

# T-DRILL

PRODUCTIVITY AS A PRODUCT.



## COLLARING MACHINE

Transportable collaring machine

T-115 Cu

# T-115 Cu

## TRANSPORTABLE COLLARING MACHINE

The **T-DRILL T-115 Cu** is designed to meet the needs of copper product manufacturers in the HVAC business. The **T-115 Cu** is a transportable collaring station for extruding branch outlets in copper tubes in the range 22–267 mm. The system consists of a pilot hole cutter which creates a round pilot hole, and a collaring tool for diameter range of 18–108 mm.

Each collaring tool (collaring head) is adjustable within a specific range. The adjustment is made according to the branch tube outside diameter.



# T-115 Cu

## AVAILABLE ACCESSORIES



## T-115 Tube Measuring Table


**T-115** Measuring Table is used for controlled and precise axial- and radial positioning of pipes for collaring process. The measuring table is suitable for pipe diameters  $\text{Ø}33,7\text{-}323,9$  mm.

### Standard lengths for 3000mm / 6000 mm tubes

- For diameters  $\text{Ø}33,7\text{-}323,9$  mm and lengths min.  $3 \times \text{O.D.}$  of run tube (When working with other pipe dimensions, please contact **T-DRILL** Sales)

- Positioning tolerances:  
length  $\pm 0.5$  mm (machine);  $\pm 1.0$  mm (tube)  
angle  $\pm 0.5^\circ$  (machine);  $\pm 1.0^\circ$  (tube)
- The longitudinal and angular positions can be seen from the digital read-out

## T-115 Cu Capacity

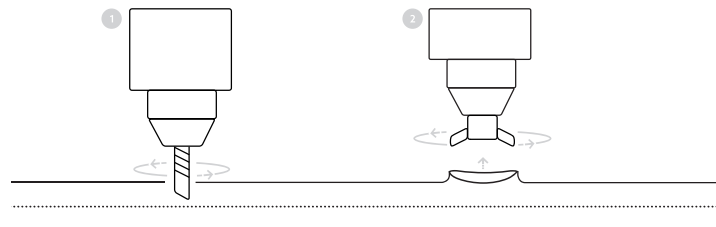
 Branch tube outside diameter

Run tube outside diameter	Branch tube outside diameter										
	mm	18	22	28	35	42	54	64	76,1	88,9	108
inch	5/8	3/4	1	1 1/4	1 1/2	2	2 1/2	3	3 1/2	4	
18 5/8	1,5 0.060	-	-	-	-	-	-	-	-	-	-
22 3/4	1,5 0.060	1,5 0.060	-	-	-	-	-	-	-	-	-
28 1	1,5 0.060	2,0 0.080	2,0 0.080	-	-	-	-	-	-	-	-
35 1 1/4	1,5 0.060	2,0 0.080	2,5 0.10	2,5 0.10	-	-	-	-	-	-	-
42 1 1/2	1,5 0.060	2,0 0.080	2,5 0.10	3 0.118	3 0.118	-	-	-	-	-	-
54 2	1,5 0.060	2,0 0.080	2,5 0.10	3 0.118	3,5 0.14	3,5 0.14	-	-	-	-	-
64 2 1/2	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	3,5 0.14	3,5 0.14	3,5 0.14	-	-	-	-
76,1 3	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	3,5 0.14	3,5 0.14	4,0 0.157	4,0 0.157	-	-	-
88,9 3 1/2	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	3,5 0.14	4,0 0.157	4,0 0.157	4,0 0.157	4,0 0.157	-	-
108 4	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	3,5 0.14	4,0 0.157	4,0 0.157	5,0 0.197	5,0 0.197	5,0 0.197	-
133 5	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	4,0 0.157	4,0 0.157	5,0 0.197	5,0 0.197	5,0 0.197	5,0 0.197	-
159 6	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	4,0 0.157	5,0 0.197	5,0 0.197	5,0 0.197	5,0 0.197	5,0 0.197	-
219,1 8	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	4,0 0.157	5,0 0.197	5,0 0.197	5,0 0.197	5,0 0.197	5,0 0.197	-
267 10	1,5 0.060	2,0 0.080	3 0.118	3,5 0.14	4,0 0.157	5,0 0.197	5,0 0.197	5,0 0.197	5,0 0.197	5,0 0.197	-

## THE T-DRILL PROCESS

1. Milling of the pilot hole

2. Collaring process



## DO IT WITH T-DRILL

Cut costs – Improve quality – Increase profit

- No T-fittings
- No costly inventories
- No tube cutting

- Only one brazed joint
- Minimized inspection cost
- Tee ratio variation flexibility

- Smaller risk of leakage or call-backs
- Optimized flow-characteristics

MANUFACTURER:

### T-DRILL

T-DRILL OY  
Ampujantie 32  
66400 Laihia, FINLAND  
Tel. +358 6 475 3333  
sales@t-drill.fi  
www.t-drill.com

REPRESENTED BY:

T-DRILL Industries Inc.

1740 Corporate Drive,  
Suite #820, Norcross,  
Georgia 30093 USA  
Tel. 800-554-2730  
sales@t-drill.com  
www.t-drill.com