

ADDISON TUBE FORMING LIMITED MACHINE TECHNICAL SPECIFICATION.

Machine Type	DB 120	Coding	B120-R60-D-**
Serial No		Customer	

Capacity

Tube outside diameter	Standard	114 mm	MAX
" " "	Stack	N/A mm	MAX
" " "		N/A mm	MIN
Tube wall thickness		8.5 mm	MAX
Centerline radius		600 mm	MAX
" " "		50 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	6000 mm	MAX
Length of tube into the collet before last bend (Large Collet)- <i>subject to tooling limitations.</i>		375 mm	MIN
Length of tube into the collet before last bend (Small Collet)- <i>subject to tooling limitations.</i>		150 mm	MIN
Tube working height		1200 mm	
Tube height from tooling platform	Lower	95 mm	
" " " " "	Middle	N/A mm	
" " " " "	Upper	N/A mm	
Mandrel retraction stroke		1000 mm	
Follower slide stroke		1000 mm	
Clamp slide stroke - <i>direct acting only</i>		229 mm	
Reaction slide stroke		260 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		250 mm	MAX
Flange offset from the standard tube end datum	Primary	105 mm	

Axis specification

AXIS	SPEED 100%	UNITS	RESOLUTION	UNITS	REPEATABILITY	UNITS
Y - feed	10	M/min.	.025	mm/count	0.05	mm
B - rotate	6	r.p.m.	.025	°/count	0.05	degrees
C - bend	3.5	r.p.m.	.025	°/count	0.05	degrees
X - radius	N/A	M/min.	N/A	mm/count	0.05	mm

Hydraulics

Hydraulic tank capacity	660	litres	Total machine kVA @ 415V	64
Hydraulic system pressure	140	bar	C axis stall torque kNm	69 at 170 bar

Dimensions

Overall length to the rear from tool post	10400 mm
Bend arm radius (clamp out)	1650 mm
Length forwards from tool post	400 mm
Length of reaction arm - <i>at MAX. center line radius from Y axis center</i>	2720 mm
Overall width	3500 mm
Overall height	2000 mm
Machine weight	11000 Kg

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 :-