

wifag//polytype group

# Tube Trimming and Brushing machines



for the production of aluminium  
tubes

mall//herlan

# Experience and Innovation – Tube Trimming by mall//herlan



## T10: special features

- // 10-station turret head with expanding mandrels and mandrel quick-change device
- // Unit for pushing the tube onto the mandrel in 2 steps
- // Trimming station to cut the tubes to length complete with special tools
- // Thread rolling unit for both radial and axial thread rolling
- // Shoulder brushing unit for polishing the tube shoulder
- // Turning station for finishing the tube neck
- // Centered chipless deburring device for the tube orifice
- // Swarf suction unit
- // Transport systems for the automatic feed and discharge of the tubes
- // Protective cover with electrically monitored doors

## Optional extras:

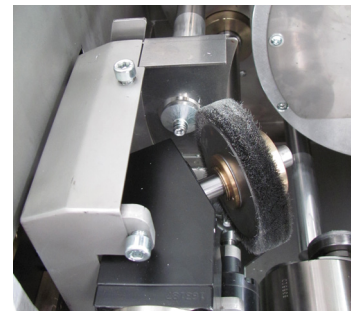
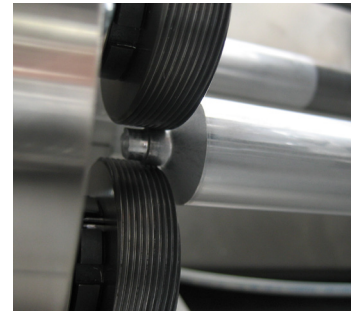
- // Detector for too short or untrimmed tubes

## Trimming and brushing machine

With the mall//herlan tube trimming machines, the tube is trimmed to length, the tube neck is turned and the tube orifice is processed. The tube shoulder may also be brushed on these machines. A synchronization unit guarantees the automatic operation with press and annealing oven.

## Technical data trimming and brushing machine

Type	T10	MHT
Tube diameter mm	10 – 50	12,5 – 55
Max. speed cpm	180	200
Max. extruded overall tube length mm	220	220/250
Min./Max. finished wall length* mm	50/210	50/240
Assumed wall thickness of tubes mm	0,1 – 0,5	0,1 – 0,5
Net weight approx. kg	3.200	6.400



\*Finished wall length ( $L > 3,5 \times D$ ) min. 50 mm

### MHT: special features

- // One-mandrel trimming system: separate trimming station with patented shearing system, scrap ring chopped up on the mandrel and sucked off
- // Radial thread rolling unit, with indexed thread rollers
- // Tube milling station and shoulder brushing unit, additionally driven for yielding optimum processing speeds
- // Swarf suction unit for the tube milling station and the shoulder brushing unit
- // Device for deburring the tube orifice
- // Unit for smoothing the tube end
- // Digital displays for reproducible settings on all tools
- // Mandrel drive by means of servomotor, speed-dependent and adjustable
- // Expanding mandrel fixture
- // Removal of the tubes from the mandrels and discharge onto the continuously operating pin chain

### Optional extras:

- // Beading unit for security closure
- // Safety and sound proofing cabin

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