

MACHINE & PRODUCT CAPABILITIES

CNC MANDREL BENDING



12 Mandrel Benders
A mix of all-electric to hybrid mandrel benders
6" Max capacity

MAZAK MULTIPLEX 6200 W/GANTRY ROBOT



Primarily stainless and carbon bar, pipe, and DOM processing
Other materials as requested
10" Cutting diameter
LNS Automatic Bar Feeder

MAZAK VCN510C 40 TAPER MILL



Table size 51" x 21"
Primary and secondary processes include keyways, chamfers, tapped holes, profile milling, and other milling applications

MAZAK MULTIPLEX 6300 W/GANTRY ROBOT



Primarily stainless and carbon bar, pipe, and DOM processing
Other materials as requested
12" Cutting diameter

MAZAK INTEGRIX 200-IV ST



CNC turning and milling center
8" turning capacity
40 taper tooling
Primary stainless and carbon bar, pipe, and DOM processing

SAWING



4 Hyd-mech Production Bandsaws
Hydraulic bundling
Up to 13" capacity

Auto-jet
MUFFLER CORP.

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MACHINE & PRODUCT CAPABILITIES Continued ...

THERMAL CUTTING

Bodor P3015 6kW Sheet Laser
5ft x 10ft sheet capacity
6000 Watt Laser Source
1" capacity in carbon
5/8" capacity on stainless



DURMA PRESS BRAKE DT-15 CONTROL

Intuitive touch-screen control
Automatic calculation of bending sequence
Servo motorized back gauge
CNC Crowning
Length 8'4"
110 Tons



BEND-TECH DRAGON TUBE PLASMA

8" round capacity
24 ft feed length
Cut tube down to 0"



MACHINE & PRODUCT CAPABILITIES

Continued . . .

(2) HEXAGON ABSOLUTE ARM V2P

- AS1 Kit V2P
- V-Tube Laser Software
- Certified length 1016 mm
- Auto corrections to mandrel benders



BEND DIE LINE SHEET

MATERIAL NOTES

American-made steel

16 gauge aluminized steel unless otherwise noted

Dimensions shown in bold text are most commonly used and are preferred for most assemblies

For bends over 45 degrees or on stainless material, longer grip lengths are required

Standard slot depth is 1-1/8"

Hosebeads start at 3/4" OD

To ensure bend accuracy, provide XYZ coordinates

MORE OPTIONS AVAILABLE

Additional CLR and grip lengths available on single bend assemblies

Call regarding options larger than 6" diameter

Design Guidelines

Tube Size	Center Line Radius (CLR)	Grip Length
1.00"	1.00"	3.00"
1.00" 304 SS	1.00"	3.00"
1.25"	2.00"	3.00"
1.25" 304 SS	2.00"	3.00"
1.50"	2.00"	4.00"
1.50" 304 SS	2.00"	4.00"
1.75"	2.00"	4.00"
1.75" 304 SS	2.00"	4.00"
2.00"	2.00"	4.00"
2.00" 304 SS	2.00"	4.00"
2.25" 14 g.2	.25"	3.00" & 4.00"
2.25" 304 SS	2.25"	3.00" & 4.00"
2.50" 14 g.3	.00"	3.00" & 4.00"
2.50" 304 SS	3.00"	3.00" & 4.00"
2.50" 316 SS	3.00"	3.00" & 4.00"
2.75" 14 g.3	.00"	3.00" & 4.00"
2.75" 304 SS	3.00"	3.00" & 4.00"

Design Guidelines

Tube Size	Center Line Radius (CLR)	Grip Length
3.00"	3.50" & 4.50"	3.00", 4.00" & 6.00"
3.00" 304 SS	3.50" & 4.50"	3.00", 4.00" & 6.00"
3.00" 409 SS	3.50" & 4.50"	3.00", 4.00" & 6.00"
3.50"	4.00" & 6.00"	3.00" & 6.00"
3.50" 304 SS	4.00" & 6.00"	3.00" & 6.00"
3.50" 409 SS	4.00" & 6.00"	3.00" & 6.00"
4.00"	4.50" & 6.00"	3.00", 4.50" & 6.00"
4.00" 304 SS	4.50" & 6.00"	3.00", 4.50" & 6.00"
4.00" 316 SS	4.50" & 6.00"	3.00", 4.50" & 6.00"
4.00" 409 SS	4.50" & 6.00"	3.00", 4.50" & 6.00"
4.50"4	4.50"	6.00" & 8.00"
5.00"	5.00" & 6.00"	6.00", 8.00" & 12.00"
5.00" 304 SS	5.00" & 6.00"	8.00" & 12.00"
6.00"	6.00" & 9.00"	14.00"
6.00" 304 SS	6.00" & 9.00"	14.00"
7.00"	Ask for Details	Ask for Details
8.00"	Ask for Details	Ask for Details

PERFORMANCE SERIES EXHAUST BELLOWS

Designed to meet the unique challenges of the most demanding applications, Auto-jet Performance Series Exhaust Bellows are engineered to outperform at the highest levels and take the typical guesswork out of your bellows selection.

ZERO SCRAP WELD CAP

- T304 SS construction
- Delivers superior weld surface presentation
- Reduces risk of weld-related failures
- Offers ease of assembly | sealing
- Increases tangent | exterior braid support
- Protects bellows from weld spatter

MULTI-DIRECTIONAL WIRE BRAIDED COVER

- T304 SS construction
- Adds vibration resistance
- Increases thermal insulation
- Tolerates multi-directional movement
- Restrains non-specified motions
- Protects bellows from debris, installation damage, corrosive elements

SUPERIOR BELLOWS DESIGN

- Multi-ply T321 SS construction
- Proven | proprietary convolution geometry
- Hydroformed for consistency
- Designed to exceed standard life cycle
- Resists fatigue | vibration
- Most sizes in stock

SEGMENTED INTERLOCK LINER

- T304 SS construction
- Ultimate durability | flexibility
- Eliminates flow-induced noise | vibration
- Supports multi-directional movement
- Increases thermal insulation
- Exceptional flow characteristics

Tube Size	Auto-Jet Part #	Length in.		Movement in.		Spring Rates #/in.	
		Live	Overall	Axial	Lateral	Axial	Lateral
1.75	175X400BL	2.5	4	0.4	0.1	88	107
1.75	175X600BL	4.5	6	0.7	0.25	49	19
1.75	175X800BL	6.5	8	1	0.35	34	6
2	200X400BL	2.5	4	0.4	0.1	92	142
2	200X500BL	3.5	5	0.5	0.2	65	52
2	200X600BL	4.5	6	0.7	0.25	51	25
2	200X800BL	6.5	8	1.1	0.35	35	8
2.25	225X400BL	2.5	4	0.4	0.1	101	188
2.25	225X500BL	3.5	5	0.5	0.2	72	68
2.25	225X600BL	4.5	6	0.7	0.25	56	33
2.25	225X800BL	6.5	8	1.1	0.35	39	11
2.5	250X400BL	2.5	4	0.4	0.1	108	244
2.5	250X500BL	3.5	5	0.5	0.2	74	85
2.5	250X600BL	4.5	6	0.7	0.25	57	39
2.5	250X800BL	6.5	8	1.1	0.35	38	13
3	300X400BL	2.5	4	0.4	0.1	105	352
3	300X500BL2	3.5	5	0.5	0.2	69	110
3	300X600BL	4.5	6	0.7	0.25	59	63
3	300X700BL	5.5	7	0.9	0.3	52	33
3	300X800BL	6.5	8	1.1	0.35	41	21
3	300X1000BL	8.5	10	1.4	0.5	61	18
3	300X1200BL	10.5	12	1.7	0.6	56	11
3.5	350X400BL	2.5	4	0.4	0.1	110	489
3.5	350X600BL	4.5	6	0.7	0.25	62	87
3.5	350X800BL	6.5	8	1.1	0.35	43	28
3.5	350X1000BL	8.5	10	1.4	0.5	66	22
3.5	350X1200BL	10.5	12	1.7	0.6	61	16
4	400X400BL	2.5	4	0.35	0.1	226	986
4	400X500BL	3.5	5	0.4	0.15	197	483
4	400X600BL	4.5	6	0.5	0.2	145	240
4	400X700BL	5.5	7	0.75	0.25	127	126
4	400X800BL	6.5	8	1	0.3	102	84
4	400X1000BL	8.5	10	1.2	0.4	131	63
4	400X1200BL	10.5	12	1.6	0.5	106	35
5	500X400BL	2.3	4	0.35	0.06	341	3477
5	500X600BL	4.3	6	0.5	0.15	193	539
5	500X800BL	6.3	8	1	0.3	220	300
5	500X1000BL	8.3	10	1.2	0.4	176	136
5	500X1200BL	10.3	12	1.6	0.5	147	74
6	600X400BL	2.3	4	0.3	0.06	513	7257
6	600X600BL	4.3	6	0.5	0.15	285	1146
6	600X800BL	6.3	8	0.75	0.2	450	843
6	600X1000BL	8.3	10	1.1	0.25	310	339
6	600X1200BL	10.3	12	1.5	0.35	266	191

PIPE THERMAL WRAP

Adhesive

Adhesive type:	Synthetic Polymer
Color:	Light Brown
Molten Tack:	Medium
Application Temp:	350°F

Fiber Blanket

Color:	White
Max Service Temp:	2200°F
Operating Temp:	2000°F
Shrinkage at 2000°F/24hrs:	0 - 1.5%
Specific Heat (BTU/LBS/F):	0.27
Avg Fiber Diameter:	2-3 Microns
Density, lbs/ft ³ (kg/m ³):	8 (128)

Aluminum Foil Tape

Substrate:	2.0-mil Aluminum Foil
Adhesive:	1.3-mil Acrylic
Tensile Strength:	17-lbs/in
Elongation:	2.5%

Fiberglass Mesh Sleeve

Continuous Operating Temp:	1200°F Max
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Stainless Steel Clamping Strap

Alloy:	304 Stainless Steel
Type:	Ball Lock
Min. Loop Tensile Strength (lbs):	300
Color:	Natural
Width:	0.31 Inches
Thickness:	0.010 Inches

Thermal Conductivity

Mean Temperature	Thermal Conductivity, BTU-in/hr-ft ² -°F(W/m ² K)
392°F (200°C)	0.35 (0.051)
752°F (400°C)	0.59 (0.085)
1112°F (600°C)	0.90 (0.13)
1472°F (800°C)	1.25 (0.18)
1832°F (1000°C)	1.73 (0.25)

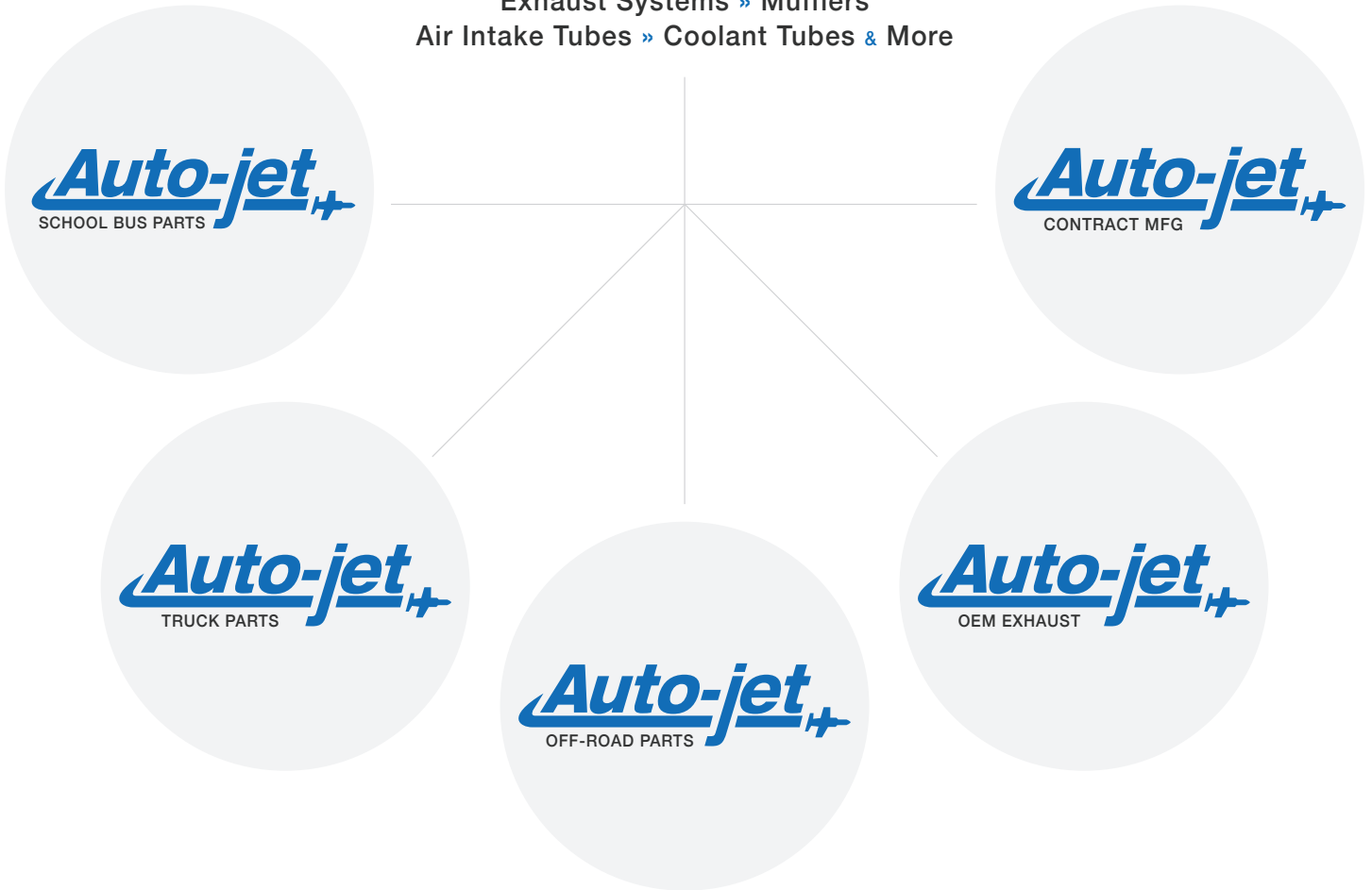


Wrapping Installation

1. Adhesive applied to the back of the fiber blanket and cut to required length.
2. Fiber blanket applied to the circumference and length of the pipe as required by customer drawings or samples provided.
3. Apply aluminum tape covering the entire insulated area of pipe surface and extending on to bare pipe for proper adhesion.
4. Fiberglass mesh sleeve applied over the insulated areas of the pipe as required by customer drawings or samples provided.
5. Stainless steel straps applied at the ends of the fiberglass mesh sleeve to secure in place.

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