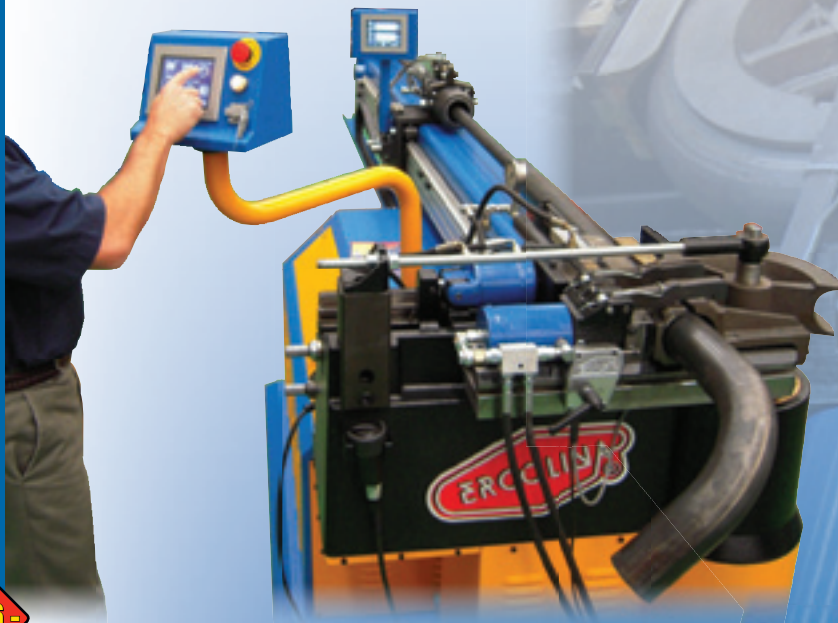
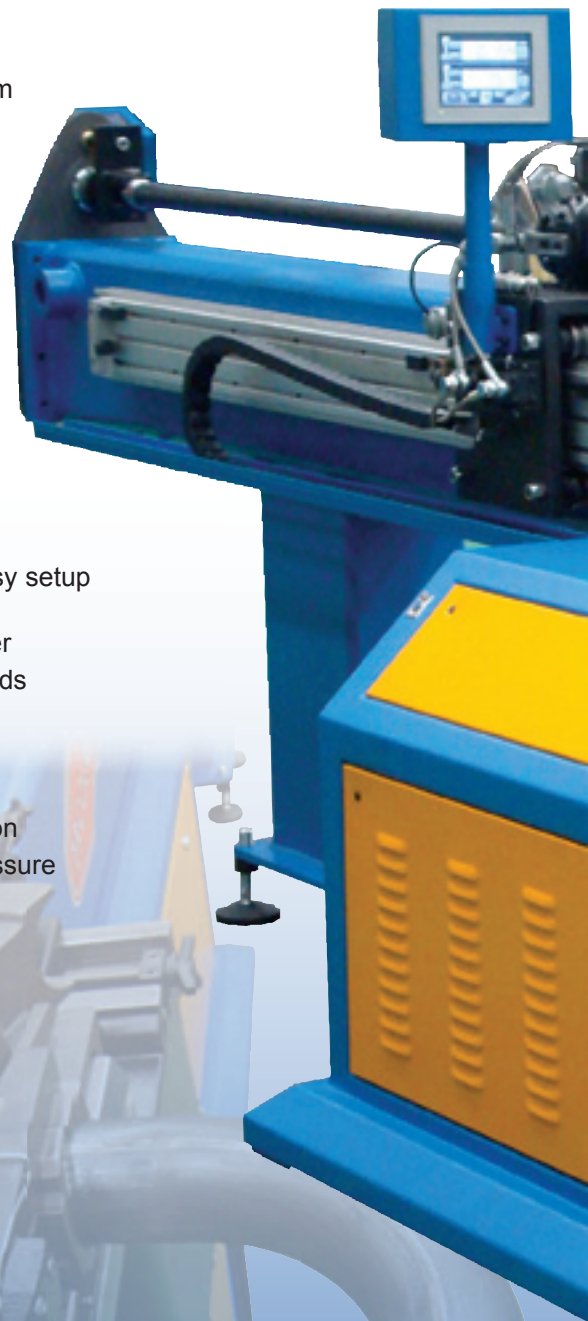


TM76 TOP MANDREL BENDER



Features

- Bending capacity to 3" round tube and multiple profiles
- Ideal for prototype or daily production
- Bend to CLR as small as 1.5D
- Accepts centerline bend radius to 10 inches
- Control offers easy access to manual and auto operating modes, system diagnostics and multiple languages
- USB for unlimited storage of bend programs, material library and job information
- Interactive touch screen displays absolute (ABS) or incremental (INC) positioning with inch or metric readout
- Programmable C axis with manual Y and B positioning
- Variable bending speed to 4 RPM with auto work sensing
- Programmable bend angle 0 to 180°
- Individual material spring back setting for every bend angle
- Programmable mandrel positioning with anticipated mandrel retraction, clamping, pressure die and boost die movements
- Pressure die with auto recapture minimizes distance between bends
- Heavy duty tailstock carriage with hydraulic clamping of work piece
- Tailstock Y and B position display resets to zero after each bend for easy setup while maintaining absolute position
- Bending head adjusts horizontally to maintain centerline radius of former
- Patented finger style clamping system minimizes distance between bends
- Hand-held remote control certified class three safety
- Direct drive electro-mechanical bending axis
- Precision encoders on all axes for greater repeatability
- Heavy one-piece steel structure improves rigidity and minimizes vibration
- Externally mounted gauges for adjustment of system and clamping pressure
- Accepts standard 030 mandrel tooling
- Electrical components UL, CSA and CE approved
- One (1) year limited warranty



Refer to **Page 19** for Standard Mandrel Tooling

TM76 TOP MANDREL BENDER



Touch screen with USB unlimited program storage.

Patented finger style (FST) clamping system.

Bending • Notching • Swaging • Ornamental • Metalworking Machinery

Part# **TM76**
Mandrel Capacity: **3"** Tube
2" Sch. 40 Pipe

Cost Effectively Replace Outdated Hydraulic Bending Machines with Innovative Technology from Ercolina®

TM76 TOP MANDREL BENDER

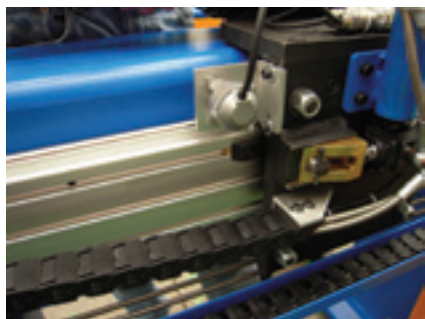


Touch screen display mounted to tailstock synchronizes with main control display.



Independent X-Y movement for precise wiper dies alignment.

Quick change tooling and mandrel rod connectors for improved productivity.



Mechanical stops control distance between bends and rotation from original bend plane.

Dimensions & Specifications

Max. Tube Capacity - Mild Steel	3" (.125 wall)
Stainless	3" (.095 wall)
Square Tube	2½" (.095 wall)
Max. Bending Radius	10"
Min. Bending Radius	.75" or 1.5" x Ø
Max. Shaft Rotation	210°
Max. Bending Angle	180°
Max. Tailstock Capacity	3"
Max. Tailstock Through Capacity	2¾"
Max. Material Length - 10' table	113"
20' table	231"
Minimum Distance Between Bends	Consult Factory
Nominal Hydraulic Pressure	150 bar
Maximum Carriage Travel	Consult Factory
Number of Programs	Unlimited with USB
Precision of Bend Angle	+/- .1°
Bending Speed	Variable to 25° per second
Motor 208V/480V 3ph at 50/60 Hz	2.2 kW 16 Amp @ 220V
Dimensions (Height - Width - Length)	61" x 36" x 168" or 286"
Weight (10' / 20')	2100 lbs. / 2500 lbs.

* Contact CML USA for complete technical specifications.
All capacities based on mild grade materials; heavy wall and high tensile materials reduce machine capacity.



Standard Mandrel Tooling for 030 & TM76 (Non-Ferrous)

Tube Diameter	CLR	Center Former	Wiper	Clamp	Polymer Pressure Die	Wall Thickness	Bronze Mandrel	Bronze Spheres	Tailstock Collet
1"	2"	AR53R051T1000	A243R051T1000	A223T1000	A20P3T1000	.065*	A21F33T100065	A21BS33T100065	Consult Factory
1 1/4"	2 1/2"	AR67R064T1250	A244R064T1250	A224T1250	A20P4T1250	.065*	A21F34T125065	A21BS34T125065	Consult Factory
1 1/2"	3"	AR84R076T1500	A241R076T1500	A221T1500	A201P1T1500	.065*	A21F41T150065	A21BS41T150065	Consult Factory
1 3/4"	3 1/4"	AR84R082T1625	A2414R082T1625	A2212T1625	A201P2T1625	.065*	A21F42T162565	A21BS42T162565	Consult Factory
1 1/2"	3 1/2"	AR100R089T1750	A2412R089T1750	A2212T1750	A201P2T1750	.065*	A21F42T175065	A21BS42T175065	Consult Factory
2"	4"	AR110R102T2000	A2413R102T2000	A2213T2000	A201P3T2000	.065*	A21F43T200065	A21BS43T200065	Consult Factory
2 1/4"	4 1/2"	AR121R114T2250	A2414R114T2250	A2214T2250	A201P4T2250	.065*	A21F44T225065	A21BS44T225065	Consult Factory
2 1/2"	5"	AR133R127T2500	A2415R127T2500	A2215T2500	A201P5T2500	.065*	A21F45T250065	A21BS45T250065	Consult Factory
3"	6"	AR178R152T3000	A2417R152T3000	A2217T3000	A201P7T3000	.065*	A21F47T300065	A21BS47T300065	Consult Factory

Pipe Diameter	CLR	Center Former	Wiper	Clamp	Polymer Pressure Die	Wall Thickness	Bronze Mandrel	Bronze Spheres	Tailstock Collet
1"	2 1/2"	AR100R067P1000	A244R067P1000	A224P1000	A204P1000	Sch. 40 .133*	A21F34P1000133	A21BS34P1000133	Consult Factory
1 1/4"	3"	AR84R076P1250	A241R076P1250	A2212P1250	A2012P1250	Sch. 40 .140*	A21F42P1250140	A21BS42P1250140	Consult Factory
1 1/2"	3"	AR84R076P1500	A241R076P1500	A221P1500	A2012P1500	Sch. 40 .145*	A21F42P1500145	A21BS43P1500145	Consult Factory
2"	4 3/4"	AR121R121P2000	A2414R121P2000	A2214P2000	A2014P2000	Sch. 40 .154*	A21F44P2000154	A21BS44P2000154	Consult Factory

Standard Mandrel Tooling for 030 & TM76 (Ferrous)

Tube Diameter	CLR	Center Former	Wiper	Clamp	Steel Pressure Die	Wall Thickness	Steel Mandrel	Steel Spheres	Tailstock Collet
1"	2"	AR53R051T1000	A243R051T1000	A223T1000	A204T1000	.065*	A21F13T100065	A21BS13T100065	Consult Factory
1 1/4"	2 1/2"	AR67R064T1250	A244R064T1250	A224T1250	A204T1250	.065*	A21F14T125065	A21BS14T125065	Consult Factory
1 1/2"	3"	AR84R076T1500	A241R076T1500	A221T1500	A2011T1500	.065*	A21F21T150065	A21BS21T150065	Consult Factory
1 3/4"	3 1/4"	AR84R082T1625	A2414R082T1625	A2212T1625	A2012T1625	.065*	A21F22T162565	A21BS22T162565	Consult Factory
1 1/2"	3 1/2"	AR100R089T1750	A2412R089T1750	A2212T1750	A2012T1750	.065*	A21F22T175065	A21BS22T175065	Consult Factory
2"	4"	AR110R102T2000	A2413R102T2000	A2213T2000	A2013T2000	.065*	A21F23T200065	A21BS23T200065	Consult Factory
2 1/4"	4 1/2"	AR121R114T2250	A2414R114T2250	A2214T2250	A2014T2250	.065*	A21F24T225065	A21BS24T225065	Consult Factory
2 1/2"	5"	AR133R127T2500	A2415R127T2500	A2215T2500	A2015T2500	.065*	A21F25T250065	A21BS25T250065	Consult Factory
3"	6"	AR178R152T3000	A2417R152T3000	A2217T3000	A2017T3000	.065*	A21F27T300065	A21BS27T300065	Consult Factory

Pipe Diameter	CLR	Center Former	Wiper	Clamp	Steel Pressure Die	Wall Thickness	Steel Mandrel	Steel Spheres	Tailstock Collet
1"	2 1/2"	AR100R067P1000	A244R067P1000	A224P1000	A204P1000	Sch. 40 .133*	A21F14P1000	A21BS14P1000133	Consult Factory
1 1/4"	3"	AR84R076P1250	A241R076P1250	A2212P1250	A2012P1250	Sch. 40 .140*	A21F22P125014	A21BS22P1250140	Consult Factory
1 1/2"	3"	AR84R076P1500	A241R076P1500	A221P1500	A2012P1500	Sch. 40 .145*	A21F22P150014	A21BS22P1500145	Consult Factory
2"	4 3/4"	AR121R121P2000	A2414R121P2000	A2214P2000	A2014P2000	Sch. 40 .154*	A21F24P200015	A21BS24P2000154	Consult Factory

Square Diameter	CLR	Center Former	Wiper	Clamp	Steel Pressure Die	Wall Thickness	Steel Mandrel	Steel Spheres	Tailstock Collet
1"	3"	AR84R076A1000	A243R076A1000	A223A1000	A203A1000	.065*	A21F13A100065	A21BS13A100065	Consult Factory
1 1/2"	4 1/2"	AR121R114A1500	A2411R114A1500	A2211A1500	A2011A1500	.083*	A21F21A150083	A21BS21A150083	Consult Factory
2"	6"	AR178R152A2000	A2413R152A2000	A2213A2000	A2013A2000	.120*	A21F23A2000120	A21BS23A2000120	Consult Factory

Note: Clamp surface on former and clamp areas are serrated unless special ordered. *Mandrels available specific to wall thickness. For non-stock tooling consult CML USA for delivery – Add fifteen percent for expedited delivery • Tube samples and work prints required • 100 percent non-refundable deposit must accompany order.



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