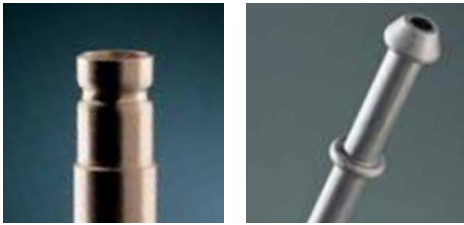


AST

MULTI-STATION TUBE ENDFORMERS WITH FORMING AND MACHINING HEADS



a BLMGROUP Company



AST25

TUBE ENDFORMING AND MACHINING

The four working stations can be configured with individual heads for ram forming, roll forming or machining operations:

- Combined processes which can be carried out on the tube end include: expanding, reducing, swaging, beading, rolling, spinning, doming, machining, facing, and trimming etc.
- Minimising finishing operations with a two-speed additional rotary device
- The optional automatic loading and unloading device minimises labour costs, improves quality and ensures consistently high productivity
- Optional "top and tail" facility on the automatic loader allows both ends of the tube to be processed in automatic cycle

The PLC control unit programmes the two axes of the machine for maximum efficiency without requiring manual adjustments.



AST25

AST38

TUBE ENDFORMING

- Rotating head with 6 ram forming stations
- Inexpensive, high productivity machine
- PLC controlled for rapid cycling
- Quick and easy tool programming
- Easily incorporated into automated cells for high volume, specific applications e.g. automatic loading of fittings on to the component prior or during endforming etc.



AST38 + AL35



BLM

AST

MULTI-STATION
TUBE ENDFORMERS
WITH FORMING AND
MACHINING HEADS

Multi-station tube endformers with forming and machining heads

- COMBINING PROCESSES OFFERS HIGHER QUALITY, ACCURACY AND REPEATABILITY AND THE LOWEST COST-PER-COMPONENT
- COMPREHENSIVE RANGE AND CAPABILITIES TO COVERS THE SIMPLEST AND MOST SOPHISTICATED APPLICATIONS
- RAM FORMING, ROLLING AND MACHINING OPERATIONS CAN BE COMBINED IN THE SAME CYCLE
- EASILY INTEGRATED IN TO MANUFACTURING CELLS
- MANUAL OR AUTOMATED LOADING AND UNLOADING
- QUICK-AND-EASY SETTING AND PROGRAMMING MINIMISES CHANGEOVER TIME





TUBE-FORM + AL35 + CARM7

AST80-100-122

CNC TUBE ENDFORMING AND MACHINING

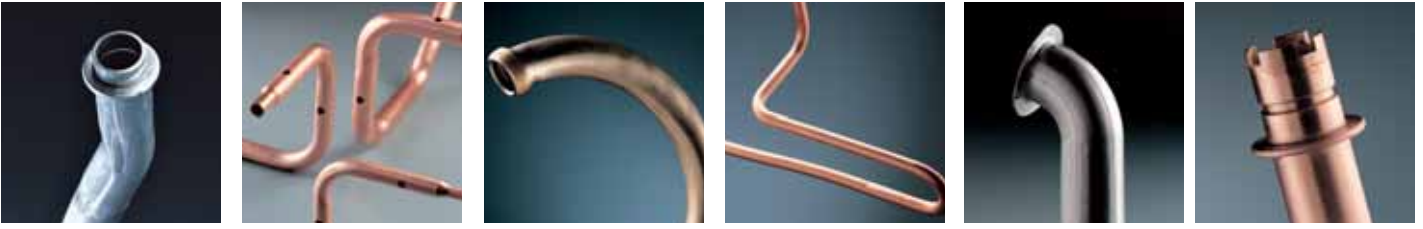
Six working stations on a rotating head - each station can be programmed for conventional ram forming (expanding, reducing, beading, flanging, swaging etc.) or rotary forming (rolling, doming etc.) or machining (facing, chamfering, threading, trimming etc.) or a combination integrating all three technologies on the same tubular component.

Combining processes during the single clamping offers a much higher manufacturing efficiency, improves accuracy and repeatability, and eliminates intermediate handling to give the lowest possible cost-per-component.

The CNC management automatically programmes and precisely controls the two axes of the machine for optimum efficiency without manual adjustment, deskilling the process.



AST80



AUTOMATION AND INTEGRATION

- Automatic loaders enables the machines to run for long periods with minimum supervision
- Innovative “top-tail” device allows both tube ends to be processed automatically in cycle
- Customised automated handling for specific requests e.g robots, bowl feeders etc.
- Fully integrated manufacturing cells linking other processes such as bending, cutting etc.



AST80 + AL38 + VIBRATING BOWL FEEDER

TECHNICAL DATA

	AST25N	AST38/6P	AST80NC	AST100NC	AST122NC
Tube O.D.	min. 4mm max 28 mm min. 0.157" max 1.1" (in Al-Cu-Ot)	min. 4 mm max 40 mm min. 0.157" max. 1.57"	min. 10 mm max 80 mm min. 0.4" max 3.15"	min. 10 mm max 100 mm min. 0.4" max. 3.15"	min. 10 mm max 100 mm min. 0.4" max. 3.15"
Working stations	4	6	5+1	5+1	5+1
Hydraulic forcer	3,5T - 4,5T (on request)	5T - 7T (on request)	12T	18T	22T
Clamping force	5T	10T	22T	22T	33T
Max. working stroke	80 mm (3.15")	130 mm (5.11")	180 mm (7")	180 mm (7")	180 mm (7")
Rotare stations*	1	-	6	6	6
Instaled power	5,5 KW	7,5 KW	11 KW	11 KW	11 kW
Tube lubrication	included	included	included	included	included
Air/oil heat exchanger	included	included	included	included	included
Two-hand push button	included	included	included	included	included
Noise level	78 dba	70 dba	75 dba	75 dba	75 dba
Machine weight	2000 Kg	1500 Kg	3000 Kg	3150 Kg	3310 Kg
Machine size	1950x1200x1600 mm (76.77"x47.24"x62.99")	1950x1400x1600 mm (76.77"x55.11"x62.99")	1600x2400x1700 mm (62.99"x94.49"x66.93")	1600x2400x1700 mm (62.99"x94.49"x66.93")	1600x2400x1700 mm (62.99"x94.49"x66.93")
Control unit	PLC	PLC	CNC	CNC	CNC
Manual pre-clamping device with quick change vice jaws	included	included	included	included	included

Other models available on “all electric” version.

Options: AST25N spindle tool holder, spray mist oil lubrication of the tube with vegetable oil, clamp die holder with manual pre-clamping device, automatic loaders and feeders. **AST38/6P:** Automatic loader. Feeder and unloader, spray

mist oil lubrication of the tube with vegetable oil, clamp die holder with manual pre-clamping device. **AST80NC-AST100NC-AST122NC:** spindle tool holder, spray mist oil lubrication of the tube with vegetable oil, clamp die holder with

manual pre-clamping device, automatic loaders and feeders.

☒ Features, weights, dimensions, capacities and performances of the machines are not binding and may be subject to change without notice. Pictures are for demonstration purpose only.

BLM GROUP

endforming
tube bending
sawing, deburring and washing
cutting & end machining
lasertube cutting system
laser cutting for sheet and tube
handling
3d measuring
manufacturing cell
non touch measuring systems
process control software