

T-DRILL

PRODUCTIVITY AS A PRODUCT.

Industry 4.0 ready



COLLARING MACHINE

Specially designed for collaring of bent tubes

S-28

THE S-28 COLLARING MACHINE

T-DRILL S-28 is a slim collaring machine that is designed especially for bent tubes with tight curves when S-56 is not suitable.

S-28 is equipped with the newest technology, robust construction, and clamping. Accurate servo-controlled movements ensure the best possible collaring result.

S-28 is capable of producing collars for copper, aluminum, steel, stainless steel, brass, and other malleable materials. Collar sizes from 6 to 28 mm.

- Industry 4.0 ready machine: very versatile and easily customized to fit specific customer needs
- Designed for producing T-outlets for brazed and welded joints on both straight and bent tubes
- Collar sizes Ø 6 mm – Ø 28 mm
- User-friendly GUI interface with color touch panel
- Adjustable machining parameters & fine-tuning of motion profiles
- Easier welding (butt weld outlet vs nozzle weld)

Enables three types of processes:

1. Drilling/collaring – Used for lap joint method
2. Drilling/collaring/trimming – Used for butt weld method
3. Elliptical pilot hole - Used for butt weld method.
Elliptical pilot hole is done beforehand with laser, plasma, milling or with punching machine. Enables 1:1 collaring.

Technical data

Collaring range (Drilling/collaring/trimming)	Collaring range (Elliptical pilot hole)	Collaring range (Drilling/collaring)	Materials for work piece	Diameter of run tube	Compressed air supply
O.D. Ø12-30 mm (½"-1 ⅝")	O.D. Ø17,2-30 mm (¾"- 1 ⅝")	I.D. Ø6-28 mm (¼"-1 ⅝")	Fe, Stainless Steel, Al, Cu, CuNi	O.D. Ø8-30 mm (5/16"-1 ⅝")	6 bar 87 psi
Air consumption (basic machine only)	Rated power	Fuses	Supply voltage	Machine dimension (with safety fences) H x W x D	Machine weight (with safety fences)
55 l/min 14.5 GPM	4 kW	16 A	400 V / 50 Hz, 3-phase Optionally also other voltages	1945 x 2360 x 2085 mm 77" x 93" x 82"	536 kg 1179 lbs

The information included in this brochure is subject to revision without notice.

DO IT WITH T-DRILL

Cut costs – Improve quality – Increase profit

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

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

- Easier welding (flat outlet)
- Smaller risk of leakage
- Optimized flow-characteristics

Capacity | Max wall thicknesses

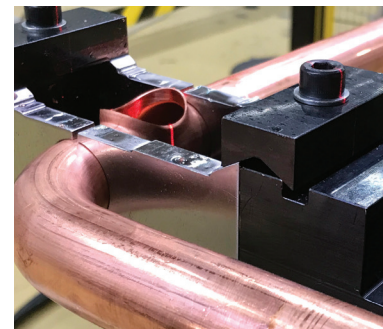


Collar **inside** diameter



Run tube outside diameter

Drilling/Collaring									
mm O.D.	6 ¼"	8 5/16"	10 3/8"	12 ½"	15 5/8"	18 ¾"	22 7/8"	25 1"	28 1 ⅝"
8 5/16"	0,5 .020	0,5 .020							
10 3/8"	0,8 .030	0,8 .030	1,0 .040						
12 ½"	0,8 .030	1,0 .040	1,0 .040	1,0 .040					
15 5/8"	0,8 .030	1,0 .040	1,0 .040	1,0 .040	1,2 .045				
18 ¾"	0,8 .030	1,0 .040	1,0 .040	1,0 .040	1,2 .045	1,2 .045			
22 7/8"	0,8 .030	1,0 .040	1,2 .045	1,2 .045	1,5 .060	1,5 .060	1,5 .060		
25 1"	0,8 .030	1,0 .040	1,2 .045	1,2 .045	1,5 .060	1,5 .060	2,0 .080	1,5 .060	
28 1 ⅝"	0,8 .030	1,0 .040	1,2 .045	1,2 .045	1,5 .060	1,5 .060	2,0 .080	2,0 .080	1,5 .060



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