



The fully-automatic Tubiroll-2R free-hand production beading machine is designed as an auxiliary machine

The operator is able to attend to upstream and downstream processes during forming, thanks to the free-hand operating method

The concept is distinguished by its stability, process reliability and speed

Technical data

Forming unit

- Tube diameter 60 – 600 mm
- Form length max. 100 mm *
- Tube wall thickness 1 mm overlap welded
- Beading depth max. 15 mm *
- Peripheral speed 0 – 75 m/min manually controlled
- Roll feed 0 – 5 mm/s manually controlled
- Roll feed rapid traverse 10 mm/s
- Cycle duration: bead 10 mm, Ø 200 mm ~8 s

Hydraulic equipment

- Tank capacity 63 L
- Roll drive delivery capacity 20 L/min
- Roll drive pressure 140 bar
- Feed delivery capacity 3 L/min
- Feed pressure manually controlled 160 bar
- Motor 5.5 kW – connection 400 V / 16 A
- Valves 24 V Bosch Rexroth
- Flow control valves Wandfluh

Machine structure

- Universal housing HW-Flex
- Electrical unit with adequate reserve
- Hydraulic unit with screwed housing
- Hollow tool holder for shaping rollers
- Wear-resistant table top with radially-configured T-slots for tube centring
- Grid with safety light curtain
- Dimension L = 1250; W = 880; H = 2600 mm
- Emission sound pressure level: 85 dB (A)
- Colour of housing – Ral 5010 gentian blue
- Colour of electrical unit – Ral 7035 light grey
- Colour of table top – galvanised
- Weight approx. 500 kg

Electrical equipment

- PLC Möller XC100 24V
- „ON/OFF“ main switch
- „Control ON/OFF“ switch
- Emergency STOP
- „Acknowledge emergency STOP“ illuminated switch
- Safety light curtain – „Sick“
- „Rapid transverse time“ potentiometer
- „Feed time“ potentiometer
- „Pneumatics ON/OFF“ switch
- Foot pedal

Options

- Choice of colour
- Siemens electrical equipment
- Connection without neutral conductor
- Special voltage
- Connection for robot handling via RS232
- Profibus interface
- Single piece counter
- Oil cooler
- Oil sump
- Oil level and oil temperature monitoring
- Filter dirt monitoring
- Static guide roller support (for long tubes)
- Pneumatic centring and holding-down support, for Form length max. 600 mm Ø 600 mm
- Pneumatic centring and holding-down support, for Form length max. 1000 mm Ø 600 mm
- Pneumatic centring and holding-down support, for Form length max. 1000 mm Ø 1000 mm
- Pneumatic centring and holding-down support, for Form length max. 1000 mm Ø 1400 mm
- Increase of max. Form length 200 mm
- Increase of max. diameter 1000 mm
- Increase of max. diameter 1400 mm



TUBIROLL-2R

Ventilation

