

ADDISON TUBE FORMING LIMITED
MACHINE TECHNICAL SPECIFICATION - PROVISIONAL

Machine Type	DB 25	Coding	B025--D30-D-**
Serial No		Customer	

Capacity

Tube outside diameter	Standard	25 mm	MAX
" " "	Stack	N/A mm	MAX
" " "		4 mm	MIN
Tube wall thickness		3 mm	MAX
Centerline radius		100 mm	MAX
" " "		20 mm	MIN
Bend arm rotation (<i>i.e. bend angle</i>)	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>		50 mm	MIN
Tube working height		1015 mm	
Tube height from tooling platform	Lower	30 mm	
" " " " "	Middle	N/A mm	
" " " " "	Upper	N/A mm	
Mandrel retraction stroke		100 mm	
Follower slide stroke		250 mm	
Clamp slide stroke - <i>direct acting only</i>		N/A mm	
Reaction slide stroke		60 mm	
" " "		3 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	80	M/min.		mm/count	0.05	mm
B - rotate	60	r.p.m.		°/count	0.05	degrees
C - bend	40	r.p.m.		°/count	0.05	degrees
X - radius		M/min.		mm/count	0.05	mm

Hydraulics

Hydraulic tank capacity		litres	Total machine kVA @ 415V	15
Hydraulic system pressure	150	bar	C axis stall torque kNm	1.3

Dimensions

Overall length to the rear from tool post		mm
Bend arm radius (<i>clamp out</i>)		mm
Length forwards from tool post		mm
Length of reaction arm - <i>at MAX. center line radius from Y axis center</i>		mm
Overall width		mm
Overall height		mm
Machine weight	1700	KG

Machine capacity figures are based on using material to the specification of BS3002 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 :-