

OAK RETURN ELBOW CROSSOVER BENDER (RECB)

This machine is designed with versatility in mind. This hydraulic powered machine can produce return bends, crossover bends, elbow bends and short straight tubes with a simple, quick tooling change and setup.



PRODUCTION

Cycle Speeds:

Crossover:	8 cyc/min
Elbow:	10 cyc/min
Return Bend:	11 cyc/min
Straight:	22 cyc/min

Bends per Cycle:

 $\frac{1}{4}^{"} - \frac{3}{8}^{"}$: 3 b/c $\frac{1}{2}^{"} - \frac{3}{4}^{"}$: 2 b/c $\frac{7}{8}^{"} - \frac{1}{4}^{"}$: 1 b/c

MATERIAL

¼" dia – 1¼" dia Straight lengths or coil tubing Copper, Aluminum

FOOTPRINT

 \approx 12.14' x 6.89' x 6.89' (3.7 m x 2.1 m x 2.1 m) ≈ 8,000 lbs (3,629 kg)

AIR

6 ft³/min at 80 psi (0.2 m³/min at 5.5 bar)

POWER

12 kW @ .80/.82 PF 24 VDC Controls **Foundation information supplied upon request

OAK MECHANICAL RETURN BENDER (MRB)

This machine is specifically designed to produce return bends at high production speeds. This machine automatically feeds, bends, and cuts off return bends from the electric motor driven, with cam operated mechanisms. The Mechanical Return Bender has no hydraulics and requires only electrical and pneumatic connections.



PRODUCTION

Up to 18 cycles per minute

Bends per Cycle:

5 mm: 4 - 6 b/c $6 \text{ mm} - \frac{1}{4}^{"}: 4 - 5 \text{ b/c}$ $7 \text{ mm} - \frac{3}{8}^{"}: 4 - 5 \text{ b/c}$ $12 \text{ mm} - \frac{1}{2}^{"}: 3 - 4 \text{ b/c}$ $\frac{5}{8}^{"}: 3 \text{ b/c}$ $\frac{3}{4}^{"}: 2 \text{ b/c}$

MATERIAL

5mm dia – ¾" dia Copper or Aluminum Straight lengths or coil tubing

FOOTPRINT

≈ 6.08' x 4.92' x 5.91' (4.9 m x 1.5 m x 1.8 m) ≈ 10,000 lbs (4,536 kg)

AIR

10 ft³/min at 80 psi (0.3 m³/min at 5.5 bar)

POWER

9 kW @ .80/.82 PF 24 VDC Controls **Foundation information supplied upon request

OAK SMALL BENDERS Tube Bending Machines



 OAK small bending machines turn out multiple bend angles easily and dependably. The cuts are straight and bend centers are accurate, protecting your investment in the quality of your final product.

Economic Advantages

- Point-of-use production of return bends enhances lean manufacturing processes.
- In-house production eliminates the shipping and handling costs of outsourced material.

Technical Advantages

- Can be configured to produce bends from a variety of materials.
- Various uncoiler designs allow the use of the most cost effective tubing coil configuration.

User Advantages

- Human Machine Interface (HMI) facilitates easy access to various operator controls and eliminates the need for manually adjusted hard stops.
- Guard design allows an unobstructed view of the tooling and working parts while ensuring the safety of the operator.
- Guarding is electronically locked during machine operation to ensure operator safety.
- Operator touch screen controls can be configured for different languages.