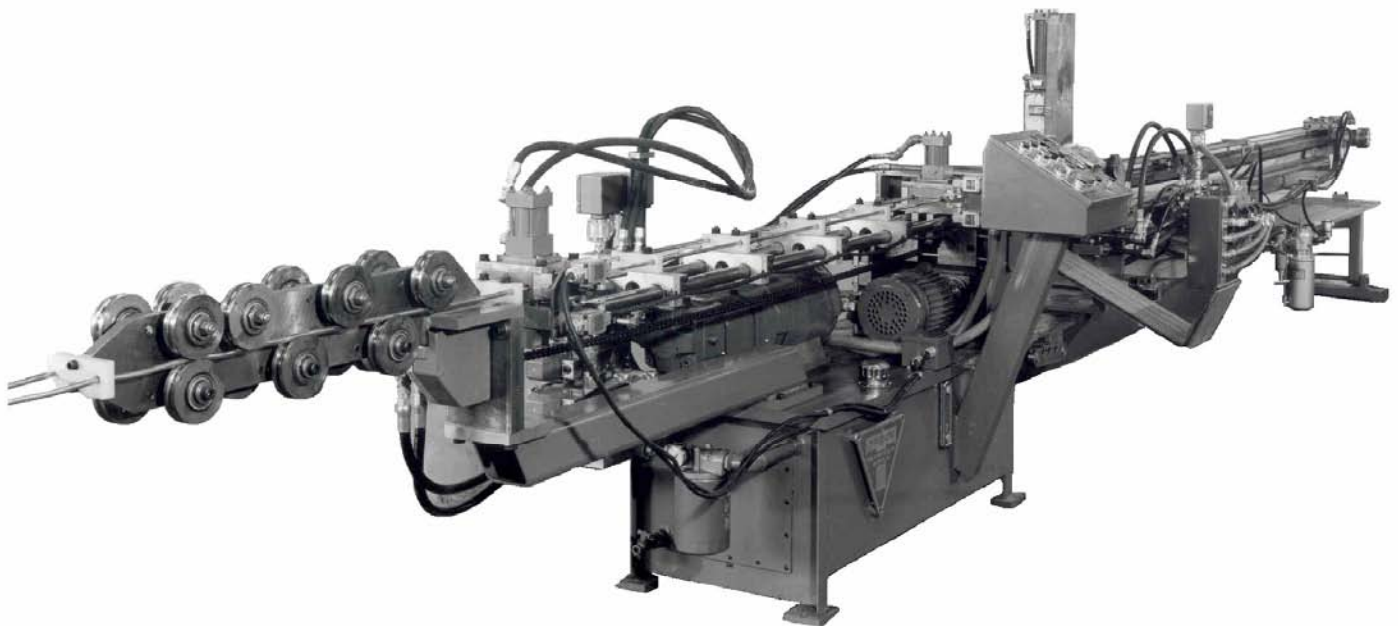


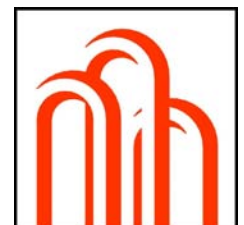
MODEL AHBQ

Qual-Ekon Hairpin Bender



The Model AHBQ **Qual-Ekon Hairpin Bender** is a fully automatic mandrel type bender that is designed for the production of 180 degree hairpin bends from level wound rolls of copper or aluminum tubing. This bender will process two tubes per cycle with the use of hitch type feed system and a chip free orbital type cutoff.

Tridan International, Inc.
130 N. Jackson Street
Danville, Illinois 61832 U.S.A.
(217) 443-3592 * (217) 443-3894
www.tridan.com



Customer Driven Designs

Tube Bender

TRIDAN MODEL AHBQ

The production application of the TRIDAN Model AHBQ-4 is to produce hairpin bends from level-wound coiled tubing of copper or aluminum. It is a fully integrated system consisting of a Tube Straightening, Sizing, and Lubrication Section, adjustable-length Tube Feeding Section, a chipless Tube Cutoff Section, and Hairpin Bender Section. Supporting equipment include a Tube Decoiling System. The Control System is designed in such a manner that all operations are sequenced fully automatically or may be individually placed under manual control.

The Tube Straightening, Feeding, and Cutoff Sections are mounted on a machined base plate, which also serves as the top of the weldment-constructed hydraulic reservoir. This oversized reservoir is an integral part of the machine's frame, and is furnished as standard with a liquid level gauge and thermometer. The Hairpin Bender Section is mounted on a heavy-duty fully machined base frame to insure positive alignment with the Tube Straightening, Feeding, and Cutoff Section under all setup and operational conditions. The Bender Section is precisely guided on the base frame, again to insure alignment between the tubes and the bending mandrels and mandrel rods.

The Tube Decoiling System is built on a weldment frame of sufficient size and rigidity to support the number and size of coils dictated by the application.

TECHNICAL SPECIFICATIONS

Tube Diameters	1/4" through 3/4"ODs (6.35/19.05mm)	Feed Speed	90 to 120 Ft/Min. (27.4/45.7Mtr/Min)
Tube Materials	Copper or Aluminum	Cutoff Time	Dependent upon tube material, diameter, and, wall thickness - 0.5 Sec. Average
Bends per Cycle	Two (2)	Tube Length Tolerance	+/- .025" per 120" length (+/- .635mm per 3.05Mtrs)
Minimum Bend Radius	Equal to Tube Outside Diameter(OD)	Tube Straightness	Better than .040" per foot of length (3.3mm per Meter)
Maximum Bend Radius	1.500" (38.1mm)	Tube Ovality	1% of Tube OD
Minimum Hairpin Length	10" (254mm) – Standard		
Maximum Hairpin Length	48" (1219mm) - Model AHBQ-4-48 72" (1829mm) - Model AHBQ-4-72 96" (2438mm) - Model AHBQ-4-96 120" (3048mm) - Model AHBQ-4-120		

