

T BEND - MANDREL BENDING MACHINES COMPACT AND VERY EFFICIENT.



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The compact mandrel bending machines can now be controlled easily with a touch panel. This opens up new possibilities, like displaying the comparison of target and actual values for all axes. Control of the length and the rotation means very little involvement for the operator during the manufacture of tubes. And users now have the option to load the bending data for individual products from a PC via a USB port.

The machines are extremely robust and easy to operate. A selection of setups is available to process tubes of different lengths, with an operational length up to 6 m.

Accessories are available, like an integrated saw, a de-burring device, a flaring tool, and a compression-fitting swaging tool. These accessories are available with all standard diameters or hydraulic tubing (6 mm to 42 mm). All compact mandrel bending machines can bend up to 180°. Radii of 1.5 or 2 times the diameter of the tube are common in this application and easy to achieve with these machines.



T BEND - MANDREL BENDING MACHINES

FULL HYDRAULIC WITH PLC-CONTROL

CONTROLLED
MANDREL WITHDRAWAL

DIFFERENT ARBOR LENGTH

MANDREL SUPPORT

COLLET CHUCK
For 360° rotation by scale,
with 4 adjustable stops

PROGRAMMABLE LOGIC CONTROL
Touch panel

FOLLOWING PRESSURE DIE
CARRIAGE FOR WIPER DIE

ADDITIONAL EQUIPMENT

- De-burring machine
- Electro hydraulic combination
- Carriage for cutting ring pre-assembling
- Carriage for flaring

MACHINE MOBILE
on wheels

MANDREL LUBRICATION

COMPACT MANDREL BENDING MACHINES

Compact and very efficient. Our fully hydraulic mandrel bending machine delivers outstanding bend quality and very simple handling, with PLC control for preselection and storage of bending angles via a touch panel.

With the appropriate tool, it is possible to bend rectangular or square tubes. The machine is equipped with a following pressure die and an internal tool locking system. Tight radii from 1.5xD with perfect bend quality can be achieved.

OUR PORTFOLIO OF MACHINES



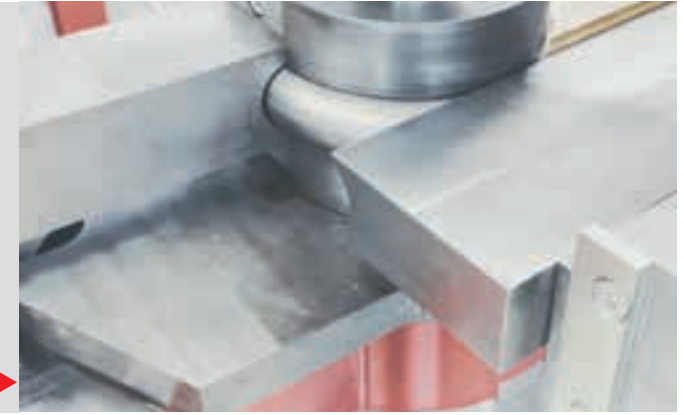
Type	DB 642-K	DB 2076-K	DB 20101-K
Range	6-42,4 mm	6-76,1 mm	6-101,6 mm
Max. capacity	42 x 5 mm (mild steel) 42 x 3 mm (stainless steel) 25 x 3,2 mm (Square section)	76,1 x 3 mm (mild steel) 76,1 x 2 mm (stainless steel) 50 x 5 mm (Square section)	101,6 x 3,5 mm (mild steel) 101,6 x 2 mm (stainless steel) 80 x 4 mm (Square section)
Max. Radii	105 mm	150 mm	300 mm
Usable length	1500 mm 3048 mm (standard) 4572 mm 6096 mm	1500 mm 3048 mm (standard) 4572 mm 6096 mm	3048 mm (standard) 4572 mm 6096 mm
Speed of bending axis	13 °/sec.	10 °/sec.	11,5 °/sec.
Power bending axis	electro-hydraulic	electro-hydraulic	electro-hydraulic
Operating voltage	400 V - 50 Hz - 3 Ph. - 4 KW	400 V - 50 Hz - 3 Ph. - 4 KW	400 V - 50 Hz - 3 Ph. - 12 KW
Nominal pressure	250 bar, Operating pressure 200 bar	250 bar, Operating pressure 200 bar	250 bar, Operating pressure 200 bar
Length	4380 mm	4450 mm	5000 mm
Width	900 mm	900 mm	1400 mm
Height	1550 mm	1580 mm	1500 mm
Weight approx.	900 kg	1250 kg	3700 kg

BASIC EQUIPMENT:



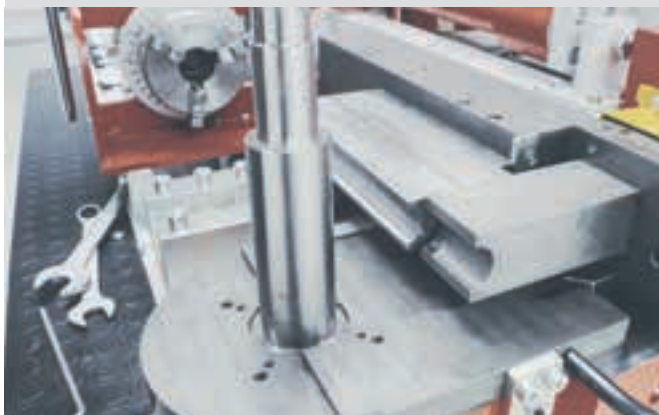
FOLLOWING PRESSURE DIE

Following pressure die for bends up to 180°
(for radii up to max. 2xD, for larger bending radii the pressure die can be repositioned to ensure a constant contact up to 180° bending angle).



HOLLOW SHAFT

Allows small-bend-radius tools.



EQUIPMENT:



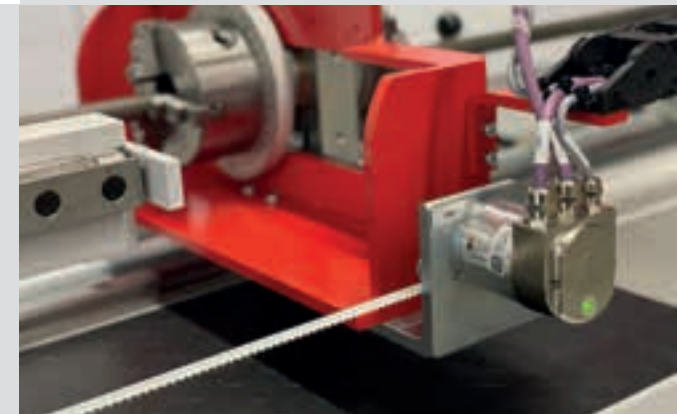
PROGRAMMABLE LOGIC CONTROL

- for compact mandrel bending machines
- With Programmable Logic Control (PLC)
- Possibility to store up to 20 bend angles to be called up individually or in sequence via Touch Panel
- Angle selection 0,1°
- Permanent showing of theoretical and actual bend angles
- Display of spring back
- Display of bending sequence
- Changeable spring back factor, to switch on/off
- With memory capacity of 500 tubes with 20 different positions
- Incl. USB Interface to import and export data



STANDARD COLLET CHUCK

- For 360° rotation by scale, with 4 adjustable stops
- With chuck clamp for all sizes up to 76,1 mm
- Inclusive length stop device with scale and 4 adjustable stops
- Usable length 6096 mm



QUICK-ACTION CHUCK

For holding individual collets (optional)



EQUIPMENT:

BENDING MANDRELS

Bending mandrels in different contours or materials.



MANDREL LUBRICATION

Lubrication via hand pump which is fixed in the bending area.
This unit is not usable for tube inside- \varnothing smaller than 13,5 mm.



WIPER DIE

Prevents the formation of wrinkles on the inside of the bend.





watch the
movie

ADVANTAGES AT A GLANCE:

- The solution for optimal sheet quality at an attractive price
- Mobile, movable machine suitable for maintenance and site piping
- Simple, intuitive control, touch screen incl. USB interface for data import/export
- Perfect sheet qualities with tight bending radii from 1.5xD
- 10° & 37° flaring function for systems available on the market, standard tools available on the market can be used
- Easy transport by rollers, crane eyes and forklift shoes
- Worldwide availability of standard electrical & hydraulic components



OPTIONAL EQUIPMENT:



CARRIAGE FOR CUTTING RING PRE-ASSEMBLING & FLARING

- For tubes from 6–42 mm Ø
- For pre-assembling single and multi bite rings according to DIN 2353



DE-BURRING MACHINE

Capacity:

- For tubes from 6 – 42 mm Ø

Machine equipment-/basic accessories:

- de-burring tools
- De-burring heads easily sharpened and adjusted
- Internal de-burring tool with 3 HSS edges
- External de-burring tool with 1 HSS edge



METAL-CUTTING SAW

- For tubes from 6–42 mm
- For integration in transfluid bending machine DB 642 K





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