

SUMNER

Welding Make-up Tools










At Sumner, our welding customers are very important people. One of our primary goals as a manufacturer is to provide our customers with high quality, competitively priced tools. But welders are not only customers—we learn from the welder in the field what products are needed to make their jobs easier. These ideas help us to design and build new and better products. In essence, our customers are part of our Research and Development Department and without your input, Sumner would be unable to continually offer great new products.

Another important part of Sumner philosophy is our commitment to safety. All Sumner employees are dedicated to the safety of the individuals who use our products. We understand that price is always a concern to our users, but we will never sacrifice quality or safety just to save costs. We know the demands expected of all Sumner products, and each is built for years of use. It could be said that Sumner tools are built the way the welder would make them. As a result, Sumner tools are not only considered the best in the market, but the most reliable tool to get the job done efficiently and safely.

Thank you for buying Sumner products!

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Pipe Jacks

SUMNER

Heavy Duty Jacks



Special features:

- ✓ 2,500 lb (1,135 kg) capacity
- ✓ Strut tension plate for superior lateral support
- ✓ 1" (2.5 cm) square tube base construction
- ✓ Built for heavy use & abuse

Hi Heavy Duty Jack
28"-49" (71-125 cm)



Lo Heavy Duty Jack
21"-36" (51-89 cm)

Heavy Duty Jack Plus



- ✓ 3,500 lb (1,580 kg) capacity
- ✓ Rib-supported vee head prevents "pancaking"
- ✓ Strut tension plate for superior lateral support
- ✓ 1" (2.5 cm) square tube base construction



Heavy Duty Jack replacement legs for easy repair
(PN 780675-KD)

Standard Features on all Sumner Jacks:

- ✓ 1-1/2" (38 mm) Acme fine adjustment thread — the largest in the industry
- ✓ Large, convenient adjustment handle
- ✓ CE rated
- ✓ Quick-action lock washer
- ✓ Patented Fall Guard®
- ✓ Set screw can lock jack head to stand — no loose pieces
- ✓ Jack independently load tested for quality assurance
- ✓ Backed by over forty years of jack stand manufacturing experience



Pro Jack®

Special features:

- ✓ Formed steel legs
- ✓ 2,000 lb (900 kg) capacity
- ✓ Priced for all budgets
- ✓ Strut tension plate for superior lateral support



Hi Pro Jack
28"-49" (71-125 cm)



Hi Fold-A-Jack®
28"-49" (71-125 cm)

Fold-A-Jack®

Special features:

- ✓ 2,500 lb (1,135 kg) capacity
- ✓ Folds up for storage ease
- ✓ 1" (2.5 cm) square tube base construction
- ✓ Convenient carrying handle

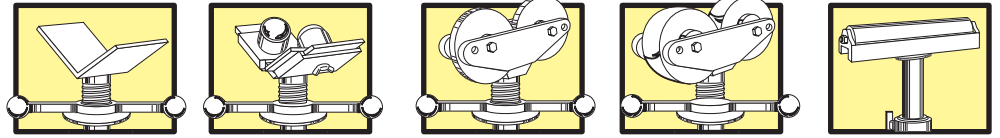


Lo Fold-A-Jack®
21"-36" (51-89 cm)



Patented

Sumner offers a choice of 5 head styles for every application:



Model	Standard Vee Head	Ball Transfer Head	Steel Wheel Head	Rubber Wheel Head	Bar Stock Head
Part Number (carbon steel)	780518	780518 & 780551	780514	780499	780519 (Hi) 780944 (Lo)
Part Number (stainless steel)	780498	780518 & 780274	780517	N/A	N/A
Pro Jack Capacity	2,000 lb 900 kg	1,000 lb 450 kg	2,000 lb 900 kg	1,000 lb 450 kg	2,000 lb 900 kg
Heavy Duty Jack & Fold-A-Jack Capacity	2,500 lb 1,135 kg				
Pipe size (min - max)	1/8" - 24" 3-600 mm	3/8" - 12" 10-300 mm	1-1/4" - 24" 30-600 mm	1-1/2" - 24" 40-600 mm	1/8" - 10" (Flat) 3-250 mm
Application	General welding of pipe shapes, solids and rounds	Rotation of pipe or tubing in all directions	Welding of pipe and rounds	Non-marring surface, roll welding of pipes and rounds	Welding of flats and shapes

Stainless Steel Vee Head Attachment PN 780502

Fits over vee and secures with two bolts - no tools required!



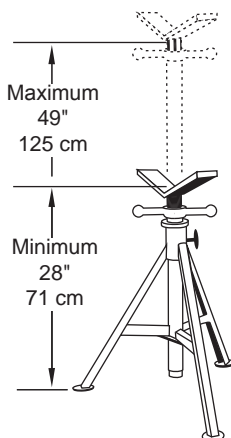
Standard Vee Head Ball Transfer Set

PN 780551 (carbon steel)
PN 780274 (stainless steel)

Attachments slide over standard vee head. Accommodates 3/8"-12" (10-300 mm) pipe sizes. 1,000 lb (450 kg) capacity.

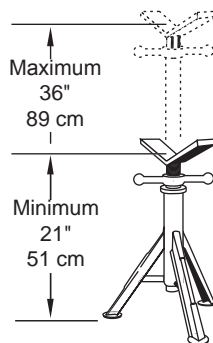


Hi Jack Height Range



Hi Jacks for perfect work height on shapes or pipe

Lo Jack Height Range



Lo Jacks for larger shapes or pipe

Hold-Down Device



Similar in operation to a chain vise for pipe, the **Hold-Down Device** uses high tensile strength chain to grip material in any Sumner vee head jack. Ideal for fitting up flanges, fittings or valves, and a must when working with short lengths.

Part No.	Description	Weight	
		lbs	kg
781050	ST-448 Hold-Down Device	6.0	2.7
781056	Chain Extension Kit (12" pipe increments)	4.0	1.8

Part No.	Description	Weight	
		lbs	kg
Hi Heavy Duty Jacks			
780375	ST-801 w/Vee Head	24.0	10.9
780376	ST-802 w/Roller Head	27.0	12.2
780377	ST-803 w/Bar Stock Head	24.0	10.9
780378	ST-804 w/Stainless Steel Rollers	28.0	12.7
780379	ST-805 w/Stainless Steel Vee Head	24.0	10.9
780380	ST-806 w/Ball Transfer Head	27.0	12.2
780381	ST-807 w/Rubber Wheels	26.0	11.8
Heavy Duty Jack Plus (Hi Jack)			
780326	w/Ribbed Vee Head	24.0	10.9
Lo Heavy Duty Jacks			
780385	ST-901 w/Vee Head	19.0	8.6
780386	ST-902 w/Roller Head	22.0	10.0
780387	ST-903 w/Bar Stock Head	18.0	8.2
780388	ST-904 w/Stainless Steel Rollers	22.0	10.0
780389	ST-905 w/Stainless Steel Vee Head	19.0	8.6
780390	ST-906 w/Ball Transfer Head	22.0	10.0
780391	ST-907 w/Rubber Wheels	21.0	9.5

Part No.	Description	Weight	
		lbs	kg
Hi Fold-A-Jacks®			
781300	ST-881 w/Vee Head	25.0	11.3
781301	ST-882 w/Roller Head	28.0	12.7
781302	ST-883 w/Bar Stock Head	25.0	11.4
781303	ST-884 w/Stainless Steel Rollers	29.0	13.1
781304	ST-885 w/Stainless Steel Vee Head	24.0	10.9
781305	ST-886 w/Ball Transfer Head	29.0	13.1
781306	ST-887 w/Rubber Wheels	26.0	11.8
Lo Fold-A-Jacks®			
781310	ST-981 w/Vee Head	21.0	9.5
781311	ST-982 w/Roller Head	24.0	10.9
781313	ST-984 w/Stainless Steel Rollers	24.0	10.9
781314	ST-985 w/Stainless Steel Vee Head	22.0	10.0
781315	ST-986 w/Ball Transfer Head	25.0	11.3
781316	ST-987 w/Rubber Wheels	22.0	10.0
Hi Pro Jacks®			
780471	ST-871 w/Vee Head	23.0	10.4
780472	ST-872 w/Roller Head	26.0	11.8
780473	ST-873 w/Bar Stock Head	23.0	10.4
780474	ST-874 w/Stainless Steel Rollers	26.0	11.8
780475	ST-875 w/Stainless Steel Vee Head	24.0	10.9
780476	ST-876 w/Ball Transfer Head	28.0	12.7
780477	ST-877 w/Rubber Wheels	25.0	11.4

NOTE: Jacks ordered with stainless steel vee heads are shipped with a standard vee head and stainless steel vee head attachment (PN 780502). See page 5 for details on stainless steel vee head attachment.

HOLD-E™ **NEW!**

A Quick, Easy, Safe Clamp For Holding Pipe In Vee Head Jack Stands

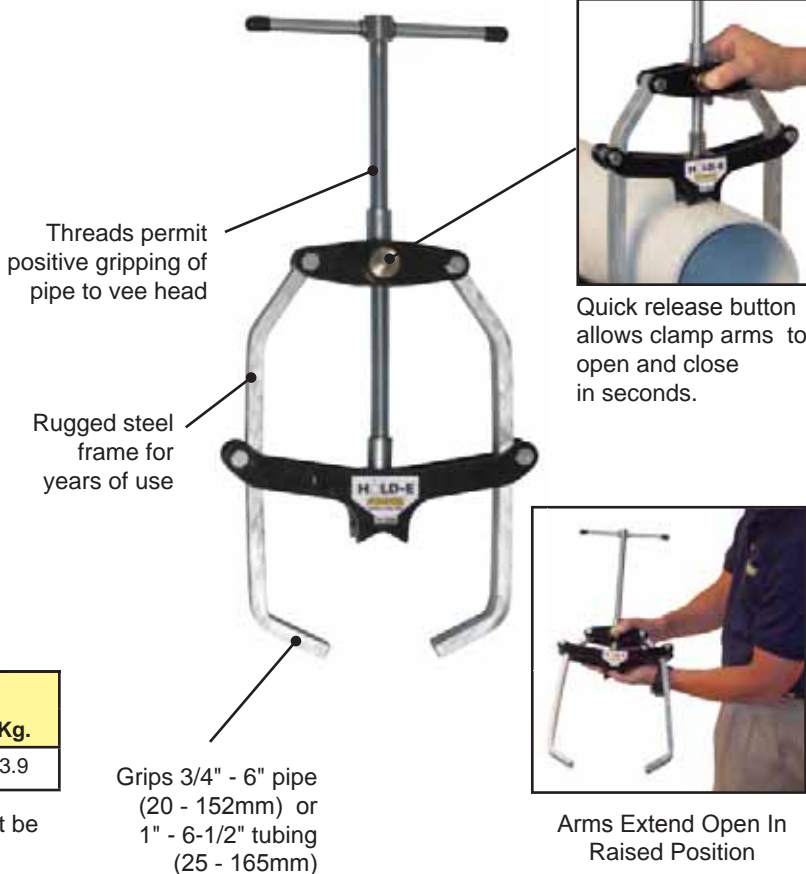


Perfect for securing pipe layout work

US and International Patents Pending

Part No.	Description	Weight	
		Lb.	Kg.
785000	Hold-E Pipe Clamp (3/4" - 6" pipe)	8.7	3.9

CAUTION: Hold-E is a clamping device and should not be used for threading or lifting.



FAT JACK



- ✓ 5,000 lb (2,270 kg) vee head capacity
- ✓ Folding Base
- ✓ 29-1/2" (75 cm) wide base
- ✓ 12-1/2" (32 cm) wide vee head
- ✓ 1-1/4" square tube base construction
- ✓ Ideal for large pipe
- ✓ Height range 38" to 52" (81 to 132 cm)



Roller head available



Fat Jack locking pin



Locking pin holds vee head in place during transport



Larger vee to accommodate larger pipe



Ribbed vee design strengthens vee frame ... no vee head bending or "pancaking"

Part No.	Description	Weight	
		lbs	kg
785200	Fat Jack w/Vee Head & Double Pin	39	17.6
785205	Fat Jack w/ Roller Head & Double Pin	42	19.0



Hi Boy™ JACK STAND

The Hi Boy is a tall jack specifically designed for tight pipe installation, such as in mechanical rooms or tunnels. The Hi Boy is a safe, portable folding stand that is easy to transport and holds a hefty 1,000 pounds (450 kg) at 72" (180 cm). In its lowest position of 39" (98 cm), the Hi Boy is ideal for normal fabrication of weld pipe. Legs fold up for convenient storage in job boxes or truck beds.

39" to 72"
(98-180 cm)
height range!



38" (96 cm) wide base

Part No.	Description	Weight	
		lbs	kg
783250	Hi Boy Jack Stand	45.0	20.4

FAB SAF Jack

Great for Serious Fabrication

Special Features:

- ✓ 3,500 lb (1,580 kg) vee head load capacity
- ✓ 2,500 lb (1,135 kg) roller head load capacity
- ✓ 30" (76 cm) wide base
- ✓ Height range 32" to 52" (81 to 132 cm)
- ✓ Large ribbed vee head to accommodate 36" (900 mm) pipe
- ✓ Quick-Action Lock Washer



Part No.	Description	Weight	
		lbs	kg
780395	FAB SAF Jack	26.0	11.8
780400	FAB SAF Jack w/Roller Head	26.0	11.8

Adjust-A-Rolls®

SUMNER



Hi Adjust-A-Roll
31" (78 cm)

Lo Adjust-A-Roll
24" (61 cm)

Table Adjust-A-Roll

New Adjust-A-Roll feature!
Replacement legs for easy repair
(p/n 780675-KD)

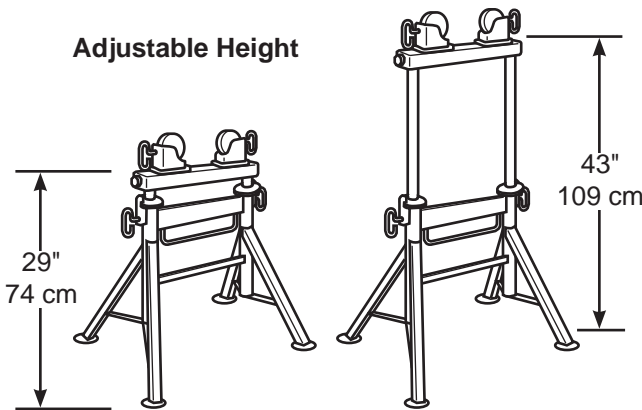


- ✓ Roller adjustment from either side
- ✓ Fast adjustment for easy pipe positioning
- ✓ 1/2" to 36" (12–900 mm), or 2,000 lb (900 kg) pipe capacity
- ✓ Clean and simple design avoids welder interference

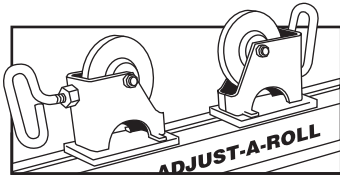
- ✓ Wheels trued for true pipe rotation
- ✓ Bronze bearing to eliminate arcing
- ✓ Brake to lock loads for layout or fit-up
- ✓ Handle large enough to work with gloved hand

Pro Roll™

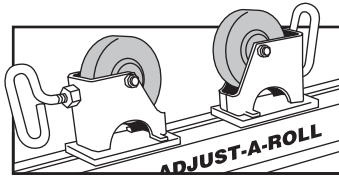
Adjustable Height



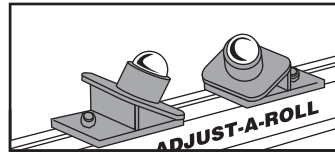
- ✓ More features
- ✓ Adjustable height
- ✓ 1/2" to 36" (1.2–91 cm) or 2,000 lb (900 kg) capacity
- ✓ Leveling on either side of stand
- ✓ Uses Quick Change Housings



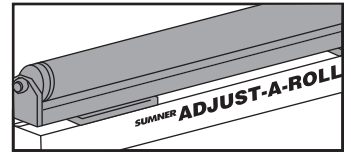
Carbon Steel or Stainless Steel Roller Head
2,000 lb (900 kg) capacity



Rubber Wheel Roller Head
1,200 lb (550 kg) capacity



Ball Transfer Roller Head
1,000 lb (450 kg) capacity
carbon or stainless steel balls



Bar Stock Head
2,000 lb (900 kg) capacity
Two position roller for containment or non-containment of material

- ✓ Wheels "trued" for even pipe rotation
- ✓ Bronze bearings to eliminate arcing
- ✓ Brake to lock loads for layout or fit-up
- ✓ Handles large enough to grip with a gloved hand
- ✓ Quick Change design increases roller stand utility

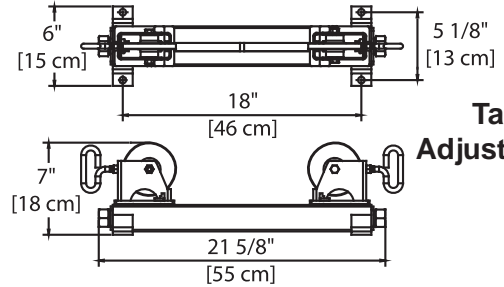


Table Adjust-A-Roll

Hi Adjust-A-Roll

Part No.	Description	Weight	
		lbs	kg
780365	ST-601 with steel wheels	35.0	15.8
780366	ST-602 with ball transfer heads	38.0	17.3
780367	ST-603 with rubber wheels	34.0	15.4
780368	ST-604 with stainless steel wheels	35.0	15.8
780369	ST-605 with bar stock head	39.0	17.6
780399	Hi Adjust-A-Roll [base only]	28.0	12.7

Lo Adjust-A-Roll

Part No.	Description	Weight	
		lbs	kg
780370	ST-701 with steel wheels	34.0	15.4
780371	ST-702 with ball transfer heads	24.0	10.9
780372	ST-703 with rubber wheels	32.0	14.5
780373	ST-704 with stainless steel wheels	34.0	15.4
780359	ST-705 with bar stock head	37.0	16.8
780405	Lo Adjust-A-Roll [base only]	26.0	11.8

Table Adjust-A-Roll

Part No.	Description	Weight	
		lbs	kg
780360	ST-501 with steel wheels	22.0	10.0
780361	ST-502 with ball transfer heads	22.0	10.0
780362	ST-503 with rubber wheels	20.0	9.0
780363	ST-504 with stainless steel wheels	22.0	10.0
780364	ST-505 with bar stock head	24.0	10.9
780500	Table Adjust-A-Roll [base only]	13.0	5.9

Pro Roll

Part No.	Description	Weight	
		lbs	kg
780440	Pro Roll [base only]	38.0	17.2
780441	Pro Roll with steel wheels	47.0	21.3
780442	Pro Roll with ball transfer heads	49.0	22.2
780443	Pro Roll with rubber wheels	45.0	20.4
780444	Pro Roll with stainless steel wheels	47.0	21.3
780446	Pro Roll with bar stock head	49.0	22.2

Hi Adjust-A-Roll, Lo Adjust-A-Roll, and Pro Roll have a width of 31" (80 cm) and a depth of 23" (58.5 cm).

Quick Change Roller Housings

for Sumner
Pro Roll and
Adjust-A-Rolls

Sumner's innovative Quick Change Roller Housings increase the utility of its roller stand product line. Roller housings can be changed in a snap, without tools, to adapt to changing job needs. Roller wheels available in steel, stainless steel or rubber. Ball transfer heads, with carbon or stainless steel balls, and bar stock heads are also available.



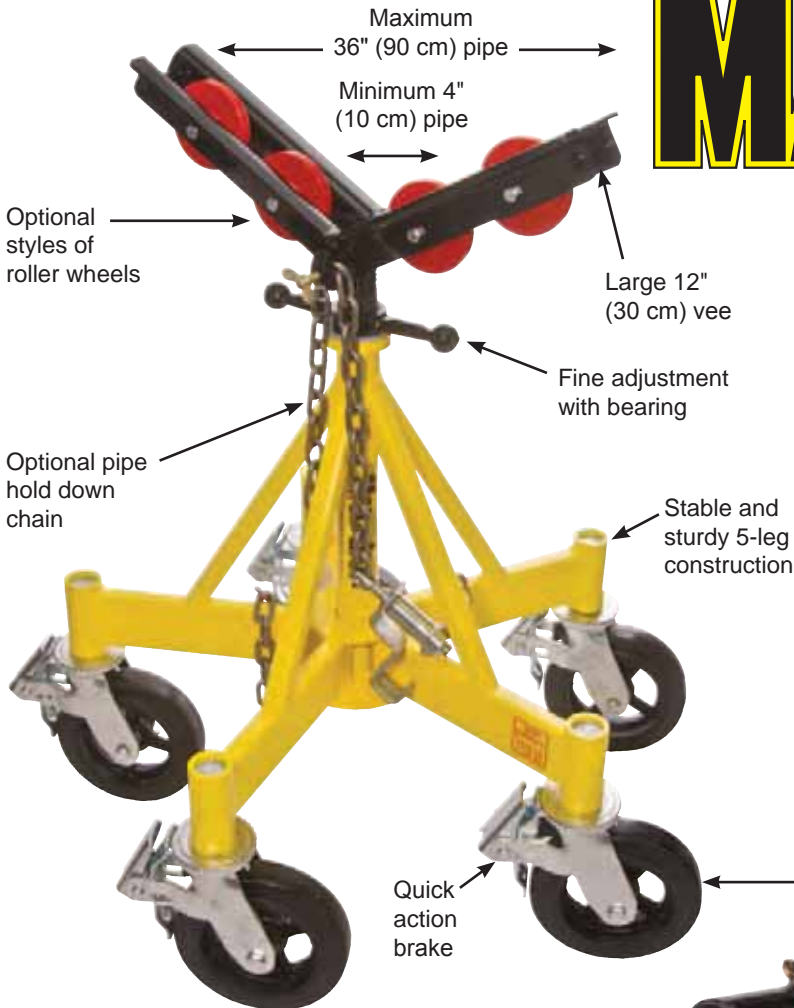
Patent Pending

Part No.	Description	Weight	
		lbs	kg
783151	Quick Change Housing with steel wheels	8.0	3.6
783152	Quick Change Housing with rubber wheels	7.0	3.2
783153	Quick Change Housing with stainless steel wheels	8.0	3.6
783154	Quick Change Housing with ball transfer head	7.0	3.2
783155	Quick Change Housing with bar stock head	16.0	7.2
783159	Quick Change Housing with stainless steel ball transfer head	8.0	3.6

Two large pipe fabricator stands capable of supporting 2,500 lb (1,135 kg) each!

MAX-JAX®

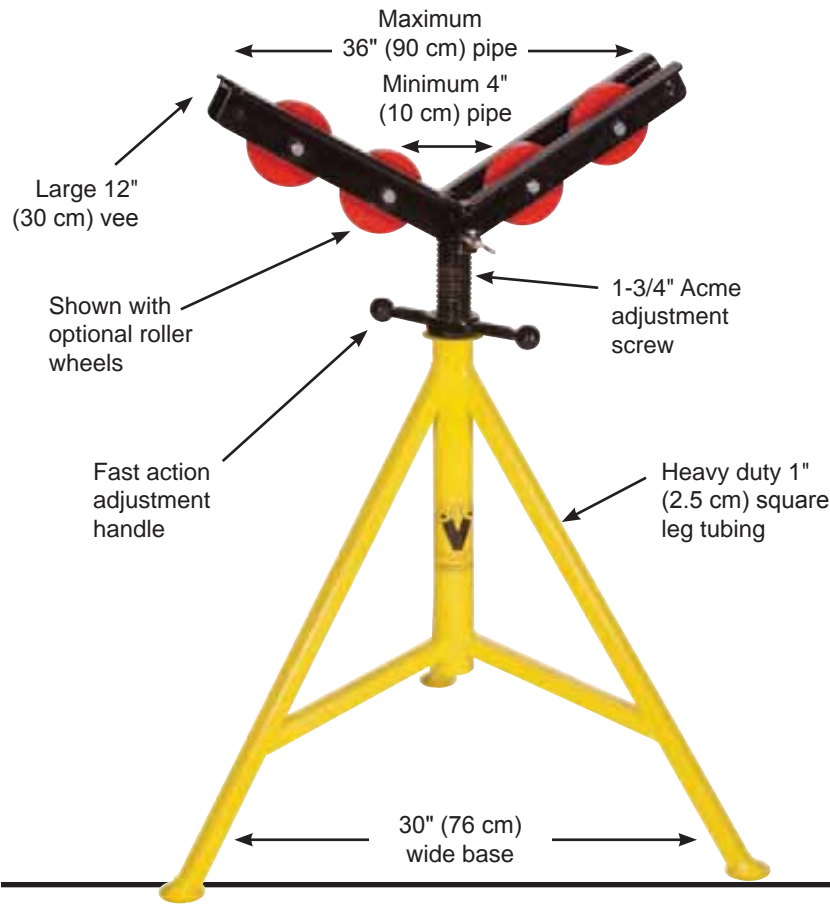
With sturdy 5-leg construction!



The versatile Max Jax is the ideal fabricator stand. The large 12" (30 cm) vee head and heavy duty five-legged design offers the welder a maximum margin of safety on pipe up to 36" (90 cm). With optional accessories, such as the heavy duty casters and Sumner Hold-Down Device, pipe weighing 2,500 lbs (1,135 kg.) per Max Jax can be wheeled with ease from storage rack... to welding bay... and onto the shipping dock. This means the load is lifted only once, resulting in a reduction of 50% or more in handling costs. The Max Jax is great for leveling loads for fit-up, or use with a pipe rotator.



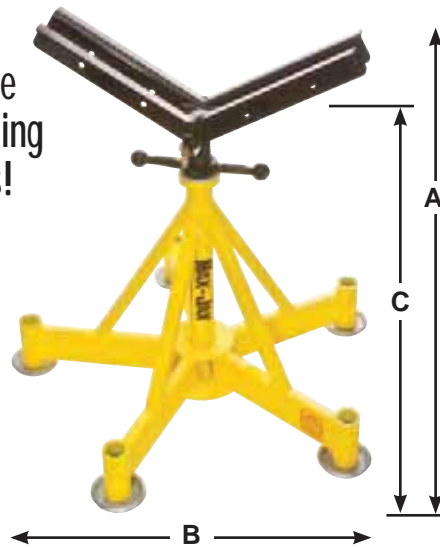
Shown with optional Hold-Down Device (part number 781050)



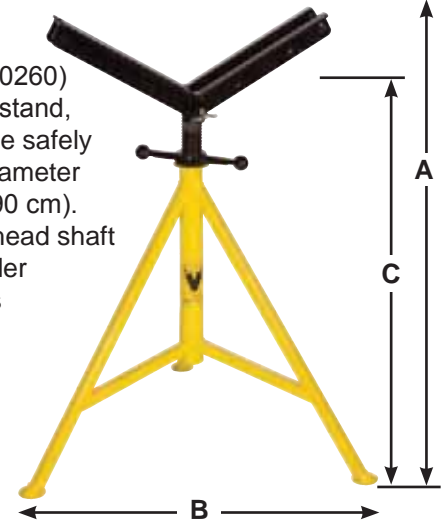
Sumner now offers the Big Vee Jack to fabricators of large diameter pipes. With a wider base, 1-3/4" Acme adjustment screw and greater load capacity, the Big Vee is the ideal stand for this application. It is a 3-leg heavy duty jack stand built tough for the demands of larger pipes at an affordable price!

Large leveling pads!

Basic Max Jax
(part number 781460)
Used as a Jack stand, the basic Max Jax safely handles large diameter pipe up to 36" (90 cm). The 1-3/4" vee head shaft permits the welder to position loads up to 2,500 lb (1,135 Kg) with ease. Check the Max Jax accessories on page 12.



Basic Big Vee
(part number 780260)
Used as a Jack stand, the basic Big Vee safely handles large diameter pipe up to 36" (90 cm). The 1-3/4" vee head shaft permits the welder to position loads up to 2,500 lb (1,135 Kg) with ease.



Specifications			
		Max Jax	Big Vee
Load Capacity		2,500 lb (1,135 kg)	2,500 lb (1,135 kg)
Basic Unit	A (height)	27.0" (686 mm)	35.5" (902 mm)
	B (width)	29.6" (752 mm)	29.5" (749 mm)
Basic Unit with casters	(height)	36.5" (927 mm)	not applicable
	(width)	39.5" (1,003 mm)	not applicable
Vee Head height	C (min.)	21.0" (533 mm)	29.5" (749 mm)
	(max.)	33.0" (838 mm)	41.0" (1,041 mm)
Vee Head height with casters	(min.)	30.5" (775 mm)	not applicable
	(max.)	42.5" (1,080 mm)	not applicable

Large Vee head Jack Accessories

Caster Kit (PN 781464) Steel Wheel Caster Kit (PN 781465)

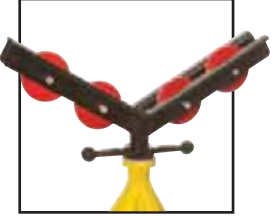


Max & Beam Jax
Five 8" (20 cm) heavy duty casters make up the Max Jax Caster Kit. The casters have a quick action braking system.



Roller Head Kit (PN 781406) Stainless Steel Roller Head Kit (PN 781407)

The Roller Head Kit option provides four roller wheels which can be quickly mounted into the 12" (30 cm) vee head. Roller wheels come in either steel or stainless steel.



Stainless Steel Sleeves (PN 781382)

When working with stainless steel pipe, the sleeve option instantly converts the Max Jax to a specialty tool for stainless steel welding, preventing carbon contamination.



Large Roller Wheels (PN 781381)

Wide steel wheels provide smoother pipe rotation with less effort.



Hold-Down Device (PN 781050)

The Sumner Hold-Down Device uses high tensile strength chain for gripping up to 12" (30 cm) pipe onto the large vee head when either welding or using the Max Jax for material handling. Chain extension kits are available for pipe up to 40" (101 cm).



Rubber Wheel Kit (PN 781394)

Consists of four rubber wheels and hardware so that it can be mounted into the 12" (30 cm) vee head. 1,000 lb (450 kg) capacity.



Stainless Steel Ball Transfers (PN 781397)

Standard Ball Transfers (PN 781383)

Consists of two 1-1/2" ball transfers which can be mounted in vee head slots for a range of 3/8—36" (9—900 mm) pipe. 1,000 lb (450 kg) capacity.



Part No.	Description	Weight	
		lbs	kg
780260	Big Vee -Basic	36.0	16.4
781460	Max Jax -Basic	68.0	30.8
781403	Max Jax Kit #1	144.0	65.5
781381	Large Roller Wheel Kit	8.0	3.6
781382	Stainless Steel Sleeves	8.0	3.6
781383	Standard Ball Transfer Kit	8.0	3.6
781394	Rubber Wheel Kit	8.0	3.6
781397	Stainless Steel Ball Transfer Kit	5.0	2.3
781406	Roller Head Kit	8.0	3.6
781407	Stainless Steel Roller Head Kit	8.0	3.6
781464	Caster Kit (Max Jax-5 casters)	70.0	31.8
781465	Steel Wheel Caster Kit (Max Jax)	75.0	34.1
781050	Hold-Down Device	6.0	2.7

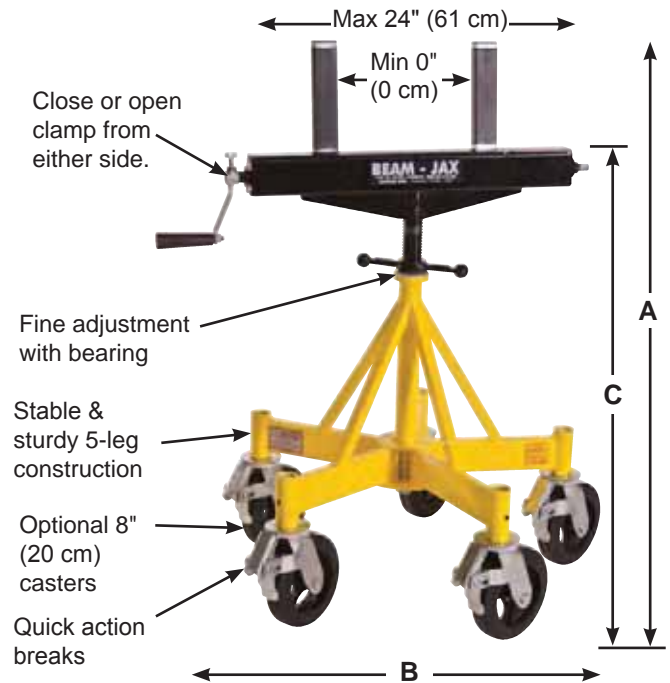
Move beams around the shop safely

- ✓ 2,500 lb (1,135 kg) capacity
- ✓ Clamping device centers load on stand & holds material in place while moving around shop
- ✓ 5-leg base construction ensures stability



Reversible beam forks

Specifications			
Load Capacity			2,500 lb (1,135 kg)
Basic Unit	A (height)		27.8" (705 mm)
	B (width)		29.6" (752 mm)
Basic Unit with casters	(height)		37.3" (947 mm)
	(width)		39.5" (1,003 mm)
Beam Head height	C (min.)		25.5" (648 mm)
	(max.)		37.5" (953 mm)
Beam Head height with casters	(min.)		35.0" (889 mm)
	(max.)		47.0" (1,194 mm)



Detachable handle permits easy clamping of material from either side of stand.



Basic Beam Jax (PN 781485)

Used as a stand, the basic Beam Jax safely supports 24" (61 cm) beams up to 2,500 lb (1,135 kg).

Detachable handle can be rotated out of operator's way.



Beam Jax Kit #1 (PN 781486) Includes basic Beam Jax unit (PN 781485) & caster kit (PN 781464).

Part No.	Description	Weight	
		lbs	kg
781485	Basic Beam Jax	51.0	23.1
781486	Beam Jax Kit (Beam Jax & Casters)	121.0	54.8

See page 12 for details on caster kits.

ULTRA quik clamp

**A fast, accurate fit-up
clamp for pipe to pipe,
pipe to fitting...
and more!**

ULTRA[®] clamp

NEW!



781530 5" - 12"
(127 - 300 mm)
781520 2" - 6"
(50 - 150 mm)
781510 1" - 2-1/2"
(25 - 65 mm)



781130 1" - 2-1/2"
(25 - 65 mm)
781150 2" - 6"
(50 - 150 mm)
781170 5" - 12"
(127 - 300 mm)

Standard Ultra Clamps uses conventional threaded adjustment.

- ✓ Rugged frame, built for job site use
- ✓ Smooth roller clamping action for positive gripping
- ✓ Stainless steel contacts & alignment screws
- ✓ Operating handle repositions for close work
- ✓ Fine adjustment screws for quick fit-up
- ✓ Light weight for overhead work



Pipe to Pipe



Pipe to Fitting



Pipe to Flange



Pipe to Tee



Push button design allows for rapid action setting and fine tune threaded adjustment

US & International Patents Pending

Part No.	Description	Weight	
		Lb.	Kg.
781130	1 - 2-1/2" Ultra Clamp	4.0	1.8
781150	2 - 6" Ultra Clamp	10.0	4.5
781170	5 - 12" Ultra Clamp	17.0	7.7
781510	1 - 2-1/2" Ultra Qwik Clamp	4.0	1.8
781520	2 - 6" Ultra Qwik Clamp	10.0	4.5
781530	5 - 12" Ultra Qwik Clamp	17.0	7.7

ULTRA

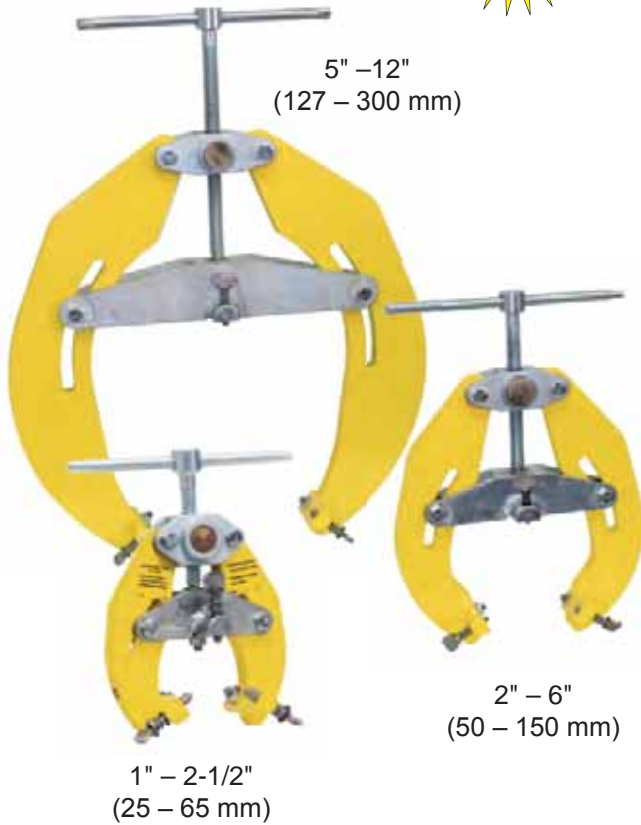
quik fit

A fast, accurate fit-up clamp for fitting to fitting!

ULTRA

fit

NEW!



Fit-up two 90° fittings



Fit-up 90° fitting to tee



Standard Ultra Fits uses conventional threaded adjustment.

- ✓ Rugged, compact design to operate in tight locations
- ✓ Stainless steel contacts & alignment screws
- ✓ Two-hand operating handle for positive gripping
- ✓ Fine adjustment screws for quick fit-up
- ✓ Light weight for overhead work
- ✓ Smooth roller clamping action for positive gripping
- ✓ Ultra Qwik Fit quick release button allows clamp to open and close in seconds
- ✓ Push button design allows for rapid action setting and fine tune threaded adjustment

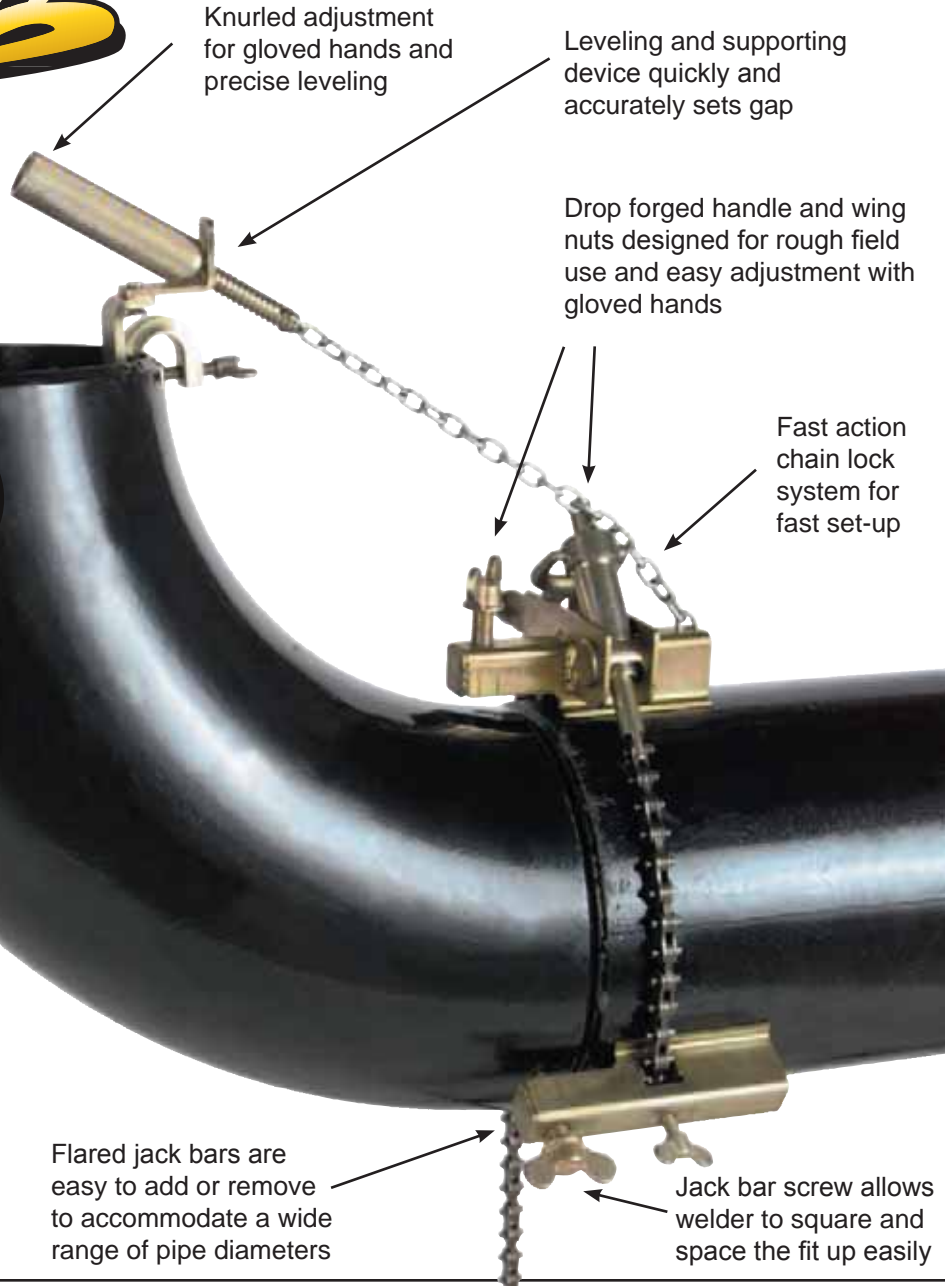
Part No.	Description	Weight	
		lbs	kg
781265	1" – 2-1/2" Ultra Fit	4.0	1.8
781275	2" – 6" Ultra Fit	8.0	3.6
781285	5" – 12" Ultra Fit	15.0	6.8
781540	1" – 2-1/2" Ultra Qwik Fit	4.0	1.8
781550	2" – 6" Ultra Qwik Fit	8.0	3.6
781560	5" – 12" Ultra Qwik Fit	15.0	6.8

US & International Patents Pending

CLAMP Champ

SUMNER

Pipe alignment and clamping tool.



Knurled adjustment for gloved hands and precise leveling

Leveling and supporting device quickly and accurately sets gap

Drop forged handle and wing nuts designed for rough field use and easy adjustment with gloved hands

Fast action chain lock system for fast set-up

All parts plated to resist rust

High tensile strength chain with black oxide finish

Flared jack bars are easy to add or remove to accommodate a wide range of pipe diameters

Jack bar screw allows welder to square and space the fit up easily

CLAMP CHAMP... an advanced solution for today's problem fit ups!

The Clamp Champ is built for the welder who takes pride in doing his job right the first time. Constructed for years of trouble-free job site use, the versatile Clamp Champ makes pipe fit-up simple and accurate – without the need of a helper. The Clamp Champ is similar to a pipe vise with fast, easy set up and solid chain engagement.

Each model offers:

FIT-UP CAPACITY

Pipe to Pipe
Pipe to Fitting
Pipe to Flange
Fitting to Fitting

Plus... Reforming up to schedule 40 pipe!

LOW COST

Half the cost of comparable cage clamps

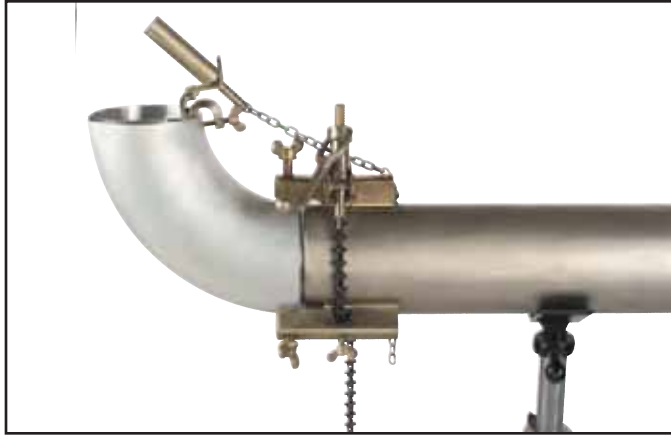
LIGHTWEIGHT CONSTRUCTION

Engineered for strength without the weight

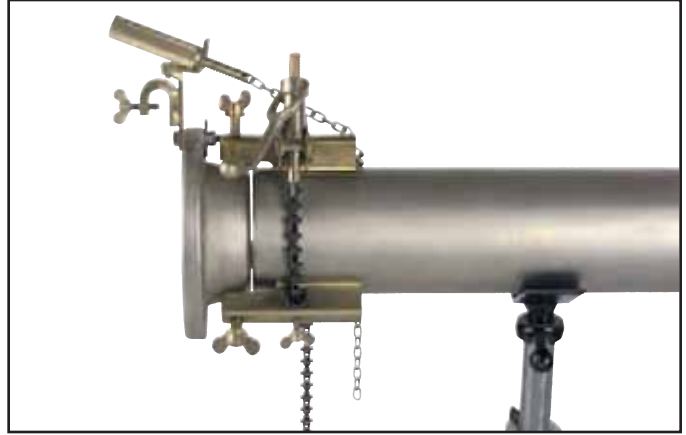
WIDE RANGE

1-10" (25–250 mm)
1-16" (25–400 mm)
10-36" (250–900 mm)
Carbon or Stainless
Plus... Conversion Kits to 48" (1,200 mm) pipe!

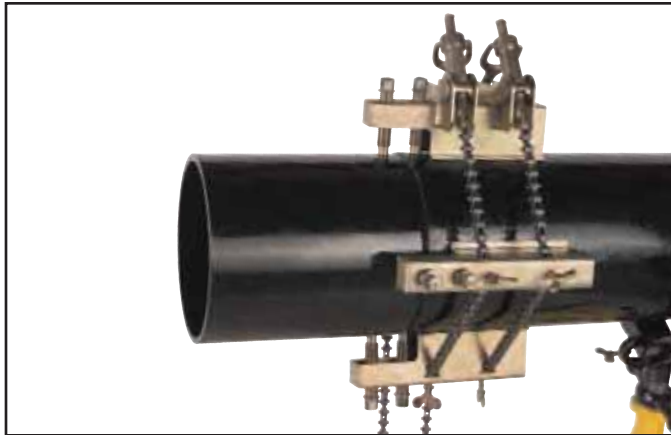
Each Clamp Champ is capable of a wide range of fit-ups ... without additional accessories!



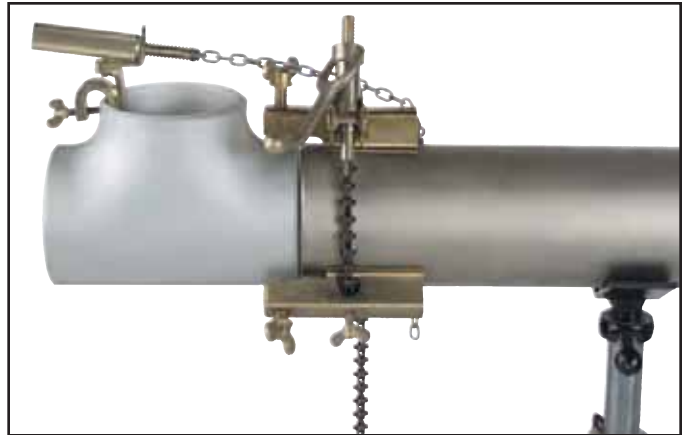
Pipe to 90° fitting



Pipe to flange



Pipe to pipe



Pipe to tee

Standard Kit:

Consists of metal carrying box, main block and chain, jack bars and instruction manual. Large Clamp Champ includes double jack screws for reforming 20 mm pipe wall.

Range	Model	Part No.	Description	Number of Jack Bars	Weight	
					Lb.	Kg.
1-10" (25 - 250 mm)	Standard	781000	ST-110 Standard Clamp Champ	3	21.0	9.5
1-10" (25 - 250 mm)	Stainless Steel	780999	ST-210 Stainless Steel Clamp Champ	3	21.0	9.5
1-16" (25 - 400 mm)	Standard	780998	ST-116 Standard Clamp Champ	5	25.0	11.3
1-16" (25 - 400 mm)	Stainless Steel	780997	ST-216 Stainless Steel Clamp Champ	5	25.0	11.3
10-36" (250 - 900 mm)	Standard	781250	Standard Clamp Champ	7	111.0	50.4
10-36" (250 - 900 mm)	Stainless Steel	781251	Stainless Steel Clamp Champ	7	111.0	50.4



Conversion Kit:

Consists of chain and jack bars to increase Clamp Champ capacity

Capacity Increase from	Capacity Increase to	Model	Part No.	Number of Jack Bars	Chain Length	Weight	
						Lb.	Kg.
10" (250 mm)	16" (400 mm)	Standard	781031	2	18" (450 mm)	7.0	3.2
10" (250 mm)	16" (400 mm)	Stainless Steel	781032	2	18" (450 mm)	7.0	3.2
36" (900 mm)	48" (1,200 mm)	Standard	781252	2	30" (760 mm)	16.0	7.3
36" (900 mm)	48" (1,200 mm)	Stainless Steel	781253	2	30" (760 mm)	16.0	7.3

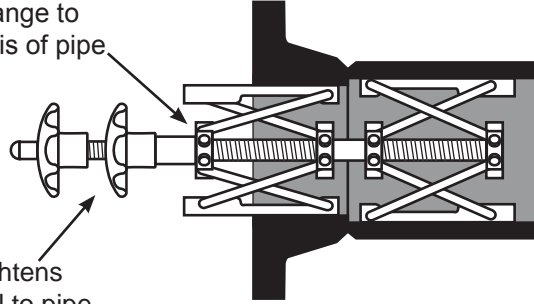


Internal Fit-up Clamp

The Ideal Flange Fit-up Tool!

Fits up flange to
center axis of pipe

Tightens
tool to pipe



Two independently operated internal mandrels align flange to pipe even if internal dimensions differ.



8" - 12" (200–300 mm)
Internal Fit-Up Clamp



4" - 8" (100–200 mm)
Internal Fit-Up Clamp



2" - 4" (50–100 mm)
Internal Fit-Up Clamp

- ✓ Can be used on all standard weld neck flanges and great with slip-on flanges
- ✓ Contact points stainless steel — a standard feature
- ✓ One piece construction — no loose pieces
- ✓ Quick action operation
- ✓ Priced right

Simple Operation



1. Tighten jaws to clamp pipe I.D.



2. Mount flange on second set of pipe jaws, adjust for gap and tighten jaws for final fit-up.

Part No.	Description	Weight	
		lbs	kg
784103	8" - 12" (200–300 mm) Internal Fit-up Clamp	28.0	12.7
784102	4" - 8" (100–200 mm) Internal Fit-up Clamp	8.5	3.9
784100	2" - 4" (50–100 mm) Internal Fit-up Clamp	2.5	1.1

NOTE: The Internal Fit-up Clamp is an alignment tool. A separate lifting device to support the flange weight is recommended.

Flange SPREADER™ (Manual)



ST-301



ST-302



ST-303



ST-304

- ✓ 4 models to cover flange ranges from 1" (25 mm) to 24" (600 mm)
- ✓ Can be used for 150 to 1,500 lbs flanges
- ✓ Hardened wedge for safe splitting
- ✓ Large feed screw
- ✓ Drive can be rotated by 1-3/8" wrench or 1/2" (12 mm) bar
- ✓ Compact design – strong enough for tough jobs

Part No.	Description	Spread	Pin Diameter	150 lb	300 lb	400 lb	600 lb	900 lb	1,500 lb
784003	ST-301 Flange Spreader	3" (76 mm)	5/8" (16 mm)	1–6"	3/4–4"	1/2–2"	—	—	—
784002	ST-302 Flange Spreader	4" (101 mm)	3/4" (19 mm)	2–12"	1-1/2–8"	1–4"	1–4"	1–2"	1–2"
784001	ST-303 Flange Spreader	5" (127 mm)	7/8" (22 mm)	5–24"	2-1/2–12"	1-1/2–8"	2–6"	1–4"	1–3"
784000	ST-304 Flange Spreader	6-3/8" (162 mm)	1" (25 mm)	10–24"	7–24"	3-1/2–16"	4–10"	1–8"	1–5"

Flange SPREADER™ (Hydraulic)



Patent Pending

- ✓ 10 ton flange splitter to tackle the tough jobs
- ✓ Spreader arms adjust from 2-3/4" to 8-1/2" (70 mm to 215 mm)
- ✓ Spring return, single action cylinder
- ✓ Hardened wedge
- ✓ Simple operation
- ✓ Hand pump and 6' (1.5 m) hose available as accessories

Accessories:
Part No. 777010
Hand hydraulic pump for Flange Spreader with 6' (1.5 m) hose and quick disconnect.

Part No.	Description	Capacity	Cylinder Capacity	Cylinder Stroke	Flange Pin Size	150 lb	300 lb	400 lb	600 lb	900 lb	1,500 lb
784004	ST-310 Flange Spreader	9 x 92 mm	10 ton	2" (54 mm)	1-1/4" – 1-5/8" (32–42 mm)	22–42"	16–28"	14–24"	12–20"	8–16"	4–8"

Flange Pins

SUMNER

For accurate alignment of pipe flanges (**carbon or stainless steel**)

- ✓ Quick installing pins work as convenient reference points to level flange for tack and weld-out — no tools needed
- ✓ Hardened tapered ST-106 and ST-206 pins automatically center on 5/8" to 1-5/8" (16–42 mm) holes; ST-258 pins similarly set in 1-1/2" to 2-5/8" (38–66 mm) holes or flange thicknesses of 4-5/8" to 6-3/8" (117–162 mm)
- ✓ Features Acme threads for maximum clamping power and hardened steel for long lasting use

ST-106 / ST-206



ST-258

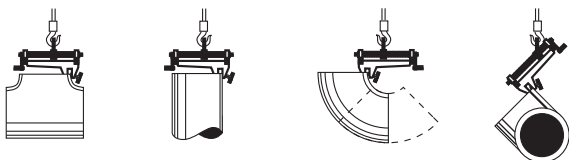


Part No.	Description	Weight	
		lbs	kg
780430	ST-106 Flange Pins	4.0	1.8
780429	ST-206 Stainless Steel Flange Pins	4.0	1.8
780650	ST-258 Flange Pins	32.0	14.5

Adjust-A-Fit

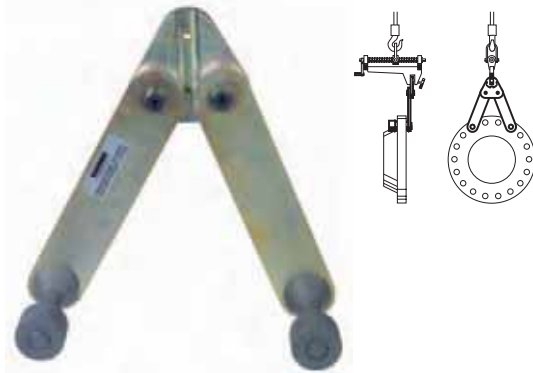


- ✓ Makes lining up fittings a trouble-free, one man operation
- ✓ Uses gravity to align fittings for loads up to 45°
- ✓ Fastens directly onto fittings for loads up to 1,000 lb (450 Kg)
- ✓ Threaded shaft assembly is hardened for long tool life
- ✓ Cloverleaf setscrew and threaded shaft handle work from either side



Part No.	Description	Weight	
		lbs	kg
780420	ST-104 Adjust-A-Fit	11.0	5.0

Adjust-A-Flange



- ✓ Fits all flanges for 5" pipe and larger with bolt holes 3/4" to 1-5/8" (19 to 42 mm)
- ✓ Used in combination with the Adjust-A-Fit to bring pipe flanges to exact plumb for tack and weld out
- ✓ Eliminates 75% of the hard work in pipe fitting when used with the Adjust-A-Fit and Roust-A-Bout (see Sumner Material Lifts catalog)
- ✓ Handles loads up to 1,000 lb (450 Kg)
- ✓ Flange nuts serve as convenient reference points to check level

Part No.	Description	Weight	
		lbs	kg
780425	ST-105 Adjust-A-Flange	11.0	5.0

For fast, accurate alignment of carbon pipe flanges

- ✓ Quick installing pins work to level flange (two-hole) for tack and weld-out
- ✓ Hardened tapered Qwik Pins automatically center on 5/8" to 1-5/8" (16–42 mm) holes
- ✓ Features Acme threads for maximum clamping power and hardened steel for long-lasting use



Part No.	Description	Weight	
		lbs	kg
781235	Qwik Pins	4.0	1.8

Simple Operation

1. Push spring-loaded button
2. Separate pin from nut
3. Insert into top two flange holes
4. Push spring button and re-insert onto pin
5. Quarter turn to tighten

Flange Leveler

- ✓ Now two-hole & level in one time-saving operation
- ✓ Uses push-button Qwik Pin nuts for fast action
- ✓ Features stub Acme threads for maximum clamping & hardened steel for lasting use



- ✓ Automatically centers in flange holes 5/8" to 1-5/8" (16–42 mm)
- ✓ Easily replaceable vials in the event of breakage

Part No.	Description	Weight	
		lbs	kg
781240	Flange Leveler	4.5	2.0
779934	Vial Kit	0.5	0.2

Rotary Ground Clamp

SUMNER

Puts an end to tangled ground leads

- ✓ Rotary head turns with the pipe — puts an end to ground lead twist, tangle and wear
- ✓ Provides quick, positive ground for roll-out welding of pipe and fittings — eliminates weld pinholes caused by poor grounding
- ✓ Attaches and detaches in seconds
- ✓ Makes up ground leads three ways — lug, clamp-on and bare cable
- ✓ Positive anti-arc bearings take loads up to 400 amps



Part No.	Description	Amp Capacity	Weight	
			lbs	kg
780435	Rotary Ground Clamp	400	4.0	1.8

FIT KIT



Now you can get the Ultra Clamp, the Ultra Fit, and the Internal Fit-Up Clamp ... all in one great package!



Fit Kit 2" – 6" contains:

- ✓ 2" – 6" Ultra Clamp
- ✓ 2" – 6" Ultra Fit
- ✓ 4" – 8" Internal Fit-Up Clamp
- ✓ Set of carbon steel flange pins
- ✓ Quad Level
- ✓ Weldbox 2008

Fit Kit 2" – 12" contains:

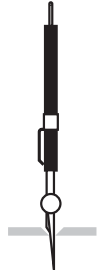
- ✓ Four (4) Fold-A-Jacks
- ✓ 2" – 6" Ultra Clamp
- ✓ 5" – 12" Ultra Clamp
- ✓ 2" – 6" Ultra Fit
- ✓ 5" – 12" Ultra Fit
- ✓ 2" – 4" Internal Fit-Up Clamp
- ✓ 4" – 8" Internal Fit-Up Clamp
- ✓ 8" – 12" Internal Fit-Up Clamp
- ✓ Quad Level
- ✓ Steel Square
- ✓ One set of Qwik Pins
- ✓ Weldbox 3617

Part No.	Description	Weight	
		lbs	kg
780324	Fit Kit 2" – 6"	35.0	16.0
780315	Fit Kit 2" – 12"	283.9	129.0

Welding Gage



Accurate quick check of internal hi-lo



Root weld spacing with little effort

- ✓ Available in both imperial and metric
- ✓ Measure internal hi-lo misalignment and root weld gap spacing



Part No.	Description	Weight	
		lbs	kg
781900	Welding Gage—Imperial	0.3	0.1
781901	Welding Gage—Metric	0.3	0.1

For fast, accurate positioning of flat and round ferrous metal for welding and assembly!



Small Angle Fixture



Medium Angle Fixture



Large Angle Fixture

Fit-up is a snap with Sumner's line of magnetic welding fixtures ...



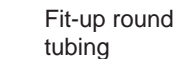
Multiple Angle Fixture



Heavy Duty, Fixed 90° Fixture



Position square tubing



Fit-up round tubing

Part No.	Description	Holding Capacity	Dimensions	Angle Configuration	Weight
781885	Multiple Angle Fixture	28.0 lb (12.5 kg)	3.75" x 0.5" x 2.5" (96 x 14 x 64 mm)	30°, 45°, 60°, 75°, 90°	1.0 lb (0.4 kg)
781886	Small Angle Fixture	48.5 lb (22.0 kg)	4.75" x 0.5" x 3.25" (120 x 14 x 82 mm)	45°, 90°, 135°	1.0 lb (0.4 kg)
781887	Medium Angle Fixture	90.0 lb (41.0 kg)	6.33" x 0.75" x 4.0" (160 x 20 x 102 mm)	45°, 90°, 135°	2.0 lb (0.9 kg)
781888	Large Angle Fixture	122.0 lb (55.0 kg)	7.88" x 0.89" x 5.0" (200 x 22 x 128 mm)	45°, 90°, 135°	3.0 lb (1.4 kg)
781875	Heavy Duty 90° Fixture	88.0 lb (40.0 kg)	8.2" x 8.2" x 1.8" (207 x 207 x 48 mm)	90°	6.0 lb (2.7 kg)



Hold tubing to steel plate

Pocket Level (PN 781947)



A twin vial level constructed of tough ABS and aluminum frame, the strong magnetic base makes this pocket-size level great for many tasks.

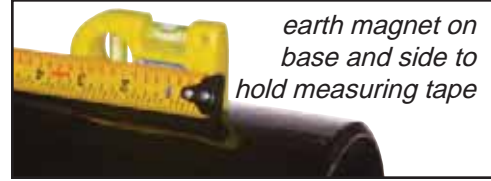
weighs just 3 oz. (84 g)



Can be used with a plumb bob.



level pipe for fit-up



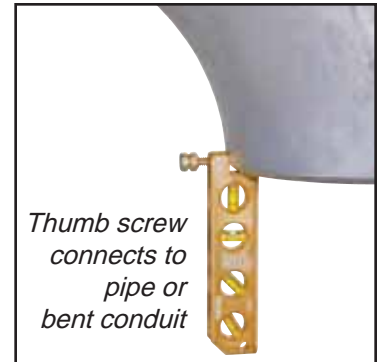
earth magnet on base and side to hold measuring tape

Versa Level (PN 781945)

Featuring a tough, anodized body and a magnetic base, the Versa Level comes with four vials (0°, 30°, 45°, 90°). There is also a "v" cut into the base for pipe and conduit work.



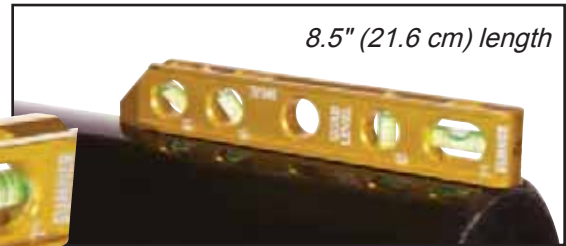
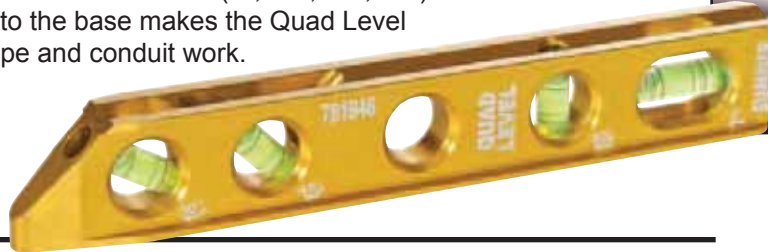
Easy read vials with magnetic base.



Thumb screw connects to pipe or bent conduit

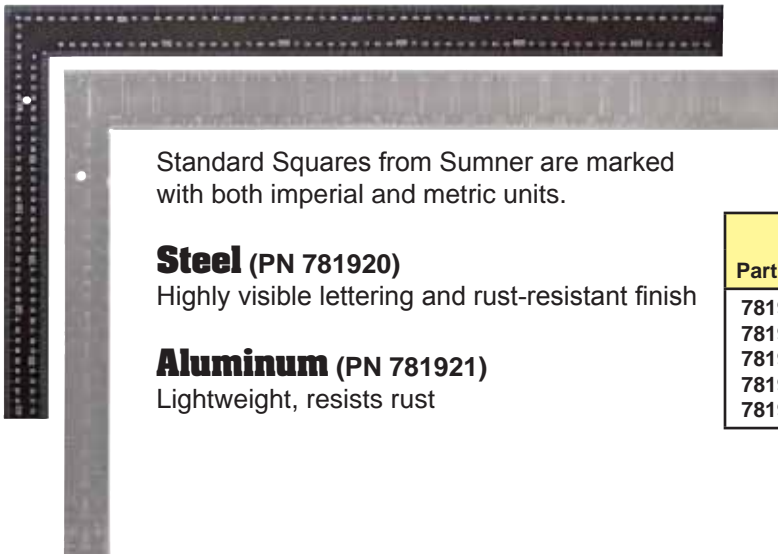
Quad Level (PN 781946)

This is a tough, anodized aluminum level with a magnetic base and four vials (0°, 30°, 45°, 90°). A "v" cut into the base makes the Quad Level great for pipe and conduit work.



8.5" (21.6 cm) length

Standard Squares



Standard Squares from Sumner are marked with both imperial and metric units.

Steel (PN 781920)

Highly visible lettering and rust-resistant finish

Aluminum (PN 781921)

Lightweight, resists rust

Part No.	Description	Weight	
		lbs	kg
781920	Standard Square (steel)	1.4	0.6
781921	Standard Square (aluminum)	0.8	0.4
781945	Versa Level	0.3	0.1
781946	Quad Level	0.4	0.2
781947	Pocket Level	0.2	0.1

MUL-T-SQUARE®

Makes problem fit-up easy and simple set-ups a snap!

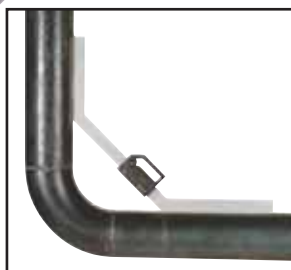
- ✓ Lightweight, but durable
- ✓ Handles up to 8" (20 cm) flanges and up to 14" (35 cm) fittings
- ✓ Versatile for measuring 45° and 90° angles
- ✓ Blades marked with both Imperial and Metric units



The Mul-T-Square consists of two 45° blades that slide effortlessly in an industrial-strength plastic handle. Each blade is made of stainless steel for precise alignment. The 10" (26 cm) and 14" (35 cm) arms allow for measurement of tight fit-ups or they can be expanded for up to 30" (76 cm) squaring of 90° fittings. In some instances, the 45° blades are handy by themselves for simple alignment. The blades are loosened or secured by a simple twist of the conveniently located locking knob.



Now get the Mul-T-Square with extended reach! Blades with 10" (26 cm) and 20" (52 cm) arms provide even greater range. Extended blades fit into the standard Mul-T-Square. Available as blades only or as a complete Mul-T-Square assembly.



Part No.	Description	Weight	
		lbs	kg
790000	Mul-T-Square complete (standard blades)	2.0	0.9
790001	Mul-T-Square handle only	0.3	0.1
790021	Mul-T-Square blades only (pair, standard)	2.0	0.9
790026	Mul-T-Square blades only (pair, extended)	2.5	1.1
790030	Mul-T-Square complete (extended blades)	2.0	0.9

Circle Snap®

A fast, accurate solution for torch cut holes.



SUMNER



Circle Snap 2-13/16
PN 784560

2-7/16", 2-9/16", 2-11/16", 2-13/16"
(62 mm, 65 mm, 68 mm, 71 mm)



Circle Snap 2-5/16
PN 784550

1-15/16", 2-1/16", 2-3/16", 2-5/16"
(49 mm, 52 mm, 56 mm, 59 mm)



Circle Snap 1-13/16
PN 784540

1-7/16", 1-9/16", 1-11/16", 1-13/16"
(37 mm, 40 mm, 43 mm, 46 mm)

- ✓ Four convenient hole sizes in each of three Circle Snap holders
- ✓ Earthen magnets lock holders to steel to prevent movement while cutting
- ✓ Loops swing out & lock ... ready for cutting!

Great For ...

- ✓ Weldlets
- ✓ Threadlets
- ✓ Matching saddlecut holes
- ✓ Any conventional gas cutting torch

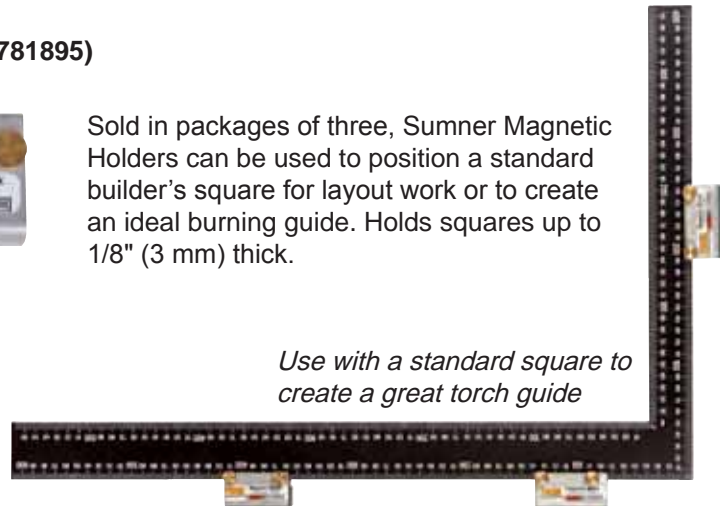
Magnetic Holders (PN 781895)



Sold in packages of three, Sumner Magnetic Holders can be used to position a standard builder's square for layout work or to create an ideal burning guide. Holds squares up to 1/8" (3 mm) thick.

Part No.	Description	Weight	
		lbs	kg
784560	Circle Snap 2-13/16	1.0	0.5
784550	Circle Snap 2-5/16	1.0	0.5
784540	Circle Snap 1-13/16	1.0	0.5
781895	Magnetic Holders	1.0	0.4
781896	Magnetic Torch Guide Kit	2.0	0.9

Use with a standard square to create a great torch guide



Magnetic Torch Guide Kit (PN 781896)

Kit includes two Sumner Magnetic Holders and a 24" (61 cm) stainless steel cutting rail for straight torch work.



More than a Pipe Buggy!

Uses leverage to lift pipe!



Now available with flat free tires!

Patented

- ✓ Transport 20 ft (6.1 m) pipe lengths up to 1,000 lbs (450 kg)
- ✓ Comes with ratchet hold-down strap and 16" (41 cm) tubed or flat free tires
- ✓ Weighs only 82 lb (37.2 kg) ... can be shipped UPS
- ✓ Quick handle disconnect for compact storage
- ✓ Carries up to 12" (30 cm) diameter pipe
- ✓ Ideal job-site material carrier



1 Use ratchet to secure Cricket to pipe



2 Use handle to flip Cricket & pipe



3 Reposition handle

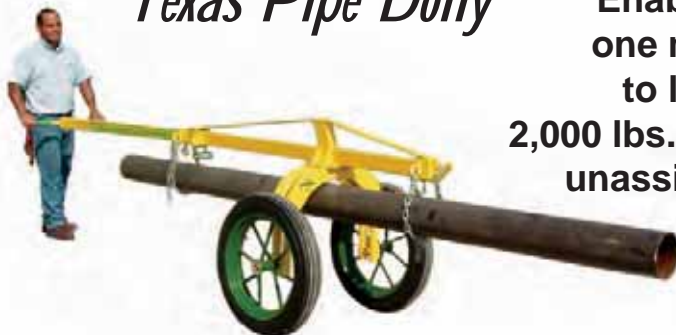


Great for flanges, fittings and valves

Part No.	Description	Height		Width		Width between wheels		Length		Weight	
		inch	cm	inch	cm	inch	cm	inch	cm	lbs	kg
782699	Cricket	21	53	28	71	16	41	28	71	82	37.2
782685	Cricket with flat free tires	21	53	28	71	16	41	28	71	82	37.2

Grasshopper

Texas Pipe Dolly



Enables one man to lift 2,000 lbs. (900 kg) unassisted!



- ✓ Special sliding chain block design accommodates long and short loads
- ✓ Carries up to 20" diameter pipe, tool boxes, fittings and valves

GRASSHOPPER SPECIFICATIONS										LOAD CAPACITY							
Part No.	Description	Weight		Length		Width		Height		Weight		Length		Width		Height	
		lb	kg	ft.	cm	in.	cm	in.	cm	lb	kg	ft.	cm	in.	cm	in.	cm
780351	ST-401 Grasshopper	165	75	12	366	35	89	40	102	2,000	900	20	610	20	51	28	71

A Mobile Pipe Cart

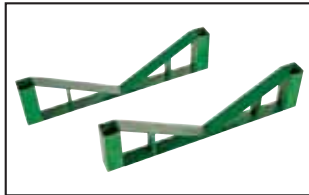
- ✓ Transports 2,000 lb (900 kg) of pipe, individually or up to a height of 34" (86 cm)
- ✓ Center-positioned casters makes rolling the Pipe Mac easy and enables quick cart rotation for tight turns
- ✓ Six 6" (15 cm) heavy duty casters
- ✓ Posts pull out for compact storage
- ✓ Stacks when not in use



Vee Attachment included!

Pipe Mac comes with vee attachment. Shown transporting 20" (51 cm) pipe.

Simple but rugged attachment prevents pipe from rolling while the Pipe Mac is in motion.



Easily slips over the four post holders — no tools required!

SPECIFICATIONS	inch	cm
Height (stowed)	19.5	49.5
Height (operating)	44.0	111.7
Length	58.5	148.6
Width	33.0	83.8
Ground clearance	7.5	19.4
Post Height	34.0	86.4



MAG RACK I™

MAG RACK II™



- ✓ 1,000 lb (455 kg) load capacity
- ✓ Double wall square tubing
- ✓ Eight bins of storage
- ✓ Arms fold easily with plunger release

Patent Pending



Patent Pending



Support masts nest into base by pulling plunger pins. Folds up in seconds for convenient storage.



Mac Rack II has a convenient utility tray.

Part No.	Description	Weight	
		lb	kg
783230	Pipe Mac	170	77.1
783317	Mac Rack I - complete with casters	165	74.8
783299	Mac Rack II - complete with casters	172	78.0

SPECIFICATIONS	with casters	
	inch	cm
Height Stowed	17-3/4	45.0
Height Open	61-1/2	155.6
Length	58-1/2	148.6
Width	33	83.8
Ground Clearance	7-1/2	19.1

SUMNER

- ✓ Holds large bundles of conduit
- ✓ Arms fold in seconds for convenient storage
- ✓ 1,000 lb (455 kg) load capacity
- ✓ Stacks with all Mac carts



**Bundle
MAC**™

**Stacking
MAC
RACKS**™

Part No.	Description	Dimensions			Weight	
		Width	Height	Length	lb	kg
783320	Bundle Mac	33" (83.8 cm)	42-1/2" (107.9 cm)	58-1/2" (148.6 cm)	165	74.8

TAINER MAC

A Mobile, Heavy Duty Stacking Container For The Contractor

Perfect storage for ...

- ➔ Power cords
 - ➔ Fittings
 - ➔ Fasteners
 - ➔ Safety Gear
 - ➔ Hardware
 - ➔ Loose parts
 - ➔ Pumps & hoses
 - ➔ Rope Slings
- ... and more!

- ✓ Transports 1,500 lb / 680 kg of material
- ✓ Four 6" heavy duty casters
- ✓ Posts for stacking & steering
- ✓ Stacks with other Sumner Stacking Macs
- ✓ Large storage capacity
- ✓ Fits through 36" (91 cm) doorway
- ✓ Lockable casters



**Stacking
MAC
RACKS**™

Part No.	Description	Height		Width		Length		Weight	
		inch	cm	inch	cm	inch	cm	lb	kg
784990	Tainer Mac	24	61	32	81	56	142	200	90.7

Stacking saves valuable floor space while still allowing access to the bottom Tainer Mac!

STOR MAC

A security storage chest for those who require high visibility of contents



- ✓ Tough steel wire screen
- ✓ Four 6" (15 cm) Heavy Duty casters standard
- ✓ Great for job site storage, security cages at trade shows, concessionaires or shop use



Two point locking doors use Master Lock No. 5



- ✓ Removable steel shelves
- ✓ Load capacity 1,500 lbs (680 kg)
- ✓ Competitively priced

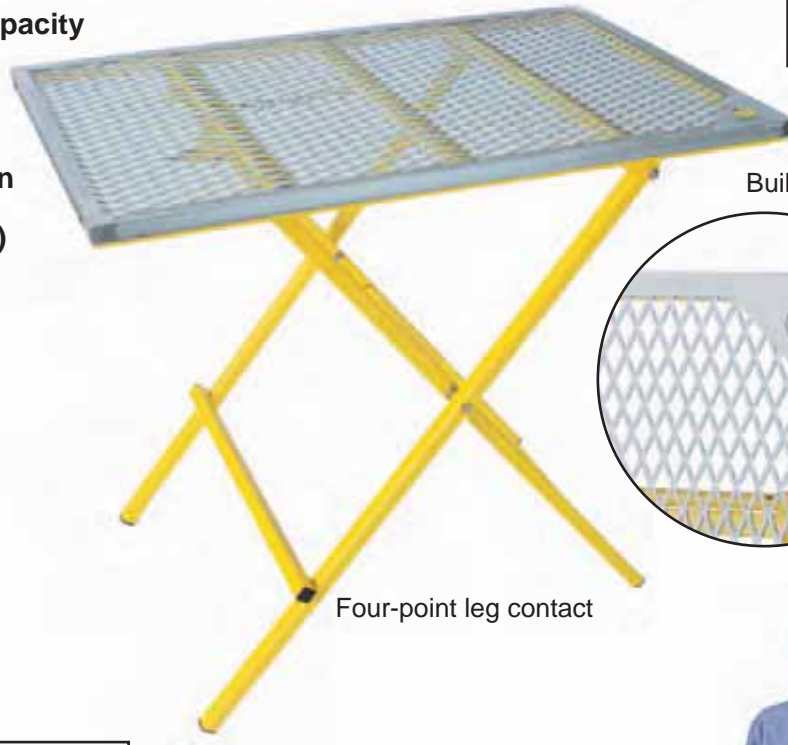
Part No.	Description	Weight	
		lbs	kg
784920	Stor Mac Security Storage Chest	322.0	146.0

a portable
welding table

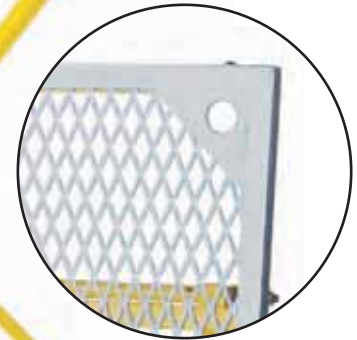


Use occasionally or as a permanent work bench

- ✓ Tough #9 expanded metal top
- ✓ 600 lb (270 kg) load capacity
- ✓ 1" (2.5 cm) square tube frame
- ✓ One piece construction
- ✓ 24" x 40" (60 x 100 cm) work surface
- ✓ Table top plated for ground clamp



Built-in torch holder



Four-point leg contact



The optional 8" (20 cm) wheel kit for the Handi-Bench allows for rolling transport of table in folded position only.



Plunger pin locks legs in open or folded position.



Compact storage

Part No.	Description	Work Dimension			Load Capacity	Weight	
		Height	Depth	Length		Lb.	Kg.
783980	HB-604 Welding Table	36.3" (92.2 cm)	24.4" (62 cm)	40.4" (102.6 cm)	600 lb (270 kg)	54.0	24.5
783965	8" Wheel Kit for Series 600 Handi-Bench					5.0	2.3

Ideal storage chest for all the welder's needs



Weldbox 3617
PN 779928

Weldbox 2008
PN 779910



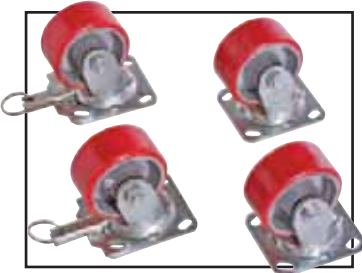
- ✓ Two-point latching system requires only 1 lock
- ✓ 16 gage steel



Weldbox 2812
PN 779911



- ✓ 16 gage steel



PN 779037 Caster Kit
Mount Heavy duty caster on Weldbox 3617 to easily move around the shop.

Part No.	Description	Opened Height		Height		Width		Depth		Weight		
		inch	cm	inch	cm	inch	cm	inch	cm	lbs	kg	
779910	WELDBOX 2008	16"	41	9-1/2"	24	20-1/8"	51	8-1/2"	22	12.1	5.5	
779911	WELDBOX 2812	22-5/8"	57	11"	28	28-3/8"	72	12"	30	30.8	14.0	
779928	WELDBOX 3617	35"	89	22-1/2"	57	36"	91	17"	43	97.9	44.5	
779037	Caster Kit (WELDBOX 3617)	N/A								23.0	10.4	

The hoist for
all fab shop
needs!



Capable of lifting
20' (6.0 m) lengths
of 10" (25 cm) pipe

- ✓ 1,000 lb capacity (450 kg), 7 ft (2.1 m) lifting capacity
- ✓ Moves loads vertically and horizontally at the same time
- ✓ Sumner-built single-speed winch offers infinite positioning for accurate fit-ups
- ✓ 8" (20 cm) casters and special base allows load to "get close to the work"
- ✓ Accessories make Fab-Mate extremely versatile
- ✓ Priced for all budgets



Position fittings with
Sumner Adjust-A-Fit
(see page 19)



Align flanges with
Sumner Adjust-A-Flange
(see page 19)



Move plate with
plate lifting clamp

Part No.	Description	Height		Width		Length		Weight	
		inch	cm	inch	cm	inch	cm	lbs	kg
783900	Fab-Mate	88.5	224.0	35.0	89.0	44.0	111.0	206.0	93.0

PURGE STAR

SUMNER

INFLATABLE PURGE DAMS 2" - 16" (50 - 400MM) PIPE & TUBING

NEW!

✓ ALL NEW DESIGN
✓ NEW PRICE SAVINGS

- ✓ Save time and argon
- ✓ Faster inflation time
- ✓ Made with the best quality material for years of use

Inflatable Purge Star System Features:

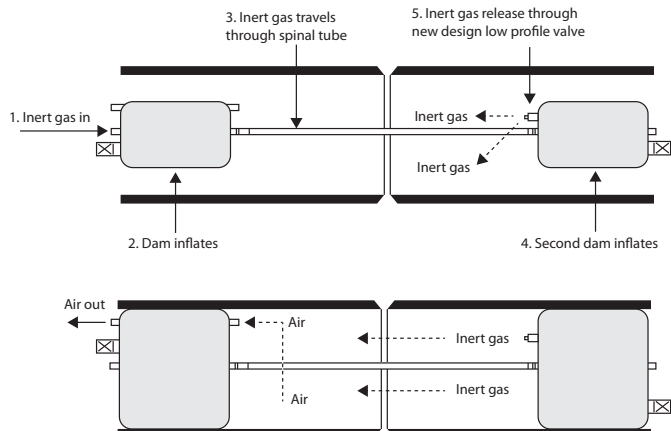
- ✓ Purge 6" pipe in less than 3 minutes to less than 1% oxygen content
- ✓ Reduce argon usage
- ✓ Increase weld production rate
- ✓ Improve weld quality

PURGE STAR FEATURES:



**NOW
LOWER
PRICE!**

Part No.	Description	Weight	
		lbs	kg
Single Hose			
786000	Inflatable Purge Star 2" (50 mm)	0.8	0.5
786001	Inflatable Purge Star 3" (75 mm)	0.9	0.5
786002	Inflatable Purge Star 4" (100 mm)	0.9	0.5
786003	Inflatable Purge Star 6" (150 mm)	0.9	0.5
786004	Inflatable Purge Star 8" (200 mm)	1.1	0.5
786005	Inflatable Purge Star 10" (250 mm)	1.2	0.5
Double Hose			
786006	Inflatable Purge Star 12" (300 mm)	1.7	0.7
786007	Inflatable Purge Star 14" (350 mm)	1.9	0.8
786008	Inflatable Purge Star 16" (400 mm)	2.0	0.9



Ring Purge

INFLATABLE PURGE DAMS
18" - 80" (450 - 2000MM)
PIPE & TUBING

NEW!

- ✓ Double hose inflation:
Red for dam inflation;
Black for weld chamber
- ✓ Exclusive dam dump valve deflates dam quickly after weld is completed
- ✓ High temperature resistant Proban & fire resistant fabrics
- ✓ Purge 36" pipe to less than 1% oxygen content in 10 minutes
- ✓ Dramatic savings in argon
- ✓ High quality weld results
- ✓ Designed for years of use



Preset valve fills weld chamber

Argon outlet with diffuser



Centering glow indicator

Chamber vent port

Part No.	Description	Weight	
		lbs	kg
786009	Inflatable Ring Purge 18" (450 mm)	6.0	2.7
786010	Inflatable Ring Purge 20" (500 mm)	6.0	2.7
786011	Inflatable Ring Purge 22" (550 mm)	6.0	2.7
786012	Inflatable Ring Purge 24" (600 mm)	8.0	3.6
786013	Inflatable Ring Purge 26" (650 mm)	8.0	3.6
786014	Inflatable Ring Purge 28" (700 mm)	9.0	4.1
786015	Inflatable Ring Purge 30" (750 mm)	9.0	4.1
786016	Inflatable Ring Purge 32" (800 mm)	12.0	5.4
786017	Inflatable Ring Purge 34" (850 mm)	15.0	6.8
786018	Inflatable Ring Purge 36" (900 mm)	18.0	8.2
786021	Inflatable Ring Purge 42" (1050 mm)	20.0	9.1
786024	Inflatable Ring Purge 48" (1200 mm)	24.0	10.9
786028	Inflatable Ring Purge 56" (1422 mm)	27.0	12.2
786030	Inflatable Ring Purge 60" (1524 mm)	32.0	14.5
786036	Inflatable Ring Purge 72" (1828 mm)	36.0	16.3
786040	Inflatable Ring Purge 80" (2031 mm)	40.0	18.1
779281	Argo-Naught weld gas analyzer	1.3	0.6

Additional sizes available upon request.

The "open-bore" design of the Ring Purge reduces purge area resulting in less volume of inert gas required.

Weld Gas Analyzer

Accurately Monitor Oxygen Levels For Critical Welding Applications



- ✓ Hermetically sealed, robust housing
- ✓ Air and water-tight
- ✓ State of the art electronics
- ✓ High measurement accuracy
- ✓ Quick response time
- ✓ Clear, large display
- ✓ Increased sensor life expectancy



Argo-Naught Weld Gas Analyzer Kit includes case, Argo-Naught Analyzer, 2 AA batteries, 6-1/2' (2 m) rubber hose, stainless steel probe & rubber vacuum bulb.

How Weld Gas Analyzers Work

Argo-Naught
Weld Gas Analyzer
Part No. 779281

The Argo-Naught Weld Gas Analyzer accurately monitors oxygen levels while using inert gas to purge stainless steel, titanium and other reactive metal. The Argo-Naught Weld Gas Analyzer measures oxygen content in the weld chamber down to 0.1% (1000 ppm), helps save on argon gas consumption and increases the welder's production rate.

WELDING CYLINDER CARTS

SUMNER



Small Single Cylinder Cart
Heavy Duty Single Cylinder Carts
Small-Medium High Rail Cylinder Carts
Medium Range High Rail Cylinder Carts
Full Range High Rail Cylinder Carts


Small Single Cylinder Cart (Model #108)		
	Part No.	782375
	Model #	108-8S
	Cylinders	40 cf. Acetylene OR 50 to 80 cf Oxygen
	Wheel PN	779024
	Wheel Type	8" semi-pneumatic
	Chain/Bar	Chain
	Lifting Eye	No
	Firewall	No
	Height	40.0" (101.6 cm)
	Depth	12.3" (31.2 cm)
	Width	12.1" (30.7 cm)
	lbs	11.0
kg	5.0	

HD Single Cylinder Cart (Model #112)			
	Part No.	782386	782385
	Model #	112-10P	112-10S
	Cylinders	75 cf. Acetylene OR 80 to 150 cf Oxygen	
	Wheel PN	779027	779011
	Wheel Type	12" pneumatic	12" semi-pneu.
	Chain/Bar	Chain	
	Lifting Eye	No	
	Firewall	No	
	Height	49.4" (125.5 cm)	
	Depth	18.1" (46.0 cm)	18" (45.7 cm)
	Width	20.8" (52.8 cm)	19.1" (48.6 cm)
	lbs	30.0	36.0
kg	13.6	16.4	
Base Plate: 7" x 14" (178 x 356 mm) Load Capacity: 500 lbs (225 kg)			

Small-Med High Rail Cylinder Carts (Model #207)			
	Part No.	782359	782360
	Model #	207-10S	207-8S
	Cylinders	40 cf. Acetylene & 50 to 80 cf Oxygen	
	Wheel PN	779011	779031
	Wheel Type	10" semi-pneu.	8" semi-pneu.
	Chain/Bar	Chain	
	Lifting Eye	No	
	Firewall	No	
	Height	41.0" (104.1 cm)	
	Depth	22.8" (57.8 cm)	21.8" (55.2 cm)
	Width	13.8" (34.9 cm)	12.8" (32.3 cm)
	lbs	30.0	30.0
kg	13.6	13.6	
Base Plate: 7.5" x 15.5" (190 x 394 mm)			

Small-Med High Rail Cylinder Carts (Model #208)			
	Part No.	782380	782379
	Model #	208-10S	208-8S
	Cylinders	75 cf. Acetylene & 80 to 150 cf Oxygen	
	Wheel PN	779011	779031
	Wheel Type	10" semi-pneu.	8" semi-pneu.
	Chain/Bar	Chain	
	Lifting Eye	No	
	Firewall	No	
	Height	49.5" (125.7 cm)	
	Depth	23" (58.4 cm)	22" (55.9 cm)
	Width	18.3" (46.4 cm)	
	lbs	40.0	40.0
kg	18.1	18.1	
Base Plate: 8" x 17" (203 x 432 mm)			


Medium Range, High Rail Cylinder Cart w/ Chain (Model #209)

	Part No.	782424	782420	782422	782426	782428
	Model #	209-14S	209-10S	209-10P	209-16P	209-16F
	Cylinders	244 to 330 cf Oxygen & 145 cf Acetylene				
	Wheel PN	779028	779011	779027	779107	779104
	Wheel Type	14" semi-pneu.	10" semi-pneu.	10" pneumatic	16" pneumatic	16" flat free
	Chain/Bar	Chain				
	Lifting Eye	No				
	Firewall	No				
	Height	43.6" (110.7 cm)				
	Depth	16.9" (42.9 cm)			18.27" (46.4 cm)	
	Width	28" (71 cm)			32.5" (82.6 cm)	
	lbs	47	48	40	53	54
kg	21.4	21.8	18.2	24.1	24.5	

782424
209-14S

Base Plate: 9" x 18" (229 x 457 mm)

Medium Range, High Rail Cylinder Cart w/ Bar (Model #209)

	Part No.	782425	782421	782427
	Model #	209-14SB	209-10SB	209-16PB
	Cylinders	244 to 330 cf Oxygen & 145 cf Acetylene		
	Wheel PN	779028	779011	779107
	Wheel Type	14" semi-pneu.	10" semi-pneu.	16" pneumatic
	Chain/Bar	Bar		
	Lifting Eye	No		
	Firewall	No		
	Height	43.6" (110.7 cm)		
	Depth	16.9" (42.9 cm)		18.27" (46.4 cm)
	Width	28" (71 cm)		32.5" (82.6 cm)
	lbs	48	49	54
kg	21.8	23.3	24.5	



782420
209-10S



782422
209-10P



782421
209-10SB




782427
209-16PB

782425
209-14SB

Base Plate: 9" x 18" (229 x 457 mm)

Medium Range, High Rail Cylinder Cart w/ Lifting Eye & Firewall (Model #209)

	Part No.	782443	782444	782439
	Model #	209-16PB-LF	209-16FB-LF	209-14SB-LF
	Cylinders	244 to 330 cf Oxygen & 145 cf Acetylene		
	Wheel PN	779107	779104	779028
	Wheel Type	16" pneumatic	16" flat free	14" semi-pneu.
	Chain/Bar	Bar		
	Lifting Eye	Yes		
	Firewall	Yes		
	Height	66" (167.6 cm)		
	Depth	18.4" (46.7 cm)		17" (43.2 cm)
	Width	32.4" (82.3 cm)		27.5" (69.9 cm)
	lbs	75.5	74	81
kg	34.2	33.6	36.7	



782426
209-16P



782428
209-16F



782444
209-16FB-LF



782439
209-14SB-LF

782443
209-16PB-LF

Base Plate: 9" x 18" (229 x 457 mm)

** Lifting eye carts comply with ASME B30.20, AWS D14.1 and AISC codes.

*** Fire-rated wall complies with OSHA 1926.350 & OSHA 1910.253.

Full Range, High Rail Cylinder Cart w/ Chain (Model #213)

	Part No.	782480	782475	782482
	Model #	213-14S	213-25W	213-16P
	Cylinders	244 to 330 cf Oxygen & 210 to 420 cf Acetylene		
	Wheel PN	779028	782575	779107
	Wheel Type	14" semi-pneu.	25" steel	16" pneumatic
	Chain/Bar	Chain		
	Lifting Eye	No		
	Firewall	No		
	Height	44.6" (113.3 cm)		
	Depth	20.3" (51.6 cm)	26.75" (67.9 cm)	22.1" (56.1 cm)
	Width	31.8" (80.8 cm)	33.6" (85.4 cm)	36.5" (92.7 cm)
	lbs	53	69	59
	kg	24	31.3	26.8

782480
213-14S



782475
213-25W



782482
213-16P

Base Plate: 13" x 25" (330 x 630 mm)

Full Range, High Rail Cylinder Cart w/ Bar (Model #213)

	Part No.	782483
	Model #	213-16PB
	Cylinders	244 to 330 cf Oxygen & 210 to 420 cf Acetylene
	Wheel PN	779107
	Wheel Type	16" pneumatic
	Chain/Bar	Bar
	Lifting Eye	No
	Firewall	No
	Height	44.6" (113.3 cm)
	Depth	22.1" (56.1 cm)
	Width	36.5" (92.7 cm)
	lbs	61
	kg	27.7

782483
213-16PB

Base Plate: 13" x 25" (330 x 630 mm)



782495
213-16PB-LF



782497
213-25PB-LF



782476
213-25WB-LF



782491
213-14SB-LF

Full Range, High Rail Cylinder Cart w/ Lifting Eye & Firewall (Model #213)

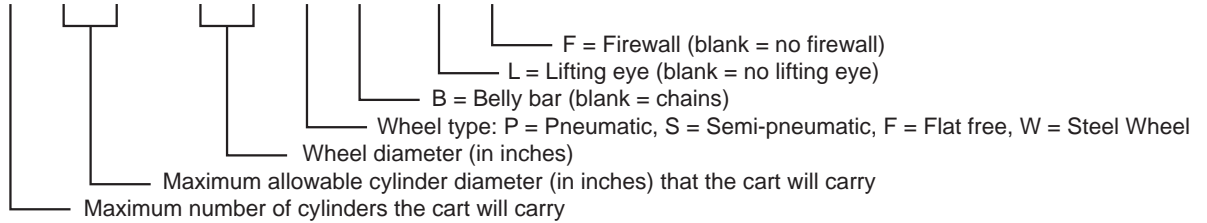
	Part No.	782496	782495	782497	782476	782491
	Model #	213-16FB-LF	213-16PB-LF	213-25PB-LF	213-25WB-LF	213-14SB-LF
	Cylinders	244 to 330 cf Oxygen & 210 to 420 cf Acetylene				
	Wheel PN	779104	779107	780521	782575	779028
	Wheel Type	16" flat free	16" pneumatic	25" pneumatic	25" steel	14" semi-pneu.
	Chain/Bar	Bar				
	Lifting Eye	Yes				
	Firewall	Yes				
	Height	66.5" (168.9 cm)				
	Depth	22.1" (56.1 cm)		27.1" (68.8 cm)	26.75" (67.9 cm)	20.5" (52.1 cm)
	Width	36.8" (93.5 cm)			33.6" (85.4 cm)	31.8" (80.8 cm)
	lbs	109	109	152	115	103
	kg	49.4	49.4	69.1	52.2	46.7

782496
213-16FB-LF

Base Plate: 13" x 25" (330 x 630 mm)

How To Read Sumner Cylinder Cart Product Descriptions

X X X - X X X X - X X



EXAMPLE: cart part number 782496, 213-16FB-LF

- 2 = carries two cylinders
- 13 = 13 inch maximum cylinder diameter
- 16 = 16 inch wheel size
- F = Flat free tire
- B = Belly bar
- L = Lifting eye
- F = Firewall

Wheel					
Part No.	779024	779031	779011	779027	779028
Diameter	8" (200 mm)	8" (200 mm)	10" (250 mm)	10" (250 mm)	14" (355 mm)
Width	1.75" (44 mm)	2" (50 mm)	2.75" (70 mm)	3.5" (89 mm)	1.75" (44 mm)
Bore	0.5" (13 mm)	0.5" (13 mm)	5/8" (16 mm)	5/8" (16 mm)	5/8" (16 mm)
Bearing	Powder metal bushing	Steel bushing	Bronze bushing	Bronze bushing	Bronze bushing
Description	Semi-pneumatic	Semi-pneumatic	Semi-pneumatic	Pneumatic	Semi-pneumatic
Load Capacity	80 lbs (36.2 kg)	400 lbs (180 kg)	400 lbs (180 kg)	350 lbs (150 kg)	150 lbs (65 kg)
Fits Sumner Cart(s)	108, 207, 208	207, 208	112, 207, 208, 209	112, 209	209, 213

Wheel				
Part No.	779104	779107	780521	782575
Diameter	16" (400 mm)	16" (400 mm)	25" (635 mm)	25" (635 mm)
Width	4.8" (120 mm)	4.8" (120 mm)	4" (100 mm)	2" (50 mm)
Bore	1" (25 mm)	1" (25 mm)	1.25" (32 mm)	1.25" (32 mm)
Bearing	Powder metal bushing	Powder metal bushing	Bronze bushing	Bronze bushing
Description	Flat free	Pneumatic	Pneumatic	Steel
Load Capacity	380 lbs (170 kg)	380 lbs (170 kg)	800 lbs (360 kg)	800 lbs (360 kg)
Fits Sumner Cart(s)	209, 213	209, 213	213	213

View video demonstrations of
Sumner's welding tools at the online
Sumner Video Library



CE All Sumner tools comply with CE regulations.

SUMNER

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