

Tube Laser Cutting



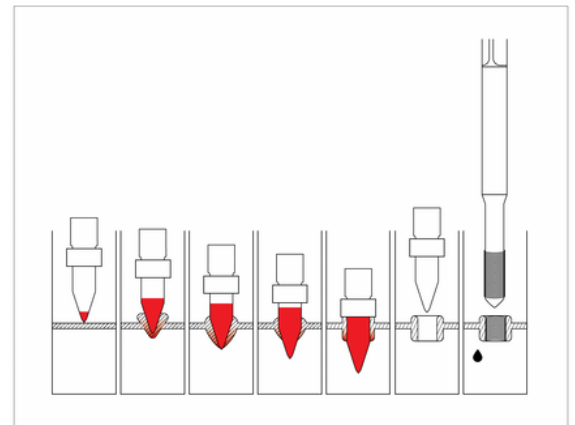
BLM LT7 Laser Capability	
Load length	1900-6500mm
Unload length (Max)	6500mm
Min/Max Cutting dimensions	12 - 152.4mm
Max difference between sides	137mm
Max weight (kg/m)	23
Max cutting thickness (Steel)	6mm

CNC Drilling

Drilling Capability						
Drilling	Tapping	Thermal Drilling	Milling	Length	Bed	Spindle Speed
ø 2mm - ø 40mm	M3 - M24	M5-M10	Linear only	50-6000mm	0.4x4.5m	750-3000 RPM

Swaging & End Forming

Swage Tooling List	
Swage (mm)	Tube Profile (mm)
13.2, 14	15.9
15, 17	19.1
19.5, 20.7, 21.6, 21.8	22.2
22.5, 24	25.4
25.7, 26.8	28.6
28.1, 28.6, 30	31.8
34.4, 35	38.1
40	41.3
42.5	44.5
46.6, 50	50.8
55	57.2
60.15	63.5



Telescoping

Telescoping			
	Outer	Inner	Nominal Clearance
Round	76.2	69.9	1.8mm (2.0 Outer wall)
	63.5	60.3	0.8mm (1.2 Outer wall)
	60.3	57.2	0.4mm (1.2 Outer wall)
	57.2	54.0	0.3mm (1.2 Outer wall)
	54.0	50.8	0.4mm (1.2 Outer wall)
	50.8	47.6	0.5mm (1.2 Outer wall)
	47.6	44.5	0.3mm (1.2 Outer wall)
	44.5	41.3	0.3mm (1.2 Outer wall)
	41.3	38.1	0.3mm (1.2 Outer wall)
	38.1	34.9	0.3mm (1.2 Outer wall)
	34.9	31.8	0.4mm (1.2 Outer wall)
	31.8	28.6	0.5mm (1.2 Outer wall)
	28.6	25.4	0.4mm (1.2 Outer wall)
	25.4	22.2	0.3mm (1.2 Outer wall)
	22.2	19.1	0.3mm (1.2 Outer wall)
	19.1	15.9	0.3mm (1.2 Outer wall)
15.9	12.7	0.4mm (1.2 Outer wall)	
12.7	9.5	0.4mm (1.2 Outer wall)	

Telescoping			
	Outer	Inner	Nominal Clearance
Rectangular	68.0x43.0	63.5x38.1	0.8mm (1.6 Outer wall)
	50.8x25.4	46.5x22.2	0.8mm (1.6 Outer wall)
	38.1x25.4	34.9x19.1	0.5mm (1.2 Outer wall)
	34.9x19.1	31.8x15.9	0.4mm (1.2 Outer wall)
Square	38.1x38.1	34.9x34.9	0.3mm (1.2 Outer wall)
	34.9x34.9	31.8x31.8	0.4mm (1.2 Outer wall)
	25.4x25.4	22.2x22.2	0.3mm (1.2 Outer wall)
	22.2x22.2	19.1x19.1	0.3mm (1.2 Outer wall)
	19.1x19.1	15.9x15.9	0.3mm (1.2 Outer wall)
	15.9x15.9	12.7x12.7	0.4mm (1.2 Outer wall)

Other variations are available and the internal weld bead can be reduced for additional clearance. MOQs apply. For production runs, plug gauges will be used as per customer specification.



CNC Mandrel Tube Bending

Available Tooling List

Tube Size (mm)	Centreline Bend Radius (mm)	Wall Thickness (mm)	Minimum Straight between bends (mm)
Ø25.4	64.3	1.6, 2.0	60
Ø31.8	97.6	1.6, 2.0	80
Ø38.1	117.1	1.6, 2.5	95
Ø44.5	77.9, 137.5	1.6, 2.5	110
Ø50.8	88.9, 155.6	1.6, 2.5	125
Ø63.5	97.7	1.6, 2.0, 2.5	140
Ø76.2	115.4	1.6, 2.0, 4.75	170
Ø88.9	133.35	1.6, 2.0	180
25.4x25.4	76.1	1.6, 2.0	80

