610-660    | 115    | 2921 | 18.5  | 469  | 20     | 508  | 925    | 420  |
| IPLC28-30 | 28-30     | 711-762    | 104    | 2641 | 24    | 610  | 25.5   | 648  | 1230   | 558  |
| IPLC32-34 | 32-34     | 812-863    | 120*   | 3048 | 28*   | 711  | 31*    | 787  | 1500*  | 681  |
| IPLC36-38 | 36-38     | 914-965    | 128    | 2670 | 36    | 914  | 37.5   | 953  | 1750   | 794  |
| IPLC40-42 | 40-42     | 1016-1067  | 144    | 3658 | 40    | 1016 | 41.5   | 1054 | 2480   | 1125 |
| IPLC44-46 | 44-46     | 1118 -1168 | 164    | 4699 | 44    | 1117 | 45*    | 1143 | 2950*  | 1340 |
| IPLC48-50 | 48-50     | 1220-1270  | 180    | 4826 | 48    | 1219 | 47.5*  | 1206 | 3400*  | 1545 |

### Distinguishing Features

Available in sizes 6" – 60"  
 Clamps 12" – 60" cover two pipe sizes by use of conversion kits  
 Standard clamps are adjustable up to .500 wall thickness  
 Modified clamps are available for heavier wall pipe  
 Powered travel drive available on models 12" – 60"  
 For efficient operation, the compressed air pressure should be  
 180 – 200 PSi (12.4 – 13.8 Bar) at 40 CFM  
 Maximum safe working pressure is 225 PSI (15.5 Bar)

### Both Non Self-Propelled and Self-Propelled Clamps Require Compressed Air

For sizes 6 through 18 non self-propelled (pull type)  
 require a 25CFM compressor  
 For sizes 10 through 36 self-propelled clamps require a  
 40CFM compressor  
 For sizes 36 through 60 self - propelled clamps require a  
 90 CFM compressor  
 All self - propelled clamps have a 25 degree grade  
 capability

### Additional Cost Features

|                                    |                                    |
|------------------------------------|------------------------------------|
| Dual side drive of 35 degree grade | Cement mortar lining compatibility |
| Additional reach rod               | Vertical operation facility        |
| Stainless steel pipe compatibility | De-icers                           |
| Storage skid                       |                                    |



# Manual & Hydraulic External Lineup Clamps: Standard and No-Tack

## Quick Specs

### Pipe Welding Applications

Pipelines  
Cross-country  
Offshore  
Shop and Field  
Fabrication

### Manual/ Raychet Line-up Clamps

Precision Acme threads assure strength and ease of operation

### Hydraulic Internal Line Up Clamp

Has all the advantages of the manual, plus hydraulic power



Decreases  
Weld Set-up Time



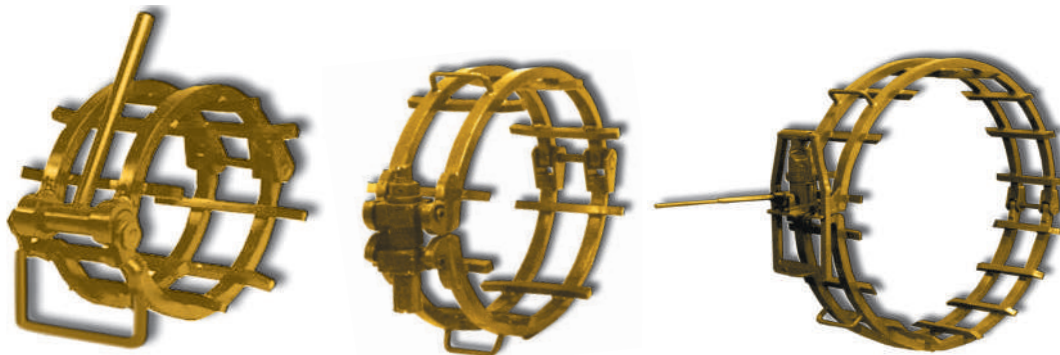
Increased  
Safety



Consistent  
Operation



Wide  
Range



## Manual/ Raychet Line-up Clamps

Precision Acme threads assure strength and ease of operation.

Standard 1" ratchet handle fits all sizes.

Mechanism is enclosed to eliminate dirt and mud.

Will not back off while weld is being made.

No-Tack type has arched cross-beams to permit continuous welding without removing the clamp.

Heavy duty all steel construction.

## Hydraulic Internal Line-Up Clamp

Accurately aligns in minutes.

Hinged open wide for easy mounting, use, or removal.

Circle secured by single master pin.

Bridging allows full 360° welding without removing clamp.

Available in sizes from 16" to 60"

Heavy duty all steel construction

Precision Manufactured, field proven.

**Dyna Torque Technologies Inc.**  
11050 W. Little York Rd, Bldg F  
Houston, Texas 77041 USA  
+1 713 937 6699

[www.dyna-torque.com](http://www.dyna-torque.com)  
<https://youtube.com/user/dynatorqueinc>

## EXTERNAL LINE-UP CLAMP SPECIFICATIONS

### Standard

|      |                 |          |
|------|-----------------|----------|
| 2"   | 8 X 8 x 11"     | 12 lbs.  |
| 2.5" | 11 x 8 x 11"    | 17 lbs.  |
| 3"   | 11 x 8 x 11"    | 17 lbs.  |
| 3.5" | 11 x 8 x 11"    | 19 lbs.  |
| 4"   | 11 x 8 x 11"    | 19 lbs.  |
| 5"   | 16 x 9 x 11"    | 32 lbs.  |
| 6"   | 16 x 11 x 11"   | 32 lbs.  |
| 8"   | 16 x 13 x 11"   | 33 lbs.  |
| 10"  | 17 x 14 x 11"   | 51 lbs.  |
| 12"  | 20 x 16 x 11"   | 53 lbs.  |
| 14"  | 21 x 17 x 11"   | 70 lbs.  |
| 16"  | 24 x 22 x 11"   | 102 lbs. |
| 18"  | 26 x 22 x 11"   | 110 lbs. |
| 20"  | 28 x 24 x 11"   | 120 lbs. |
| 22"  | 29 x 25 x 11"   | 125 lbs. |
| 24"  | 32 x 28 x 11"   | 126 lbs. |
| 26"  | 35 x 29 x 11"   | 130 lbs. |
| 30"  | 39 x 33 x 11"   | 160 lbs. |
| 32"  | 40 x 36 x 11"   | 168 lbs. |
| 34"  | 42 x 38 x 11"   | 174 lbs. |
| 36"  | 44 x 39 x 11"   | 180 lbs. |
| 38"  | 47 x 43 x 13.5" | 255 lbs. |
| 40"  | 49 x 45 x 13.5" | 298 lbs. |
| 42"  | 51 x 47 x 13.5" | 308 lbs. |
| 48"  | 57 x 53 x 13.5" | 348 lbs. |
| 54"  | 63 x 59 x 13.5" | 395 lbs. |
| 60"  | 69 x 65 x 13.5" | 445 lbs. |

### Standard Ratchet

|     |               |          |
|-----|---------------|----------|
| 14" | 22 x 17 x 11" | 80 lbs.  |
| 16" | 25 x 22 x 11" | 106 lbs. |
| 18" | 27 x 22 x 11" | 110 lbs. |
| 20" | 29 x 24 x 11" | 118 lbs. |
| 22" | 31 x 25 x 11" | 125 lbs. |
| 24" | 33 x 28 x 11" | 128 lbs. |
| 26" | 36 x 29 x 11" | 140 lbs. |
| 30" | 40 x 33 x 11" | 151 lbs. |
| 32" | 41 x 36 x 11" | 162 lbs. |
| 34" | 43 x 38 x 11" | 169 lbs. |
| 36" | 45 x 39 x 11" | 172 lbs. |
| 38" | 48 x 43 x 11" | 255 lbs. |
| 40" | 50 x 45 x 11" | 268 lbs. |
| 42" | 52 x 47 x 11" | 275 lbs. |
| 48" | 58 x 53 x 11" | 300 lbs. |
| 54" | 64 x 59 x 11" | 331 lbs. |
| 56" | 66 x 63 x 11" | 356 lbs. |
| 60" | 69 x 65 x 11" | 372 lbs. |

### Hydraulic

|     |               |          |
|-----|---------------|----------|
| 16" | 24 x 24 x 11" | 125 lbs. |
| 18" | 26 x 26 x 11" | 130 lbs. |
| 20" | 28 x 28 x 11" | 138 lbs. |
| 22" | 30 x 30 x 11" | 140 lbs. |
| 24" | 32 x 32 x 11" | 148 lbs. |
| 26" | 34 x 34 x 11" | 150 lbs. |
| 30" | 40 x 40 x 11" | 165 lbs. |
| 32" | 42 x 42 x 11" | 175 lbs. |
| 34" | 44 x 44 x 11" | 190 lbs. |
| 36" | 48 x 44 x 11" | 192 lbs. |
| 38" | 52 x 44 x 11" | 265 lbs. |
| 40" | 52 x 44 x 11" | 295 lbs. |
| 42" | 52 x 50 x 12" | 320 lbs. |
| 48" | 60 x 56 x 12" | 344 lbs. |
| 54" | 66 x 60 x 12" | 380 lbs. |
| 56" | 68 x 62 x 12" | 412 lbs. |
| 60" | 72 x 64 x 14" | 445 lbs. |

### Standard No-Tack

|     |                 |          |
|-----|-----------------|----------|
| 8"  | 16 x 15 x 11"   | 32 lbs.  |
| 10" | 17 x 16 x 11"   | 51 lbs.  |
| 12" | 20 x 18 x 11"   | 54 lbs.  |
| 14" | 21 x 19 x 11"   | 66 lbs.  |
| 16" | 24 x 20 x 11"   | 102 lbs. |
| 18" | 26 x 23 x 11"   | 107 lbs. |
| 20" | 28 x 26 x 11"   | 117 lbs. |
| 22" | 29 x 27 x 11"   | 124 lbs. |
| 24" | 32 x 30 x 11"   | 128 lbs. |
| 26" | 35 x 31 x 11"   | 136 lbs. |
| 30" | 39 x 35 x 11"   | 195 lbs. |
| 32" | 40 x 38 x 11"   | 206 lbs. |
| 34" | 42 x 40 x 11"   | 213 lbs. |
| 36" | 44 x 41 x 11"   | 227 lbs. |
| 38" | 47 x 45 x 13.5" | 238 lbs. |
| 40" | 49 x 47 x 13.5" | 262 lbs. |
| 42" | 51 x 49 x 13.5" | 280 lbs. |
| 48" | 57 x 55 x 13.5" | 338 lbs. |
| 54" | 65 x 61 x 13.5" | 350 lbs. |
| 60" | 69 x 67 x 13.5" | 377 lbs. |

### Standard Ratchet No-Tack

|     |                 |          |
|-----|-----------------|----------|
| 14" | 22 x 19 x 11"   | 70 lbs.  |
| 16" | 25 x 20 x 11"   | 102 lbs. |
| 18" | 27 x 23 x 11"   | 106 lbs. |
| 20" | 29 x 26 x 11"   | 111 lbs. |
| 22" | 31 x 27 x 11"   | 125 lbs. |
| 24" | 33 x 30 x 11"   | 122 lbs. |
| 26" | 36 x 31 x 11"   | 138 lbs. |
| 30" | 40 x 35 x 11"   | 160 lbs. |
| 32" | 41 x 38 x 11"   | 174 lbs. |
| 34" | 43 x 40 x 11"   | 179 lbs. |
| 36" | 45 x 41 x 11"   | 165 lbs. |
| 38" | 48 x 45 x 13.5" | 255 lbs. |
| 40" | 50 x 47 x 13.5" | 298 lbs. |
| 42" | 52 x 49 x 13.5" | 308 lbs. |
| 48" | 58 x 55 x 13.5" | 330 lbs. |
| 54" | 64 x 59 x 13.5" | 340 lbs. |
| 56" | 66 x 61 x 13.5" | 356 lbs. |
| 60" | 69 x 67 x 13.5" | 370 lbs. |

### Hydraulic No-Tack

|     |               |          |
|-----|---------------|----------|
| 16" | 25 x 25 x 11" | 124 lbs. |
| 18" | 28 x 28 x 11" | 127 lbs. |
| 20" | 30 x 30 x 11" | 136 lbs. |
| 22" | 32 x 32 x 11" | 142 lbs. |
| 24" | 34 x 34 x 11" | 149 lbs. |
| 26" | 36 x 36 x 11" | 157 lbs. |
| 30" | 42 x 42 x 11" | 166 lbs. |
| 32" | 42 x 42 x 11" | 177 lbs. |
| 34" | 46 x 44 x 11" | 186 lbs. |
| 36" | 48 x 44 x 11" | 240 lbs. |
| 38" | 50 x 44 x 11" | 244 lbs. |
| 40" | 54 x 56 x 11" | 280 lbs. |
| 42" | 56 x 50 x 12" | 300 lbs. |
| 48" | 64 x 58 x 12" | 325 lbs. |
| 54" | 68 x 62 x 12" | 345 lbs. |
| 56" | 70 x 64 x 12" | 365 lbs. |
| 60" | 76 x 68 x 14" | 375 lbs. |

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# Manual & Hydraulic Internal Lineup Clamps

|                    |   |  |
|--------------------|---|--|
| <b>Quick Specs</b> | <b>Pipe Welding Applications</b>  | <b>Manual Internal Line Up clamp Model 241</b>   |
|                    | Pipelines<br>Cross-country<br>Offshore<br>Shop and Field<br>Fabrication | <b>Fastest Most reliable clamp in the field</b><br><b>Hydraulic Internal Line Up Clamp</b><br>Has all the advantages of the manual, plus hydraulic power |



**Decreases Weld Set-up Time**



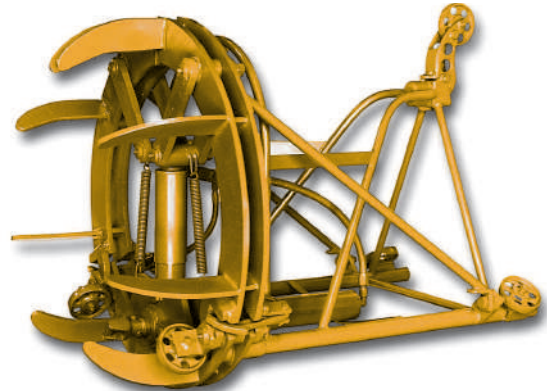
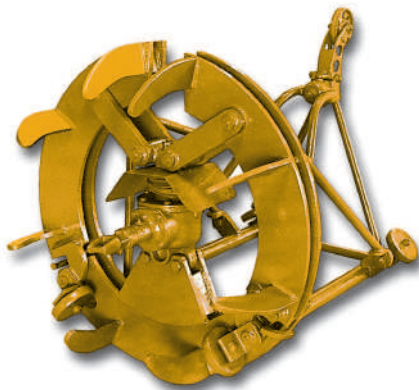
**Increased Safety**



**Consistent Operation**



**Easily Adjustable**



**Manual Internal Line up Clamp Model 241**

Toggle action puts maximum power on the pipe  
 "Gap" is unobstructed for fuller stringer bead  
 Heavy duty jack box puts more power on the pipe with less operator effort  
 Each clamp machine for specific pipe I.D.  
 Heavy duty all steel construction.

**Hydraulic Internal Line Up Clamp Model 245**

Easy to operate.  
 Requires no outside power unit.  
 Precision manufactured, field proven.  
 Standard through 52"

| SIZE | CUBE* | LB. WEIGHT* |
|------|-------|-------------|
| 10"  | 3     | 163         |
| 12"  | 4     | 195         |
| 14"  | 5     | 210         |
| 16"  | 6     | 242         |
| 18"  | 7     | 268         |
| 20"  | 9     | 283         |

**SPECIFICATIONS  
Manuals and  
Hydraulic Models**

| SIZE | CUBE* | LB. WEIGHT* |
|------|-------|-------------|
| 22"  | 12    | 301         |
| 24"  | 17    | 339         |
| 26"  | 21    | 360         |
| 30"  | 32    | 420         |
| 34"  | 44    | 522         |
| 36"  | 50    | 595         |

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# Pipe Demagnetization System



## Quick Specs

**Pipe Welding Applications**  
Pipelines  
Cross-country  
Offshore  
Shop and Field  
Fabrication

Easy to use  
Remote pendant control with gauss meter  
Mobile  
Efficient and Repetitive (manual and auto modes)  
Timing and current can be adjusted for each application



Decreases  
Weld Set-up Time



Increased  
Safety



Consistent  
Operation



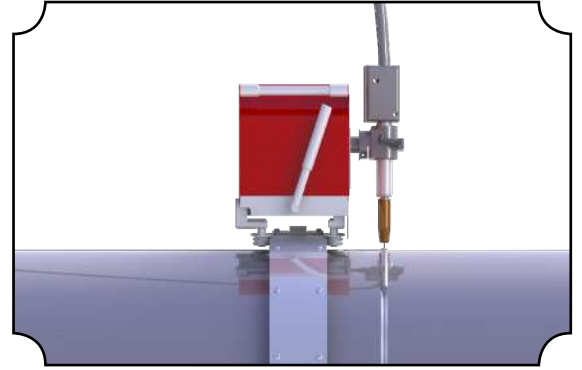
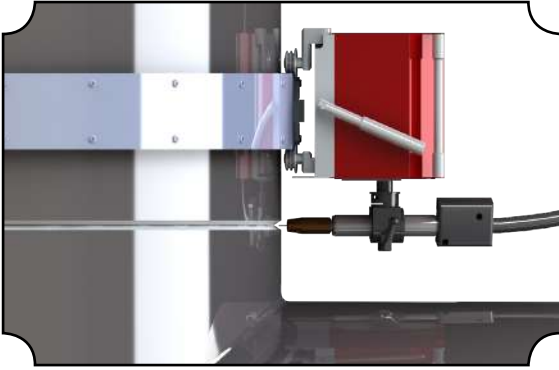
Easily  
Adjustable



Pipe Demagnetization system (Demag) is a smart system used to cancel magnetization in pipe primarily for the purpose of welding two joints together

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