

MACHINE SPECIFICATIONS

Wallace Coast Model # 1004 Mandrel Tube Benders.

The capacity of both machines are 5" IPS schedule 80 carbon steel pipe.

This machine has the capabilities to bend round, square, rectangle and solid. (Solid bar capacity is 2" diameter.) Minimum distance between bends is 4.75"

Standard bend quality features for this machine include

Ovality not greater than 7% for mandrel bending.

Wall thinning less than 12.5% for 3XD bends.

Wrinkle free bending.

Tolerance levels of + -1 degree.

Length tolerance of + -1/16".

Expandit Company Tooling.

The following tooling is presently in house. With the volume of 3000 pieces we will tool up for any size within the capacity of our machines. All radius dies are center-line radius.

Diameter	Centerline Radius	Wall Thickness	Stainless Compatible
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1 1/2"	5"	.065 .125	NO
1 3/4"	2 1/2"	.065 16 gauge	NO
2"	2 1/2"	.065 16 gauge	YES
2"	3 1/2"	.065 16 gauge	YES
2 1/2"	3"	.083 14 gauge	YES
2 3/8"	7"	.154 SCH 40	NO
2 3/4"	2 3/4"	.083 14 gauge	NO
3"	3 1/2"	.065 16 gauge	YES
3"	4 1/2"	.065 16 gauge	YES
3 1/2"	4"	.065 16 gauge	NO
3 1/2"	6"	.065 16 gauge	NO
4"	4 1/2"	.065 16 gauge	YES
4"	6"	.065 16 gauge	YES
4"	8"	.065 16 gauge	YES
5"	6"	.065 16 gauge	NO

Ben Pearson Model #MC59HS Compression Bender.

The capacity of this machine is 3" diameter 14 gauge material.

This machine is a standard exhaust tube bender and does show distortion throughout the bend. Tolerance levels are + -1 degree and + -1/16".

Expandit Company Tooling.

Diameter	Centerline Radius	Wall Thickness	Stainless Compatible
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1"	3"	.065 to 1.25	YES
1 1/4"	3"	.065 to 1.25	YES
1 3/8"	3"	.065 to 1.25	YES
1 1/2"	3"	.065 to 1.25	YES
1 1/2"	4"	.065 to 1.25	YES
1 3/4"	3"	.065 to 1.25	YES
1 3/4"	4"	.065 to 1.25	YES
1 7/8"	3"	.065 to 1.25	YES
1 7/8"	4"	.065 to 1.25	YES
1 7/8"	5"	.065 to 1.25	YES
2"	3"	.065 to .083	YES
2"	4"	.065 to .083	YES
2"	5"	.065 to .083	YES
2 1/4"	3"	.065 to .083	YES
2 1/4"	4"	.065 to .083	YES
2 1/4"	5"	.065 to .083	YES
2 1/2"	4"	.065 to .083	YES
2 1/2"	5"	.065 to .083	YES
2 3/4"	5"	.065 to .083	YES
3"	5"	.065 to .083	YES