

ADDISON TUBE FORMING LIMITED MACHINE TECHNICAL SPECIFICATION

Machine Type	DB 76	Coding	B076--*30-D-**
Serial No		Customer	

Capacity

Tube outside diameter	Standard	76 mm	MAX
" " "	Stack	N/A mm	MAX
" " "		20 mm	MIN
Tube wall thickness		3 mm	MAX
Centerline radius		250 mm	MAX
" " "		0 mm	MIN
Bend arm rotation (i.e. bend angle)	C axis	193 deg	MAX
Length of tube over the mandrel rod into the collet	Y axis	3000 mm	MAX
Length of tube into the collet before last bend - <i>subject to tooling limitations.</i>		80 mm	MIN
Tube working height		1015 mm	
Tube height from tooling platform	Lower	50 mm	
" " " " "	Middle	N/A mm	
" " " " "	Upper	N/A mm	
Mandrel retraction stroke		150 mm	
Follower slide stroke		600 mm	
Clamp slide stroke - <i>direct acting only</i>		N/A mm	
Reaction slide stroke		100 mm	
Vertical shift pitch	1 st	N/A mm	
" " "	2 nd	N/A mm	
Horizontal shift	X axis	N/A mm	
Difference between tooling radii		N/A mm	MAX
Flange outside diameter		N/A mm	MAX
Flange offset from the standard tube end datum	Primary	N/A mm	

Axis specification

AXIS	SPEED 100%	UNITS	RESOLUTION	UNITS	REPEATABILITY	UNITS
Y - feed	60	M/min.	.008	mm/count	0.05	mm
B - rotate	50	r.p.m.	.0061	°/count	0.05	degrees
C - bend	13	r.p.m.	.0062	°/count	0.05	degrees
X - radius	N/A	M/min.		mm/count	0.05	mm

Hydraulics

Hydraulic tank capacity	530	litres	Total machine kVA @ 415V	38
Hydraulic system pressure	150	bar	C axis stall torque kNm	12.7

Dimensions

Overall length to the rear from tool post	5200 mm
Bend arm radius (<i>clamp out</i>)	700 mm
Length forwards from tool post	150 mm
Length of reaction arm - <i>at MAX. center line radius from Y axis center</i>	1300 mm
Overall width	1930 mm
Overall height	1800 mm
Machine weight	4500 Kg (Est.)

Machine capacity figures are based on using material to the specification of BS3602 part 1:1987 having a mean tensile strength of 450 N/mm² bent at a radius of 2 times the outside diameter.
This document has been compiled in good faith. (Errors and omissions excepted)
This information applies to machines manufactured after serial number - 9338

Compiled by :-