

ADDISON TUBE FORMING LIMITED

MACHINE TECHNICAL SPECIFICATION.

Machine Type	DB 40	Coding	B040-*40-D-**
Serial No		Customer	

Capacity

Tube outside diameter	Standard	40 mm	MAX
" " "	Stack	N/A mm	MAX
" " "		8 mm	MIN
Tube wall thickness		3 mm	MAX
Centerline radius		200 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	4000 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	LOWER
Tube height from tooling platform	Lower	30 mm	
" " " " "	Middle	N/A mm	
" " " " "	Upper	N/A mm	
Mandrel retraction stroke		100 mm	
Follower slide stroke		400 mm	
Clamp slide stroke - <i>direct acting only</i>		N/A mm	
Reaction slide stroke		70 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	70	M/min.	.008	mm/count	0.05	mm
B - rotate	60	r.p.m.	.0061	°/count	0.05	degrees
C - bend	40	r.p.m.	.0062	°/count	0.05	degrees
X - radius		M/min.		mm/count	0.05	mm

Hydraulics

Hydraulic tank capacity	530	litres	Total machine kVA @ 415V	25
Hydraulic system pressure	150	bar	C axis stall torque kNm	3.66

Dimensions

Overall length to the rear from tool post	5655 mm
Bend arm radius (clamp out)	495 mm
Length forwards from tool post	110 mm
Length of reaction arm - <i>at MAX. center line radius from Y axis center</i>	600 mm
Overall width	1640 mm
Overall height	1500 mm
Machine weight	3500 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 :-