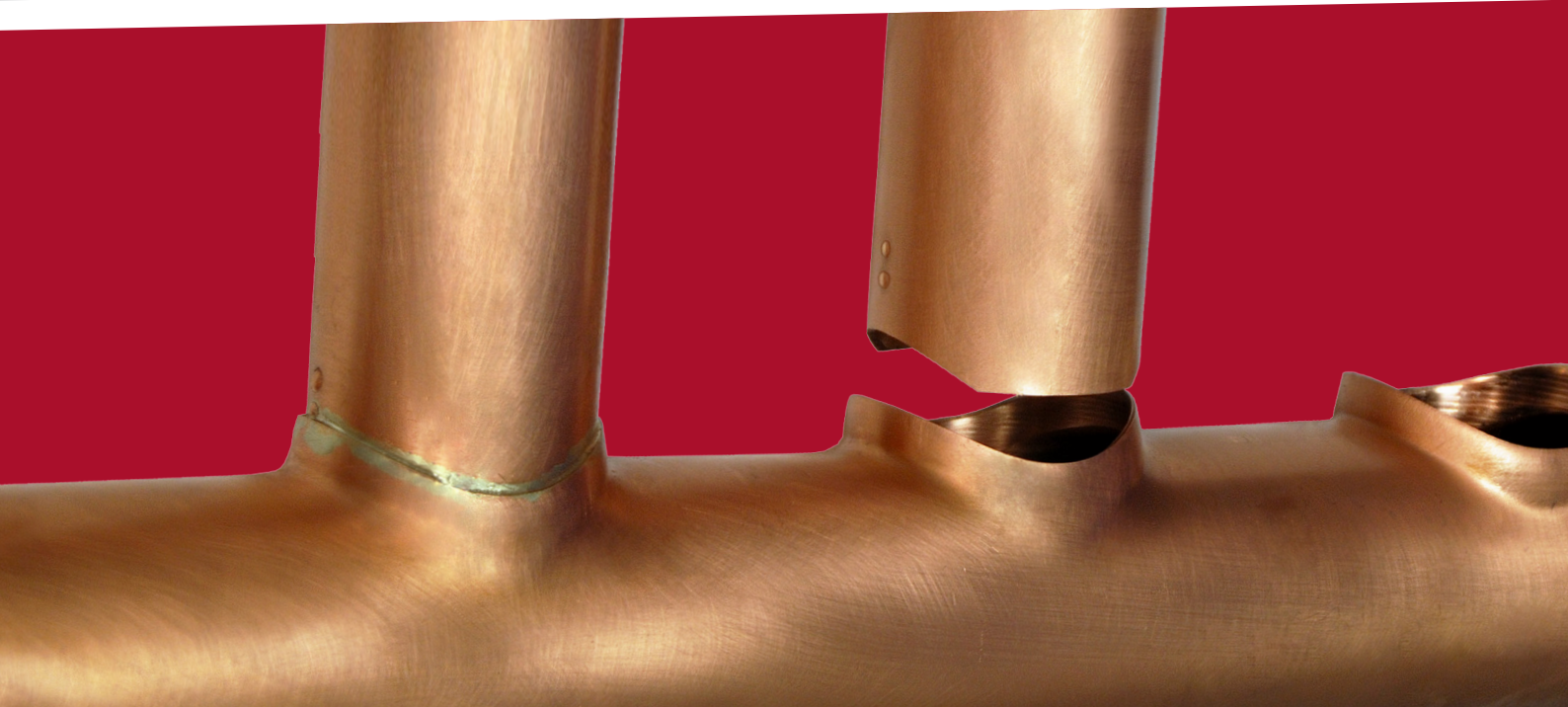


T-DRILL

PRODUCTIVITY AS A PRODUCT.



COLLARING UNIT

Manual Feed Table for Collaring Machine S-54

S-54 MFT

S-54 MFT - MANUAL FEED TABLE SOLUTIONS FROM T-DRILL

The **S-54** Manual Feed Table is user friendly, safe and ergonomic system for manifold/collector production. The system is easy to understand and operate. Standard modules according to max. tube lengths are 1500, 2500, 3500 and 4500 mm. Additionally it is possible to customize the module up to 6 500 mm long tubes.

The **S-54** machine with **MFT** is capable to produce $\varnothing 6$ -54 mm (1/4 to 2 1/8) collars in run tubes $\varnothing 8$ -108 mm (5/16 to 4 1/8). Suitable for copper, aluminium, steel, stainless steel, brass and other malleable materials.

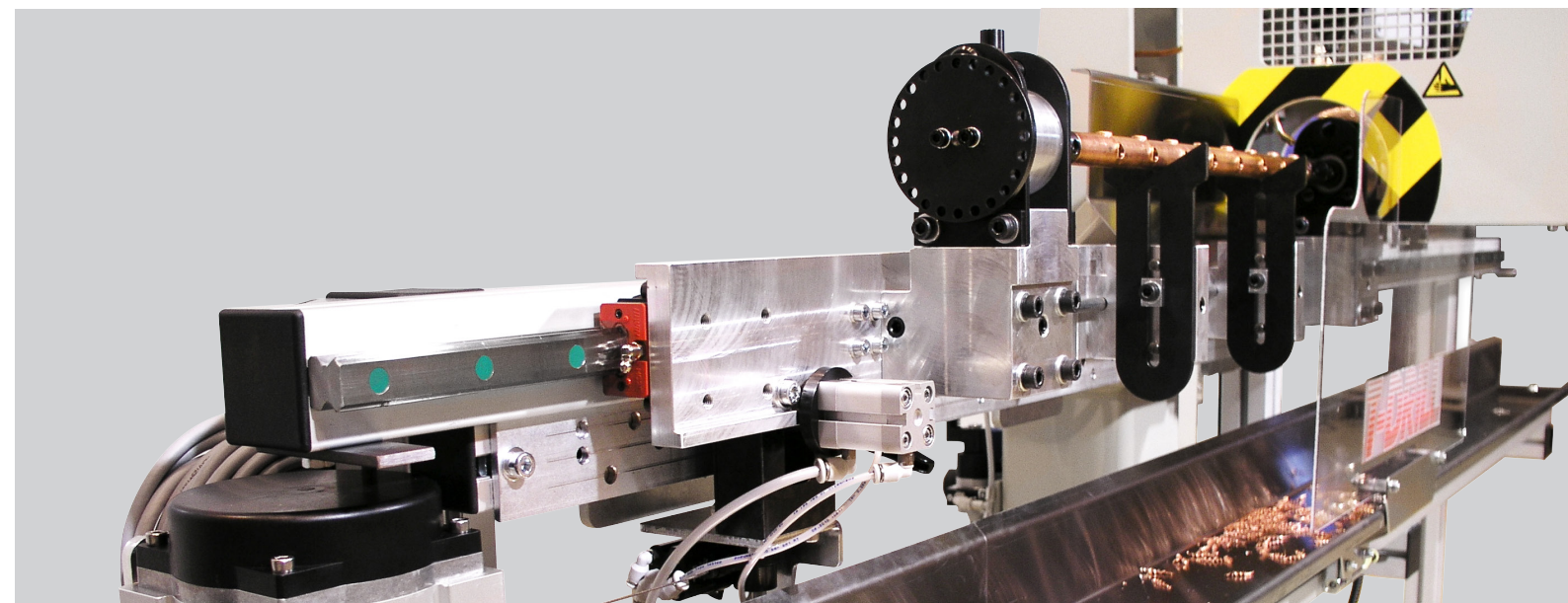
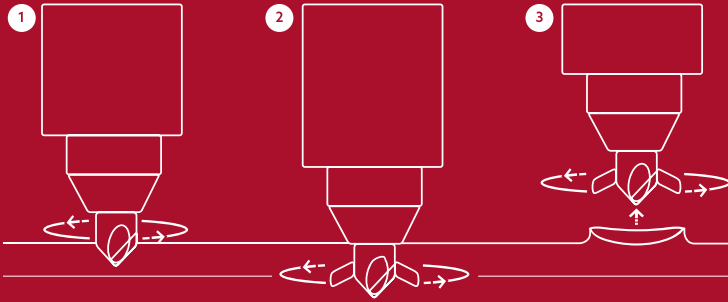


THE T-DRILL PROCESS

1. Drilling of pilot hole

2. Extension of forming pins

3. Finished collar



With the standard MFT it is possible to make the positioning of collars on the whole tube length by using pre-drilled templates (three pcs.), or by using the pneumatic foot brake pedal. Optionally there is a digital measuring device available, which shows the axial positioning of the collars from the display. The tube can be rotated at standard intervals of 15 degrees. Using different templates makes any angle possible. Changing of the templates is quick and easy!

In some cases, it is possible to handle complex bent tubes with the MFT system. In these special cases we are pleased to help you to find the best solution for your application.

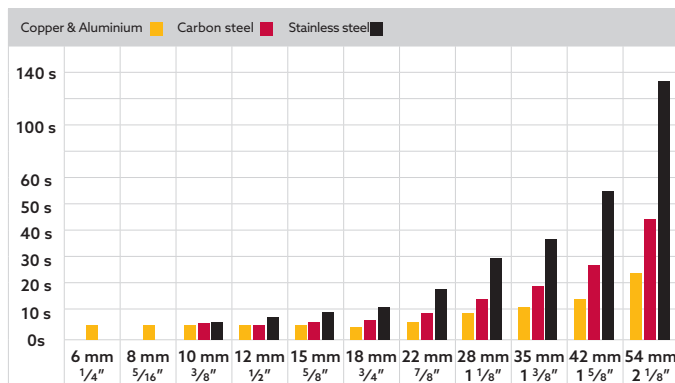
Technical data

	Copper/Aluminium	Steels
Collaring range	6-54 mm / 1/4" - 2 1/8"	10-54 mm / 3/8" - 2 1/8"
Run tube range	8-108 mm / 5/16" - 4 1/8"	10-108 mm / 3/8" - 4 1/8"
Rated power	3 kW	3 kW
Air supply	6 bar/90 psi	6 bar/90 psi
Air consumption	50 l/min / 1.765 ft ³ /min	50 l/min / 1.765 ft ³ /min
Weight (basic unit)	200 kg/450 lbs	200 kg/450 lbs
Noise level	<70dB(A)	<70dB(A)

The information included in this brochure is subject to revision without notice. In addition, many pipe walls thicker than the ones mentioned in the capacity table are suitable for **S-54 HD** (heavy duty) collaring process.

In case of thicker pipe walls - please contact T-DRILL sales!

Collaring times



Max wall thickness for copper

Run tube outside diameter	Branch tube outside diameter										
	6 mm	8 mm	10 mm	12 mm	15 mm	18 mm	22 mm	28 mm	35 mm	54 mm	
8 mm	0.5	0.5									
10 mm	0.8	0.8	1.0								
12 mm	0.8	1.0	1.0	1.0							
15 mm	0.8	1.0	1.0	1.0	1.2						
18 mm	0.8	1.0	1.0	1.0	1.2	1.2					
22 mm	0.8	1.0	1.2	1.2	1.5	1.5	1.5				
28 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	1.5			
35 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	1.5		
54 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	2.0	2.0	
79 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	2.5	2.0	
104 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	2.5	2.0	

Max wall thickness for steels

Run tube outside diameter	Branch tube outside diameter										
	10 mm	12 mm	15 mm	18 mm	22 mm	28 mm	35 mm	54 mm			
10 mm	0.8										
12 mm	0.8	0.8									
15 mm	1.0	1.0	1.0								
18 mm	1.0	1.0	1.2	1.0							
22 mm	1.0	1.0	1.2	1.2	1.2						
28 mm	1.0	1.0	1.2	1.2	1.2	1.2					
35 mm	1.0	1.0	1.2	1.2	1.4	1.2	1.2				
42 mm	1.0	1.0	1.2	1.2	1.4	1.4	1.4				
54 mm	1.0	1.0	1.2	1.4	1.4	1.4	1.4	1.2			
79 mm	1.0	1.0	1.2	1.4	1.6	1.6	1.6	1.6	1.6		
104 mm	1.0	1.0	1.2	1.4	1.6	1.6	1.6	1.6	1.6		

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
- Reduces working time

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

MANUFACTURER:

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