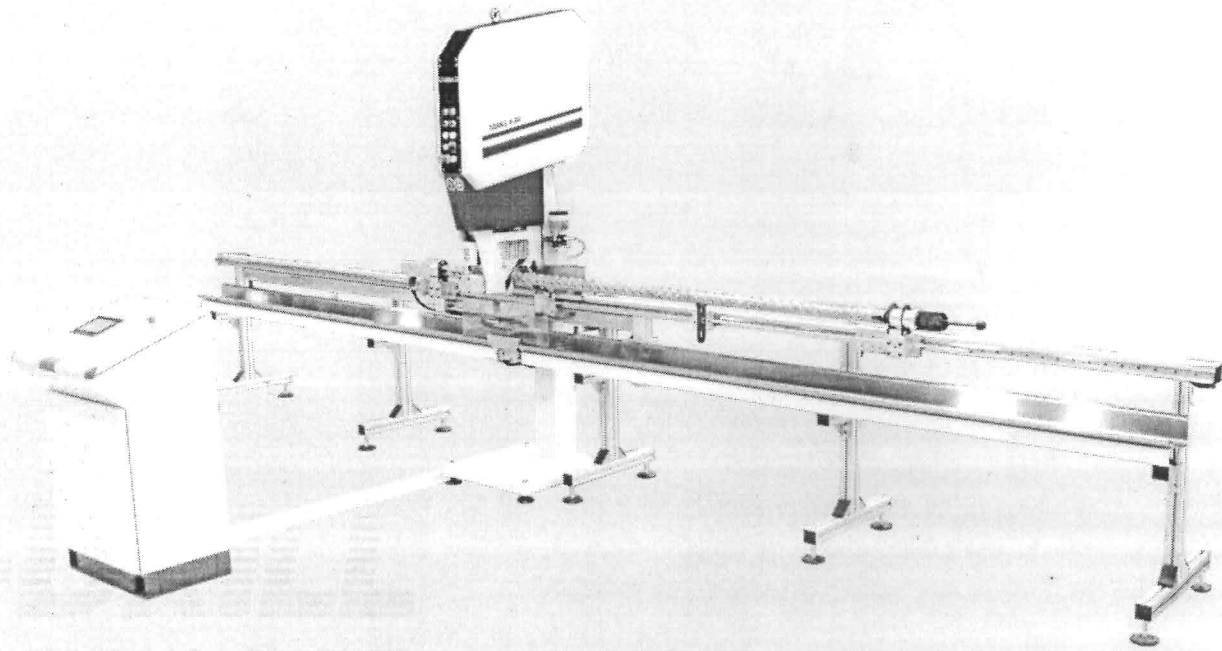
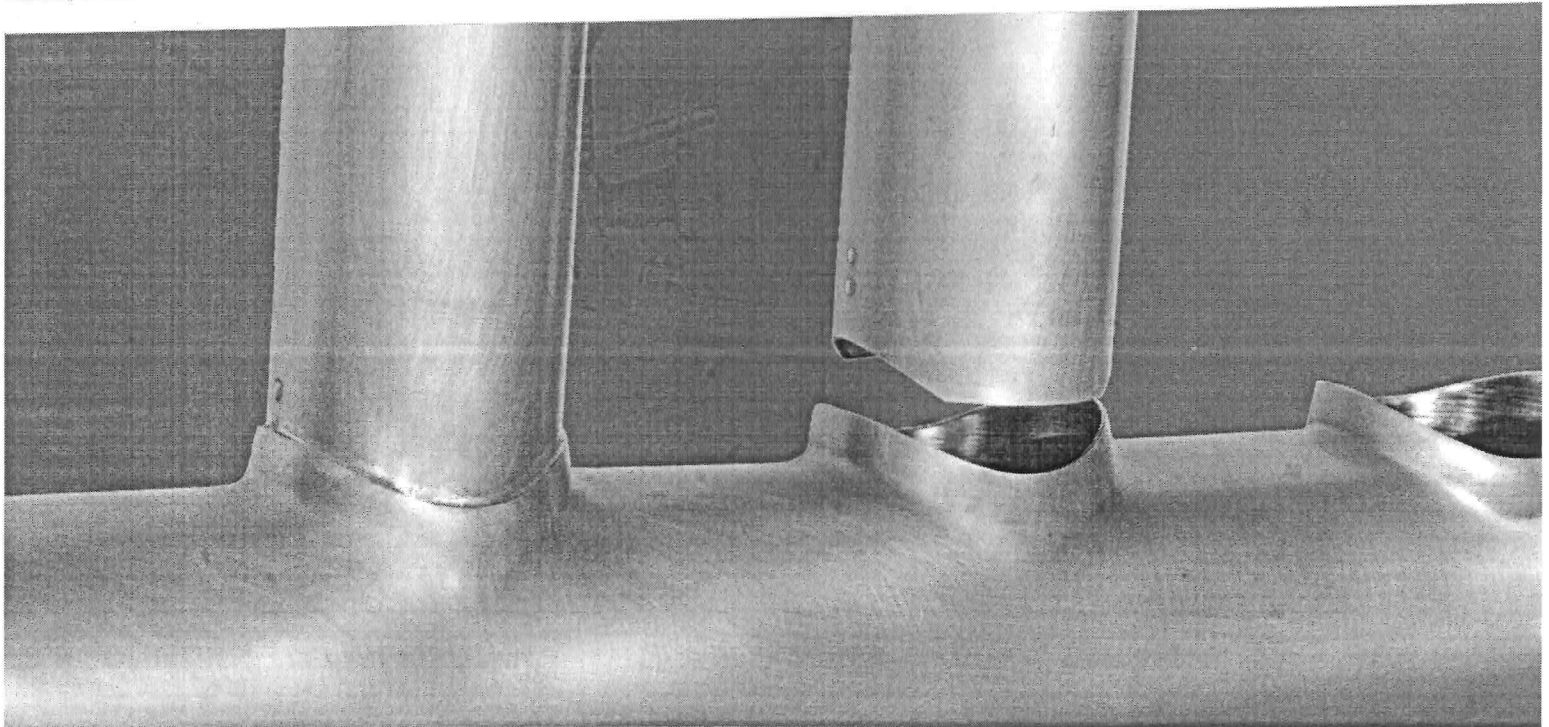


T-DRILL

PRODUCTIVITY AS A PRODUCT.



PRODUCTIVITY AS A PRODUCT.



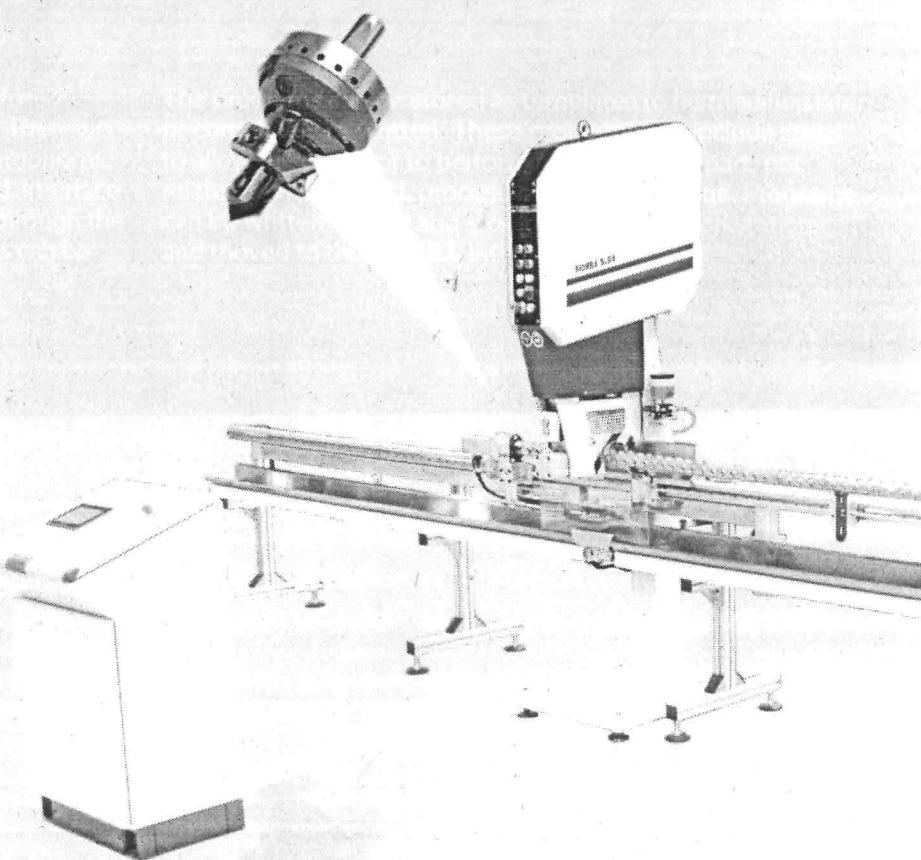
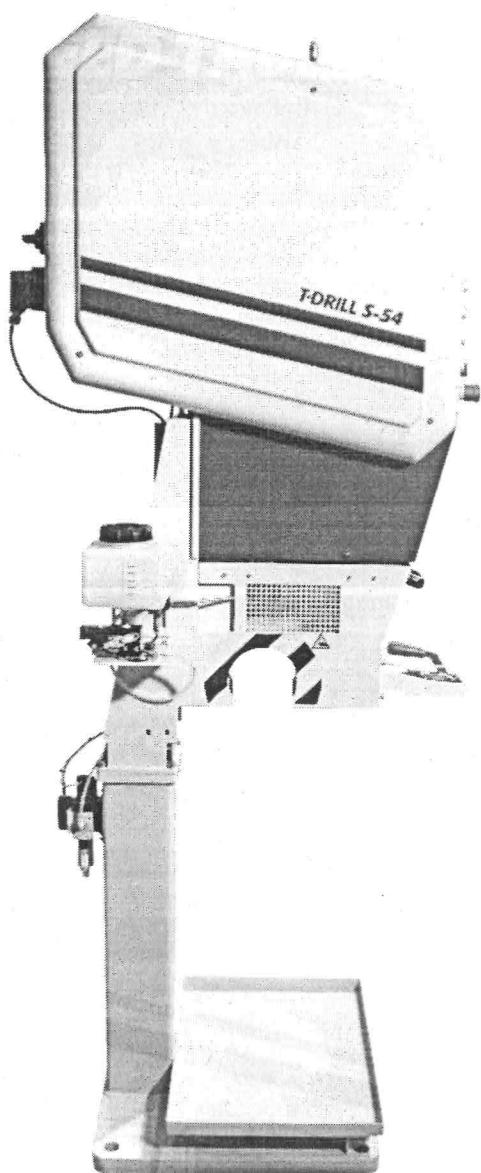
COLLARING UNIT

Automatic Feed Table for C 54

S-54 AFT - FEED TABLE SOLUTIONS FROM T-DRILL

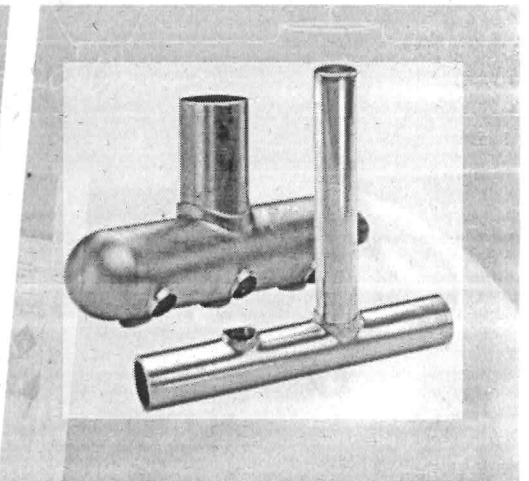
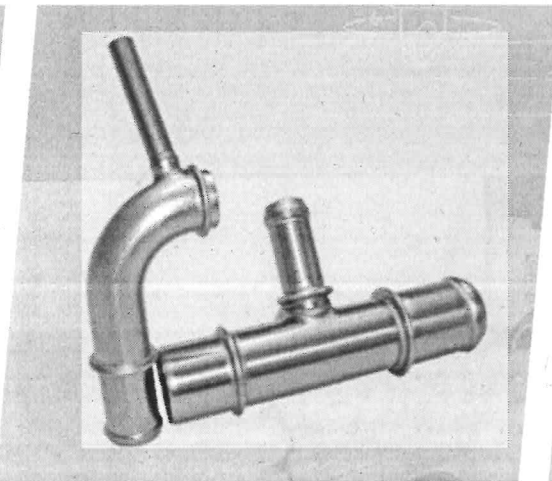
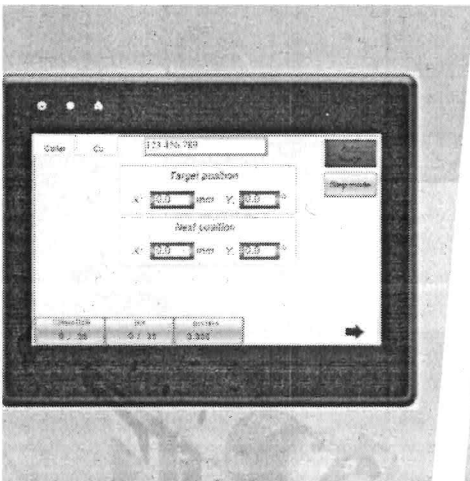
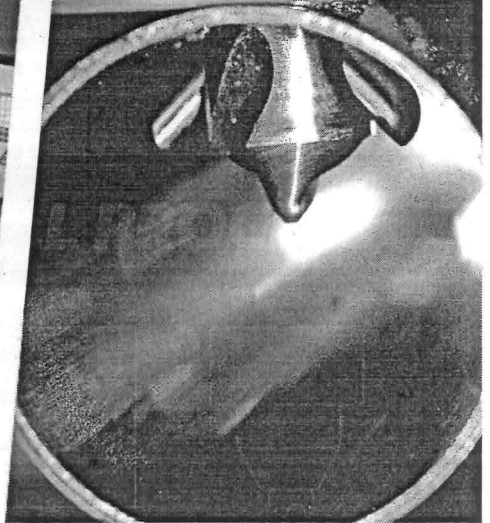
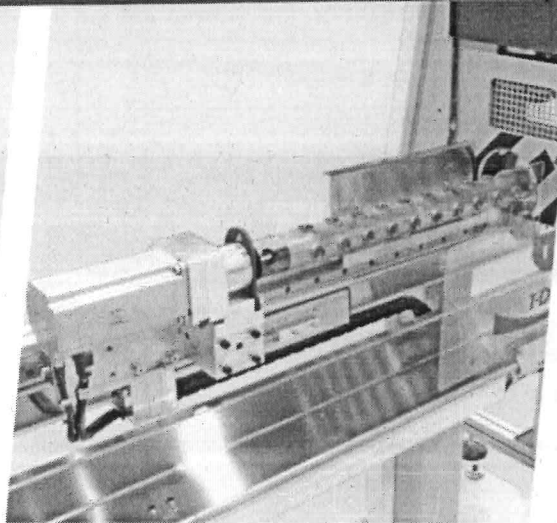
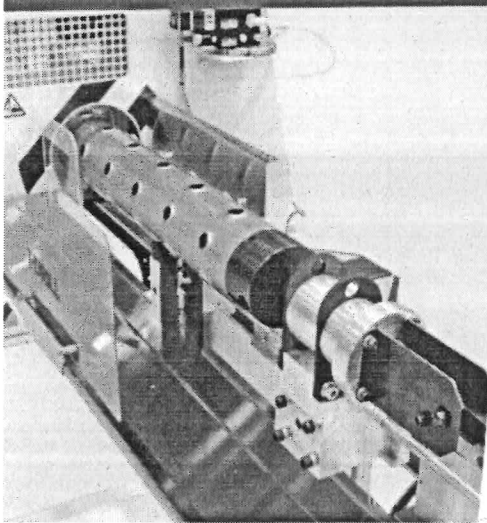
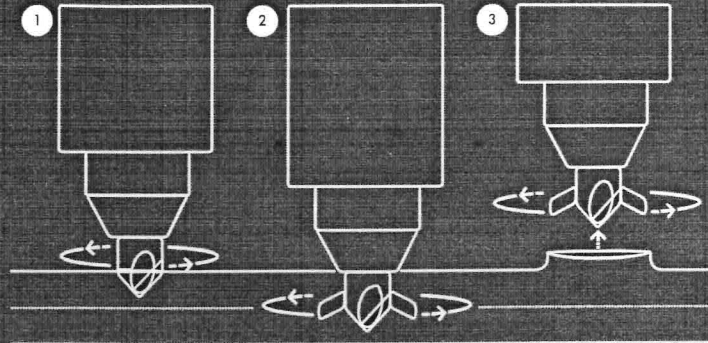
The **S-54** Automatic Feed Table provides a solution for automatic high-level manifold/collector production. The system is easy to understand, efficient to operate, ergonomic and safe. Using a touch-screen for input, the **T-DRILL** Interface provides on-screen prompts to guide the operator through the programming process. Up to 300 different programs can be stored with each containing as many as 300 steps.

The programs can be stored as templates to be modified later or completely re-written. These programs can include steps to allow the operator to perform actions on the part, not related to the **T-DRILL** process, and then continue. Programs can be written, edited and stored on external workstations and moved to the **T-DRILL** Interface.



THE T-DRILL PROCESS

1. Drilling of pilot hole 2. Extension of forming pins 3. Finished collar



The Feed Table itself is designed to be easily loaded and unloaded, and to make any necessary tool changes able to be done efficiently. The most important aspect of this system is the result! More surface area for brazing means a stronger leak-free joint and the **T-DRILL** process gives you much more surface area for brazing than merely drilling or punching. The **T-DRILL** process produces the strongest and most reliable braze joints available and it is the single best method of producing manifolds!

The standard lengths for automatic feed tables are for maximum tubes of 1,500, 2 500, 3 500, 4 500, 6 000 and 8 000 mm. Other lengths are available on request.

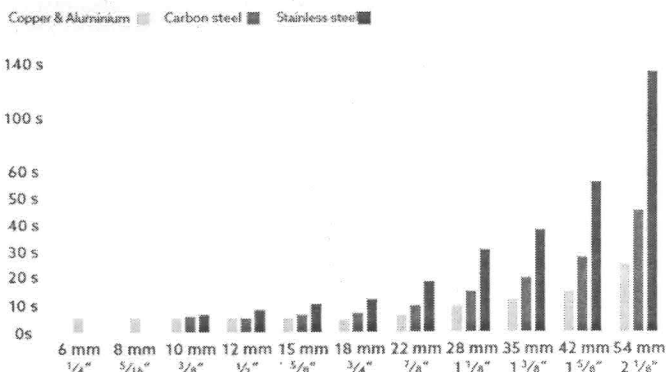
Specifications

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 ft³/min	50 l/min / 1.765 ft³/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

Branch tube outside diameter												
mm		6 mm	8 mm	10 mm	12 mm	15 mm	18 mm	22 mm	28 mm	35 mm	54 mm	
mm		1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	7/8"	1 1/8"	1 3/8"	2 1/8"	
Run tube outside diameter	8 mm	0.5	0.5									
	5/16"	.020	.020									
	10 mm	0.8	0.8	1.0								
	3/8"	.030	.030	.040								
	12 mm	0.8	1.0	1.0	1.0							
	1/2"	.030	.040	.040	.040							
	15 mm	0.8	1.0	1.0	1.0	1.2						
	5/8"	.030	.040	.040	.040	.045						
	18 mm	0.8	1.0	1.0	1.0	1.2	1.2					
	3/4"	.030	.040	.040	.040	.045	.045					
	22 mm	0.8	1.0	1.2	1.2	1.5	1.5	1.5				
	7/8"	.030	.040	.045	.045	.060	.060	.060				
	28 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	1.5			
	1 1/8"	.030	.040	.045	.045	.060	.060	.080	.060			
	35 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	1.5		
	1 3/8"	.030	.040	.045	.045	.060	.060	.080	.080	.060		
	54 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	2.0	2.0	
	2 1/8"	.030	.040	.045	.045	.060	.060	.080	.080	.080	.080	
	79 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	2.5	2.0	
	3 1/8"	.030	.040	.045	.045	.060	.060	.080	.080	.100	.080	
	104 mm	0.8	1.0	1.2	1.2	1.5	1.5	2.0	2.0	2.5	2.0	
	4 1/8"	.030	.040	.045	.045	.060	.060	.080	.080	.100	.080	

Max wall thickness for steels

Branch tube outside diameter												
mm		10 mm	12 mm	15 mm	18 mm	22 mm	28 mm	35 mm	54 mm			
mm		3/8"	1/2"	5/8"	3/4"	7/8"	1 1/8"	1 3/8"	2 1/8"			
Run tube outside diameter	10 mm	0.8										
	3/8"	.030										
	12 mm	0.8	0.8									
	1/2"	.030	.030									
	15 mm	1.0	1.0	1.0								
	5/8"	.040	.040	.040								
	18 mm	1.0	1.0	1.2	1.0							
	3/4"	.040	.040	.045	.040							
	22 mm	1.0	1.0	1.2	1.2	1.2						
	7/8"	.040	.040	.045	.045	.045						
	28 mm	1.0	1.0	1.2	1.2	1.2	1.2					
	1 1/8"	.040	.040	.045	.045	.045	.045					
	35 mm	1.0	1.0	1.2	1.2	1.4	1.2	1.2				
	1 3/8"	.040	.040	.045	.045	.045	.045	.045				
	42 mm	1.0	1.0	1.2	1.2	1.4	1.4	1.4	1.4			
	1 5/8"	.040	.040	.045	.045	.045	.045	.045	.045			
	54 mm	1.0	1.0	1.2	1.4	1.4	1.4	1.4	1.4	1.2		
	2 1/8"	.040	.040	.045	.045	.045	.045	.045	.045	.045		
	79 mm	1.0	1.0	1.2	1.4	1.6	1.6	1.6	1.6	1.6		
	3 1/8"	.040	.040	.045	.045	.045	.045	.045	.045	.045		
	104 mm	1.0	1.0	1.2	1.4	1.6	1.6	1.6	1.6	1.6		
	4 1/8"	.040	.040	.045	.045	.045	.045	.045	.045	.045		

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

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

MANUFACTURER:

T-DRILL

T-DRILL OY

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00400 Lahti, FINLAND

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