Fully automatic PLC pipe bending machine

TUBOTRON 140 PLC
Basic equipment and features
- Programmable sequence control with menu-driven user guidance via SIMATIC Operator Panel with function keys, color plaintext display and storage capability for 50 bending programs on mobile control board
- Hydraulic bending drive
- Hydraulic pipe clamping with adjustable clamping pressure
- Hydraulic pressure die positioning
- Follower-type pressure die (linear guiding)
- Servo-electric pipe feed and rotation
- Hydraulic long-neck collet chuck allows for positioning of the pipe in the pressure die area, with pipe re-gripping functionality
- Foot switch for hydraulic collet chuck
- Hydraulic and anticipated mandrel retraction
- Automatic minimum quantity mandrel lubrication
- Interface for remote maintenance of the machine control
- Oil cooler

Additional equipment, options and accessories
- Pipe and mandrel support
- Quick-change system for the bending tools
- PIPEFAB BE pipe bending software

Models
- Pipe length (over mandrel): 4500 mm / 6000 mm

Technical data

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>Maximum bending capacity (mild steel)</td>
<td>Ø 120.0 x 8.0 mm</td>
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<td>Maximum bending radius</td>
<td>420 mm</td>
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<tr>
<td>Bending speed (max.)</td>
<td>6 °/s</td>
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<tr>
<td>Positioning accuracy of all axes</td>
<td>± 0.2 mm / ± 0.2 °</td>
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<tr>
<td>Dimensions, approx. (LxWxH)</td>
<td>8000 x 2500 x 1500 mm</td>
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<tr>
<td>Weight, approx.</td>
<td>12000 kg</td>
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<tr>
<td>Connected load</td>
<td>25.0 kW</td>
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</table>

1) at minimum pipe length over mandrel

Full automatic and precise bending of pipes up to Ø 140 mm.

Application example:
mild steel pipe  Ø 114.3 x 3.6 mm