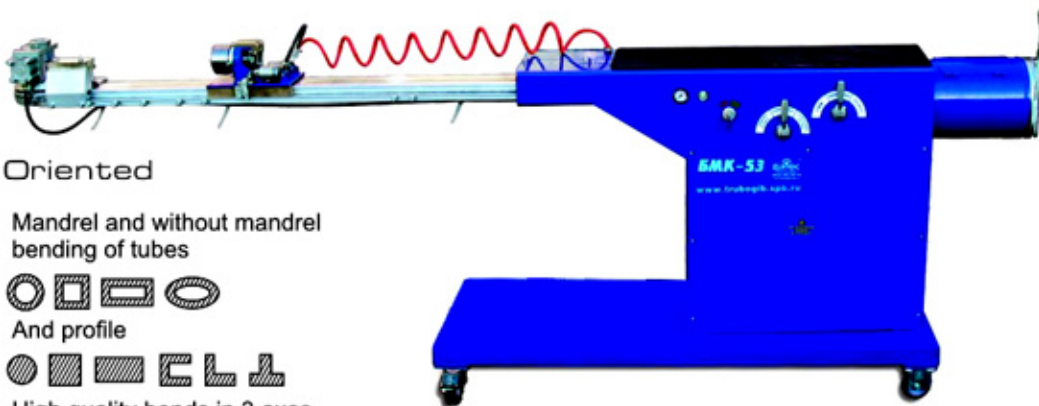


# Model - 53

Pneumatic bending machine



## Oriented

Mandrel and without mandrel bending of tubes



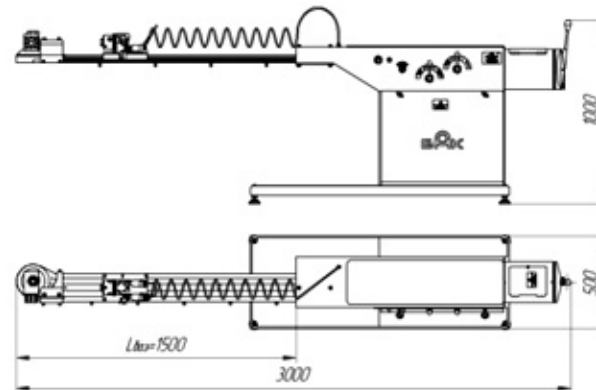
And profile



High quality bends in 3 axes by coiling method

## Abilities

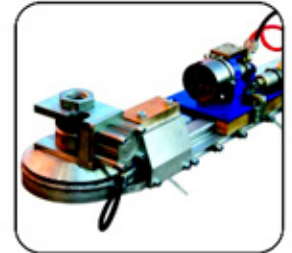
- 3 axes control (A;L;R)
- Exclusion of clash between machine and tube during complex bending
- Bending radius (CLR) is defined by machine construction and not variable
- Energy source - compressed air 6-8 atm
- Saves form of tube section in place of bend when you bend with mandrel



## Tooling

For without mandrel bending by coiling method consists of 3 elements:

- Former
- Clamp
- Pressure die



## Positioning Device

Clamps of tube end by lathe chuck

Allows to change bending plate (Tube rotation in space, (axis R) and exactly fix straight pieces size between bends (axis L)

## Technical data

Maximum tube diameter (D), mm	Up to 16
CLR, mm	27-80
CLR, min	1,5 D
Bending angel, degrees	0-180
Accuracy	
Bending angel (A), degrees	0,5
Tube advance (L), mm	0,5
Tube space rotation angel (R), degrees	2,5
Probability of parts repetition, %	99
Time of one bend, sec.	4-10
Tube space rotation (R)	Semiautomatic
Advance up to next bend (L)	Semiautomatic
Clamp	Automatic
Return to bend starting position	Automatic
Program by rests (single memory size) in axes	:
A	6
L (per running meter)	Up to 20
R	Up to 12
Productivity, bends / hour	Up to 200
Energy source - compressed air, kg/ sm <sup>2</sup>	6-8
LxHxB, mm	3000x1000x500
Weight, kg	100

## Base set

- Bending machine
- Position table 1,5 m
- Packing
- Operating manual
- Training to Customer's personnel

## Advanced options

- Machine adaptation for mandrel bending
- Modification (decrease or extension) of position table length
- Delivery of tooling (when you change size of tubes, but radius of bend (CLR) is invariable)
- Delivery of compressor
- Machine and tooling modification for bending without straight pieces between bends
- Increase of quantity of mechanical memory rests
- Machine adaptation for production of specific parts (more freedom for bend tube movement)



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