



TEC-150
Collaring Station



T-DRILL

The T-DRILL TEC-150 Collaring Station — now faster and easier than ever!

The entire T-DRILL TEC-150 process from pilot hole milling to collar trimming is carried out in a single workstation.

Further advantages have been achieved by incorporating the latest technology. Our TEC-150 is able to provide increased productivity thanks to the improvements made in the tube positioning, handling and collaring operations. Smaller diameter collars of O.D. 21.3-26.9 mm ($\frac{1}{2}$ "- $\frac{3}{4}$ " IPS) are now also achievable depending on run tube diameter and wall thickness.

TEC-150 Options

For tube positioning TEC-150 can also be equipped with a manually operated, or NC controlled positioning systems. Depending on requirement, either tube or machine is moved.

Optionally, we have also available TEC-150 version for forming up to 219.1 mm (8") collars from pre-cut pilot hole.



F-200 and F-400

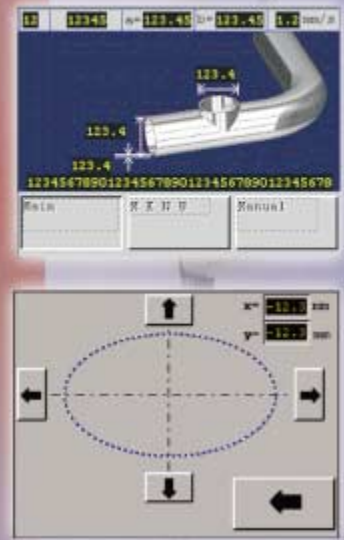
T-DRILL flanging machines eliminate the need for costly welded flanges and reduce pipe joint preparation and installation time by over 40%. Flanging range O.D. 21.3-419 mm ($\frac{1}{2}$ "-16" IPS).



T-60 Steel

T-DRILL has also a portable pipe collaring system for stainless steel. The collaring range is O.D. 20-51 mm ($\frac{1}{2}$ "-1 $\frac{1}{2}$ " IPS).





User friendly touch screen is used for entering the parameters for the collaring operation. Alternatively the parameters can be stored to memory and quickly loaded from there.

Technical specifications

Collaring range	21.3-168.3 mm (219.1 mm)	½-6" (8") IPS
Run tube	33.7-560 mm	1-20" IPS
Wall thickness	see capability chart	
Electric	3-phase voltage to be specified / 4 kW	
Weight	1000 kg	2200 lbs.
Height	1800 mm	71"
Width	1000 mm	40"
Depth	1700 mm	67"



Pilot hole milling.



Collaring head replacing and the extrusion of the branch collar.



Trimming of the collar.



Easy tube handling.

No special tools or keys needed.



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

TEC-150 Capability Chart

Cold Forming of Stainless Steel

Branch tube outside diameter in mm (N.S. inch).

	21.3 ½	26.9 ¾	33.7 1	42.4 1¼	48.3 1½	60.3 2	73 2½	88.9 3	114.3 4	141.3 5	168.3 6
33.7 1	1.5 0.060	2.0 0.080	2.0 0.080	-	-	-	-	-	-	-	-
42.4 1¼	2.0 0.080	2.3 0.091	2.6 0.102	2.6 0.102	-	-	-	-	-	-	-
48.3 1½	2.0 0.080	2.3 0.091	2.6 0.102	2.9 0.114	2.9 0.114	-	-	t.max	-	-	-
60.3 2	2.0 0.080	2.3 0.091	2.9 0.114	2.9 0.114	3.2 0.126	3.2 0.126	-	-	-	-	-
73 2½	2.0 0.080	2.3 0.091	2.9 0.114	3.2 0.126	3.6 0.142	3.6 0.142	3.6 0.142	-	-	-	-
88.9 3	2.0 0.080	2.3 0.091	2.9 0.114	3.2 0.126	3.6 0.142	3.6 0.142	3.6 0.142	3.9 0.154	-	-	-
114.3 4	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	4.5 0.177	-	-
141.3 5	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	5.6 0.220	4.5 0.177	-
168.3 6	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	6.3 0.250	5.6 0.220	5.0 0.20
219.1 8	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	6.3 0.250	6.3 0.250	5.6 0.220
273 10	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	6.3 0.250	6.3 0.250	6.3 0.250
323.9 12	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	6.3 0.250	6.3 0.250	6.3 0.250
355.6 14	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	6.3 0.250	6.3 0.250	6.3 0.250
406.4 16	2.0 0.080	2.3 0.091	2.9 0.114	3.6 0.142	4.0 0.157	4.5 0.177	5.0 0.20	5.6 0.220	6.3 0.250	6.3 0.250	6.3 0.250

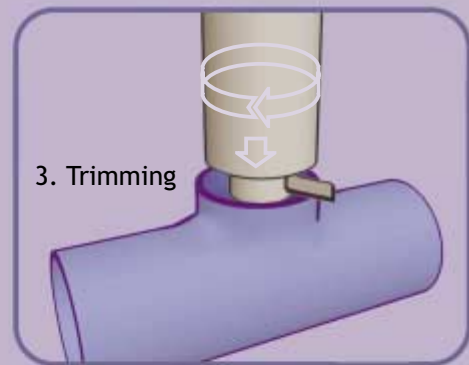
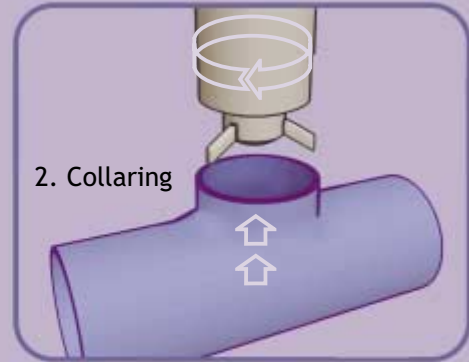
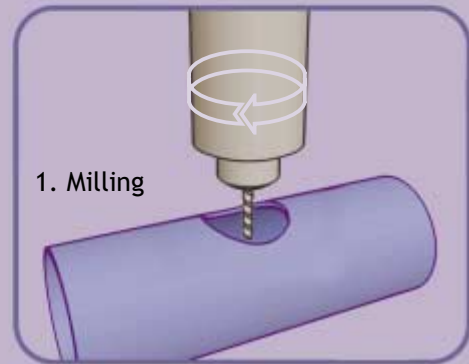
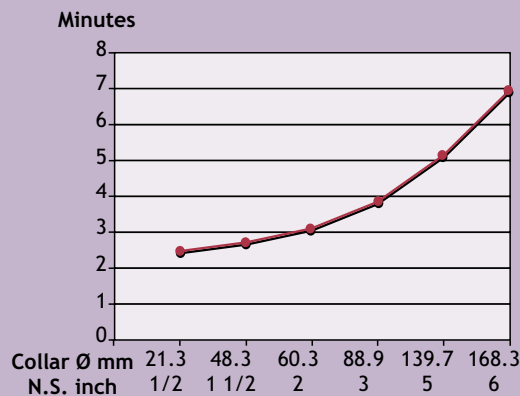
Run tube outside diameter in mm (N.S. inch)

Process times

for TEC-150

Time required to produce a mill faced collar, excluded the time for loading and unloading the tube.

Applicable to austenitic steel.



The T-DRILL Method

The T-DRILL method of branching is applicable to almost all malleable materials including stainless steel, CuNi, aluminium alloys and copper.

1. An elliptical pilot hole is milled in the pipe
2. The forming pins of the collaring head are extended and the collar formed. This is aided by automated lubrication and optimized forming.
3. The collar is trimmed to the desired height.