

Booster bender

HEAVEY DUTY BOOSTER BENDER FOR BOILERS

Specification

Model	100CNC-1A	65CNC-1A
Max. Tube Capacity (D x t)	D144 x 7 mm (ferrous tube UTS 54 kg/mm ²)	D63.5 x 6.35 mm (ferrous tubes UTS 45 kg/mm ²)
Min. Tube Capacity (D)	25 mm	10 mm
Max. Bend Radius (CLR)	500 mm	200 mm
Min Bend Radius (CLR)	38 mm	24 mm
Min. bend radius	1 D (In terms of D) UPTO 63.5 Dia.	1 D (In terms of D)
Tube wall factor minimum	D/T=<9 D=Dia of pipe T=Thickness of pipe	D/T=<9 D=Dia of pipe T=Thickness of pipe
Direction of bend	Clockwise	Clockwise
Booster cylinder controlled by	Closed loop servo controller	
Standard length over mandrel	9 meters	9 meters
Bend Angle range	0 to 180 degrees	0 to 180 degrees
Bending Speed in Normal mode	12 Degrees/sec	18 Degrees/sec
Bending Speed in Booster mode	4-5 Degrees/sec	3-4 Degree/sec
Split die opening stroke	30 mm. (On request)	-
Wiper die arrangement for x-y-z axis adjustable	For thin tubes	For thin tubes
Serpentine bending	By means of gooseneck tooling arrangement	-
Electric Motor	15 Hp + 7.5 Hp	15 hp
Ovality in 'boost' mode	Within 8% - 10% or as per IBR norms	-
Thinning	10% - 12% on R=1D Bends with D/t =< 9	