

T-DRILL PROCESS

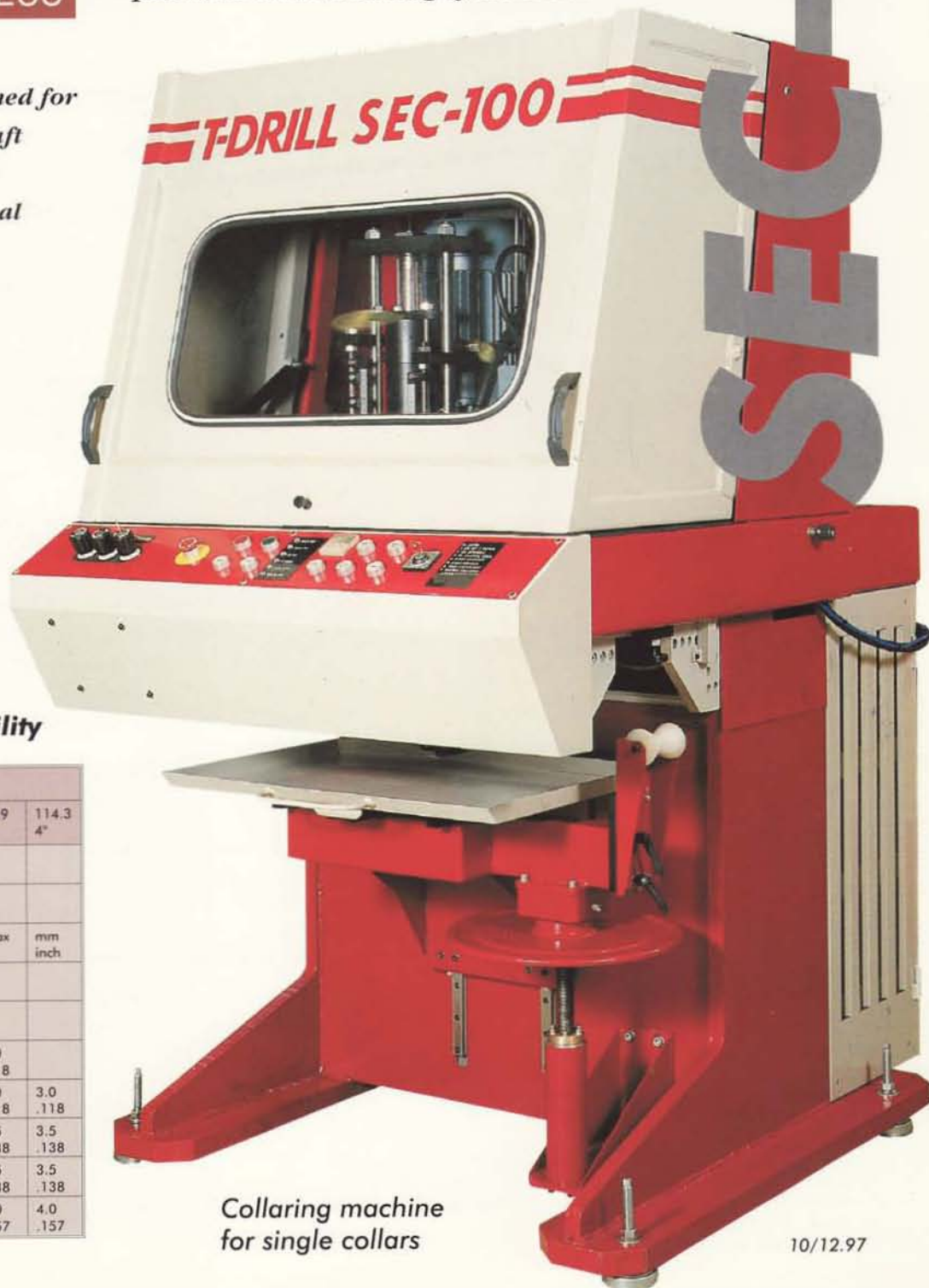
The Automatic SEC-100 Collaring Machine

The T-DRILL SEC-100 collaring machine is a combination of two modular T-DRILL units integrated to the same frame. The pilot hole cutter and the collaring machine process the collar automatically, from the milling of the pilot hole to the trimming of the collar.

The SEC-100 is designed for the food, dairy and aircraft industries as well as pipe fabrication and mechanical contactor applications.

The SEC-100 handles thin-wall stainless steel, carbon steel, copper and other alloys.

An automatic work cycle with simple preset tools makes the SEC-100 ideal for both high volume and short-run production.

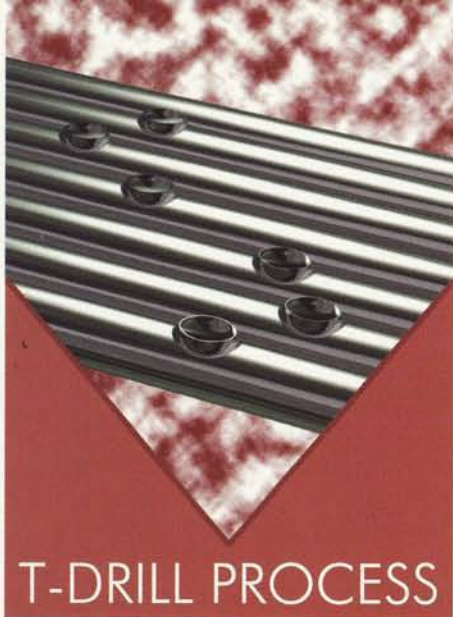


Wall Thickness Capability

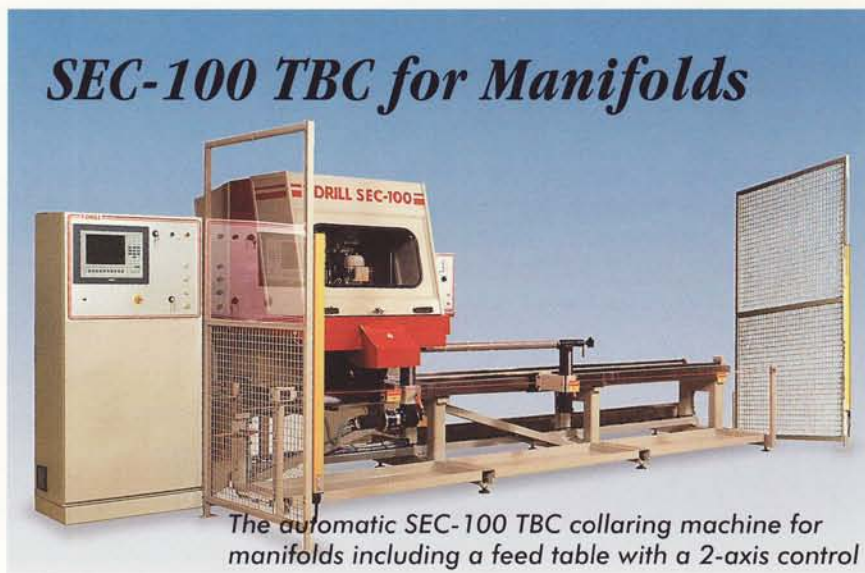
Run tube N.S./O.D.	Collar N.S./O.D.						max mm	inch
	26.9 3/4"	33.7 1"	42.4 1 1/4"	60.3 2"	88.9 3"	114.3 4"		
33.7 1"	2.0 .080	2.0 .080						
42.4 1 1/4"	2.3 .090	2.3 .090	2.6 .100					
48.3 1 1/2"	2.3 .090	2.6 .100	2.9 .114					
60.3 2"	2.3 .090	2.6 .100	2.9 .114	3.0 .118				
76.1 2 1/2"	2.3 .090	2.9 .114	3.0 .118	3.0 .118				
88.9 3"	2.3 .090	2.9 .114	3.0 .118	3.0 .118	3.0 .118			
114.3 4"	2.3 .090	2.9 .114	3.0 .118	3.0 .118	3.0 .118	3.0 .118		
139.7 5"	2.3 .090	2.9 .114	3.5 .138	3.5 .138	3.5 .138	3.5 .138		
168.3 6"	2.3 .090	2.9 .114	3.5 .138	3.5 .138	3.5 .138	3.5 .138		
219.1 8"	2.3 .090	2.9 .114	3.5 .138	4.0 .157	4.0 .157	4.0 .157		

This chart is intended as a guide only.

Collaring machine for single collars



T-DRILL PROCESS



The automatic SEC-100 TBC collaring machine for manifolds including a feed table with a 2-axis control

Technical data

- Collaring range \varnothing 21.3-114.3 mm (1/2"-4" IPS)
- Run tube \varnothing 33.7-219.1 mm (1"-8" IPS)
- Wall thickness (see capability chart)
- Electric motor 3 kW
- Automatic grease lubrication
- Process time: 5-7 min.

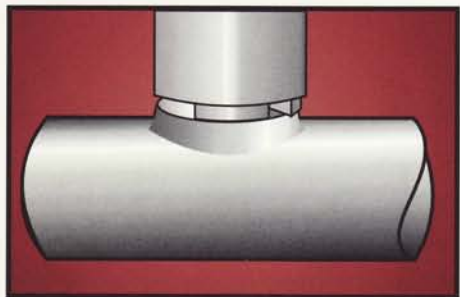
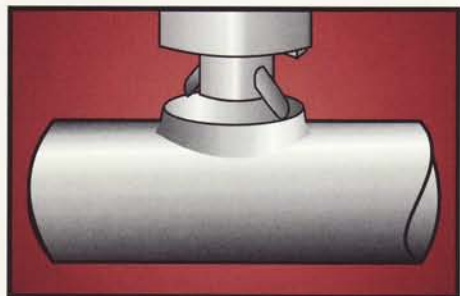
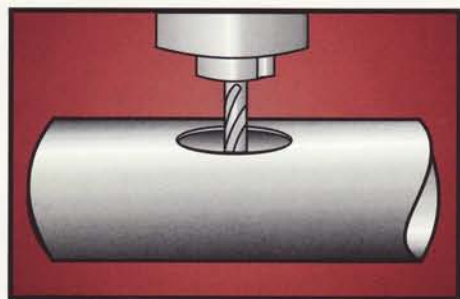
The manual process

- Preset the elliptical pilot hole parameters manually.
- Install the preadjusted collaring head and the clamps according to the tube size.
- Set the axial tube stop.
- Mount the tube in the clamps.
- Push the start-button and the cycle will start.

The automatic cycle

- The clamps close and the EC-100 mills the elliptical hole.
- When the hole is finished the EC-100 unit retracts.
- The S-100 unit begins the collaring of the tube and the trimming of the collar.
- Finally the EC-100 returns to the milling position and the clamps open.
- On the TBC-model the unit is positioned according to the program and the cycle repeats.

The data in this brochure is subject to revision without notice.



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