



® 联安机械
L&A MACH-TECH



液压管路加工设备

HYDRAULIC TUBE PROCESSING EQUIPMENT

www.la-mach.com



企业简介

About Us

秦皇岛联安机械科技有限公司是免焊接液压管路加工设备的专业制造商，设备广泛应用于工程机械，船舶，钢厂，矿山，装备制造，航空航天等液压系统中。

随着时代发展、科技的进步，高品质的产品越来越备受青睐。我公司紧跟市场需求，不断研发新产品，从不同角度来满足客户的需求。目前我公司生产的设备可实现卡套式管路连接，扩口式管路连接，挤压成型式管路连接，37度/90度扩口法兰连接，保持环式管路连接等免焊接技术。

管路无焊接安装不仅缩短产品安装周期，避免污染，并且提高了液压系统的稳定性、可靠性、为客户大幅降低了产品制造成本和液压系统的故障率。

品质是企业的生命，以卓越的产品和服务，取得客户的认同和满意，一直是我们所追求的目标。所有产品通过ISO9001及CE认证，我们的品质经得起考验！

公司凭借稳定的产品质量，产品已销往全国各地及欧美、东南亚、南美等国际市场，并取得客户的信赖。我们的目标是——通过不懈努力，使联安成为世界领先的液压管路加工设备的专业制造商！

Qinhuangdao L&A Mach-Tech Co.Ltd. is a professional manufacturer of Hydraulic Tube Processing Equipment. Our products are widely used in these Hydraulic Systems: construction machinery industry, marine field, steel plant, mining, equipment manufacturing industry, aerospace and so on.

With the development of technology, high-level products are more and more popular. With the requirement of the markets, we are always developing new equipments according to the needs of customer. At present, Our equipments can realize Bite cutting ring fitting system; flare fitting system; 37°/90° flare flange connection system; Retain ring system; LAFORM & Seal tube reshaping system and so on. With the application of non-welded pipeline technology, more and more factories realized such installation. It not only shortens installation cycle, preventing pollution, but also lowering the cost and failing rate of Hydraulic System, improving its reliability, stability and sealability.

Quality is the life of the enterprise. What we are pursuing is to obtain recognition and satisfaction of customers with excellent product and service. All products have passed ISO9001 Certificate and CE Certificate. Our quality stands the test of time.

Rely on the stable quality, our products are sold to European and American Markets, Southeast Asian Markets, all over China and achieved recognition of customers. We aim to be the first class of the Professional manufacturer of Hydraulic Tubing Processing Equipments in the world.



企业文化

Enterprise Culture



| 目标 Aim

对提高全世界工业产品的品质有所助益!

To help improve the quality of industrial products all over the world!



| 团队 Team Work

我们旨在成为员工心目中最受欢迎的工作场所。

We aim to become the home of our staffs.



| 市场 Marketing

打造行业最具竞争力的产品!

Make the most competitive products in the industry.



| 客户 Clients

我们旨在成为客户心目中最信任的合作伙伴!

We aim to become the most trusted partner!

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2 硬管系列 Rigid Tube Series

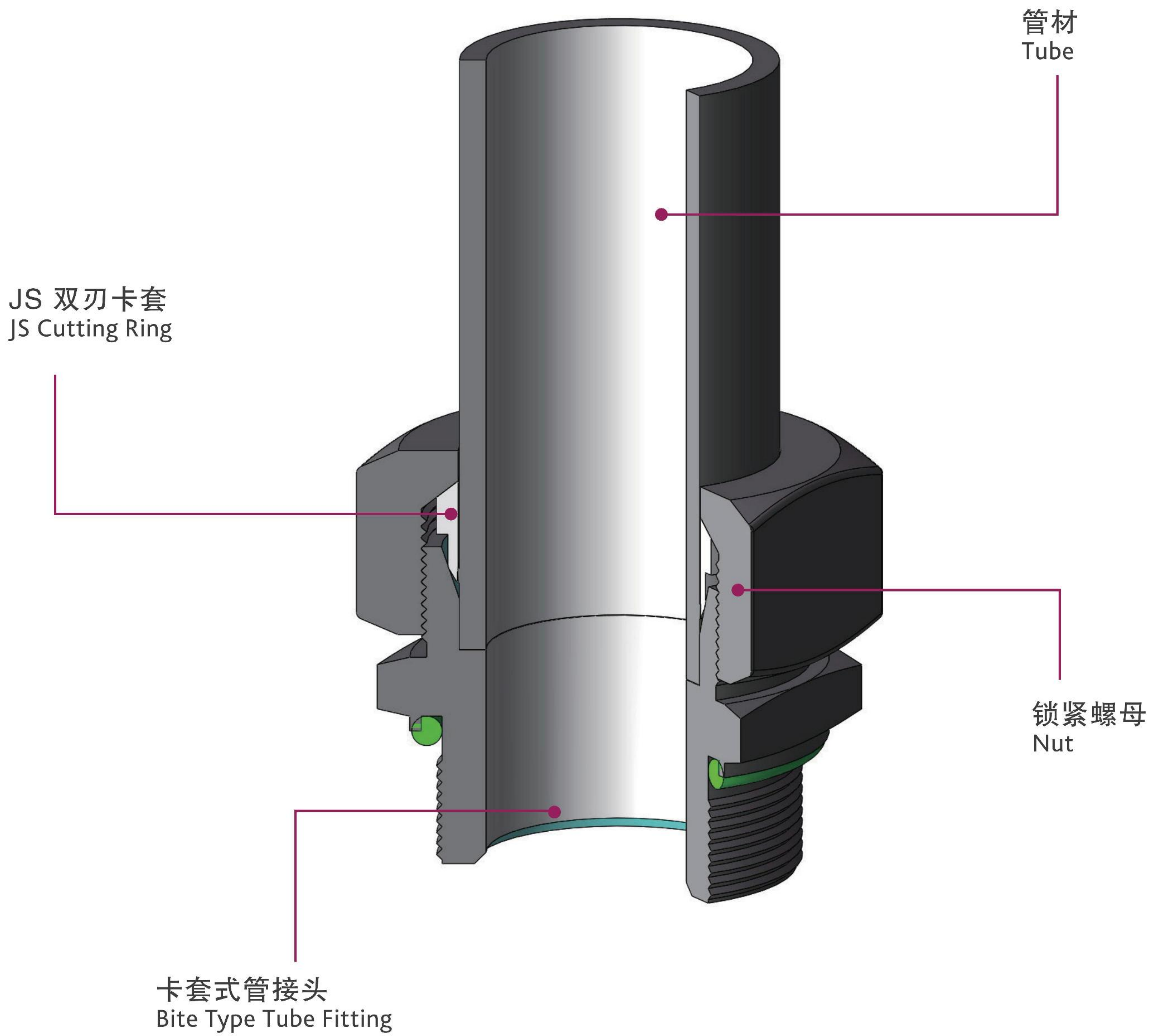
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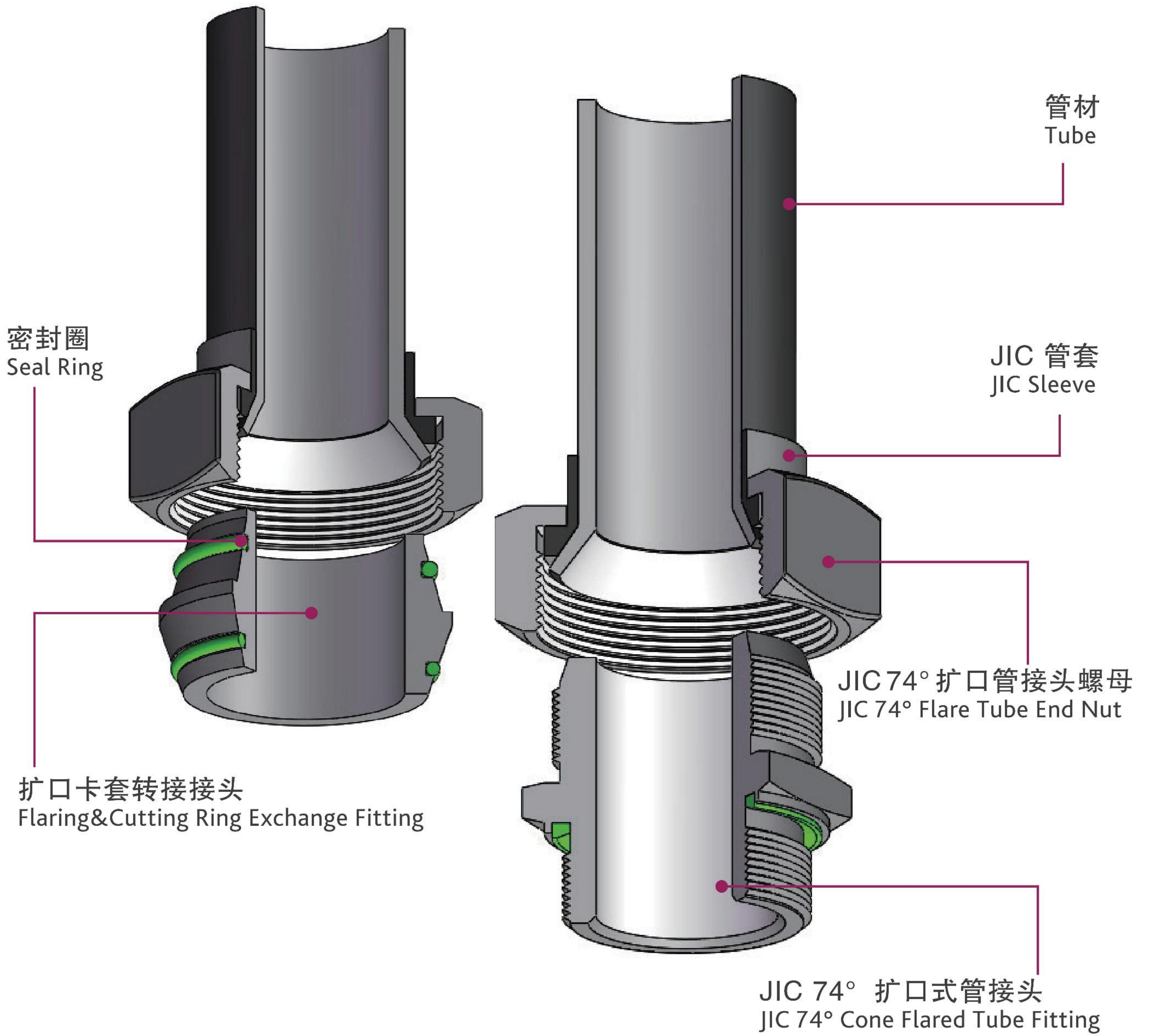
卡套式管接头连接

BITE CUTTING RING FITTING SYSTEM



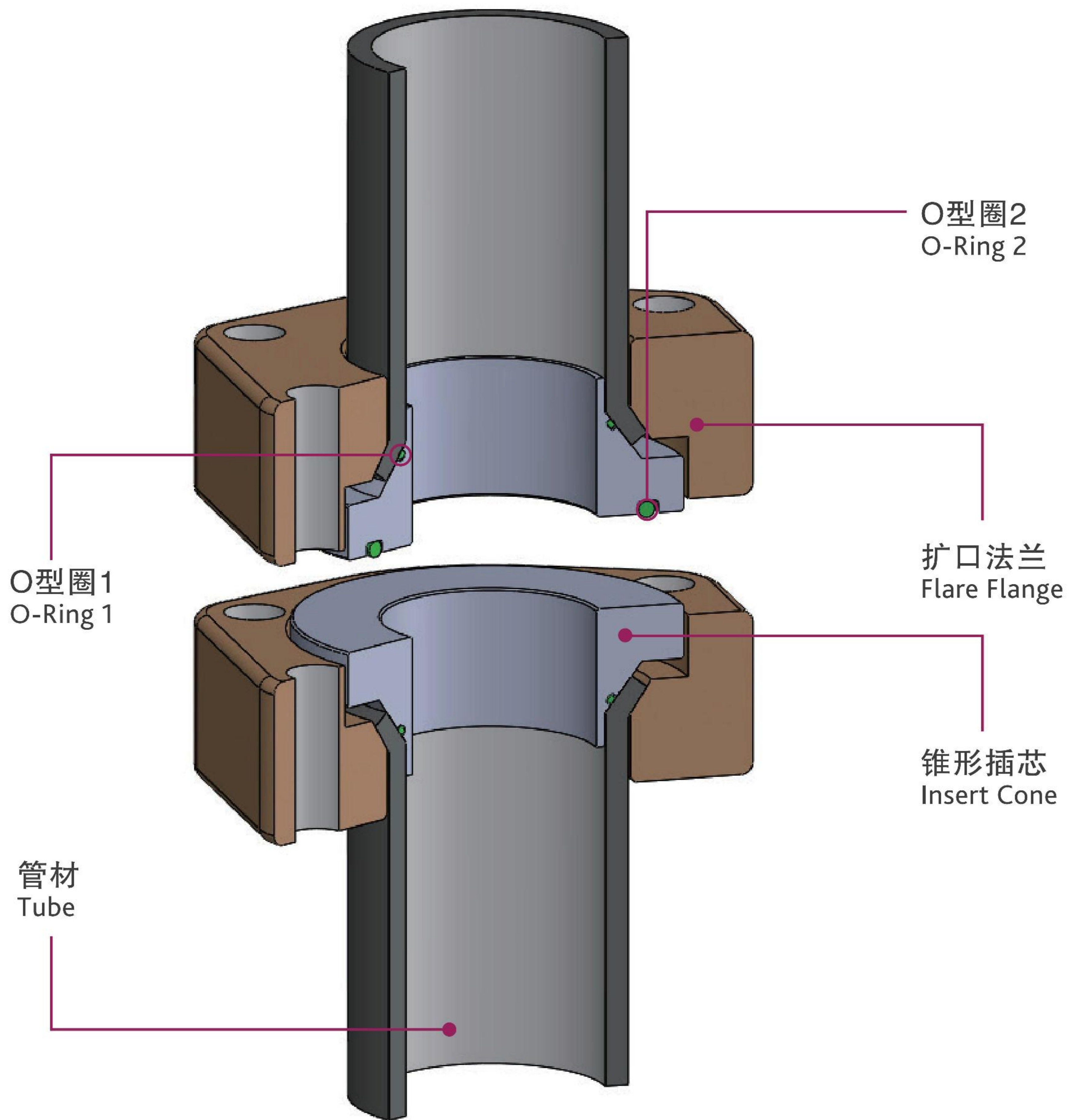
JIC 37° 扩口式管接头连接

JIC 37° FLARE FITTING SYSTEM



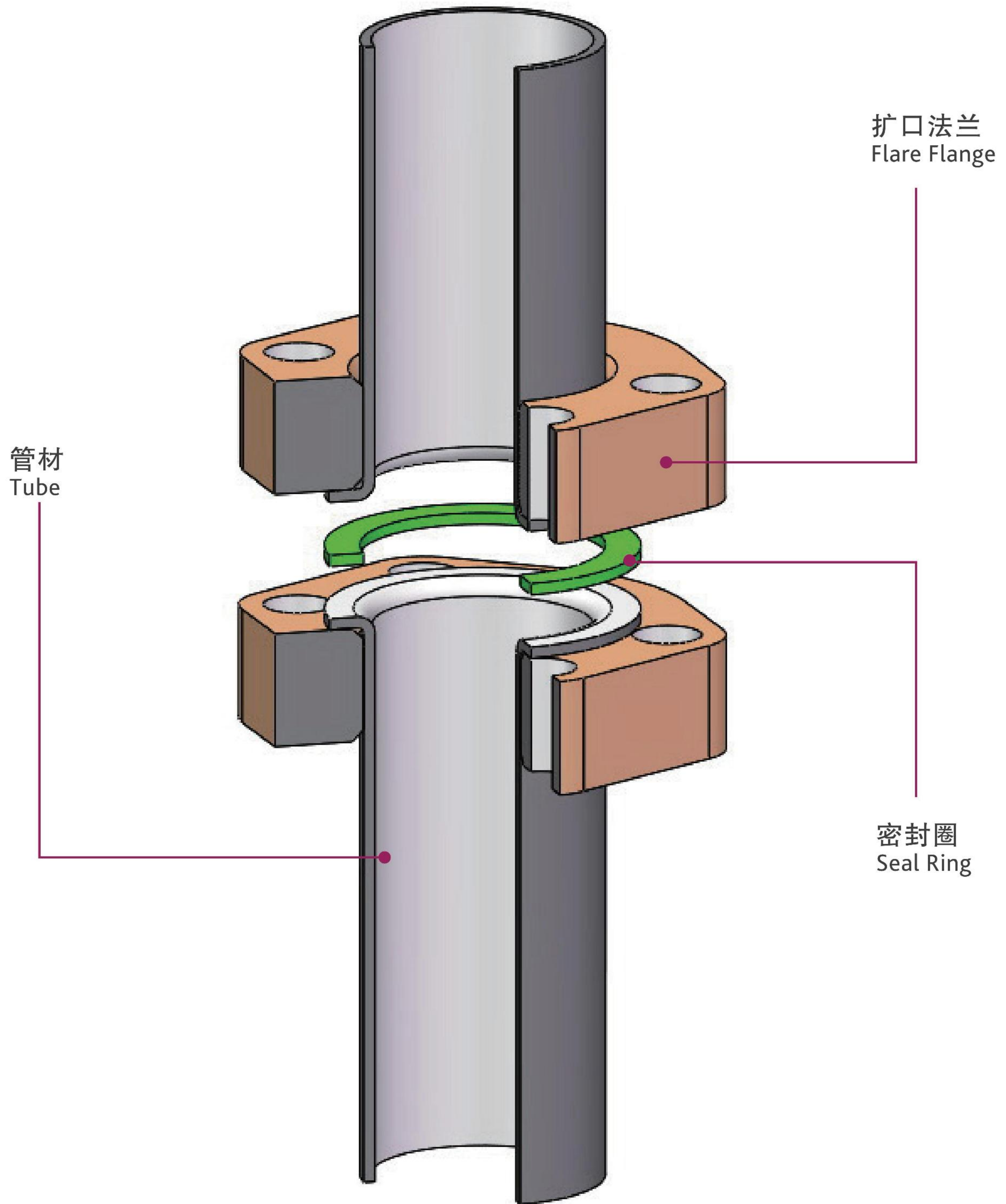
37° 扩口式法兰连接

37° FLARE FLANGE SYSTEM



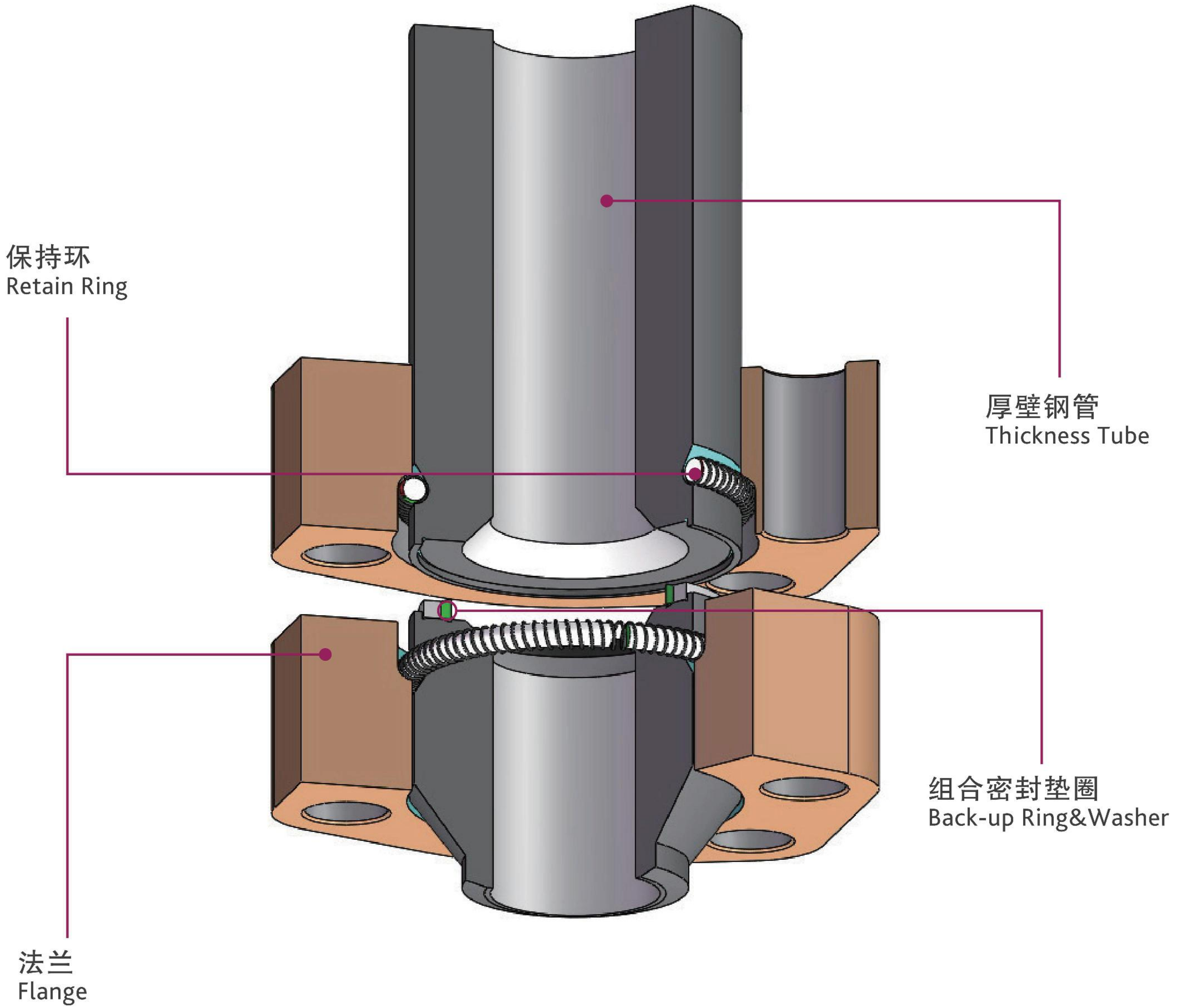
90° 扩口式法兰连接

90° FLARE FLANGE SYSTEM



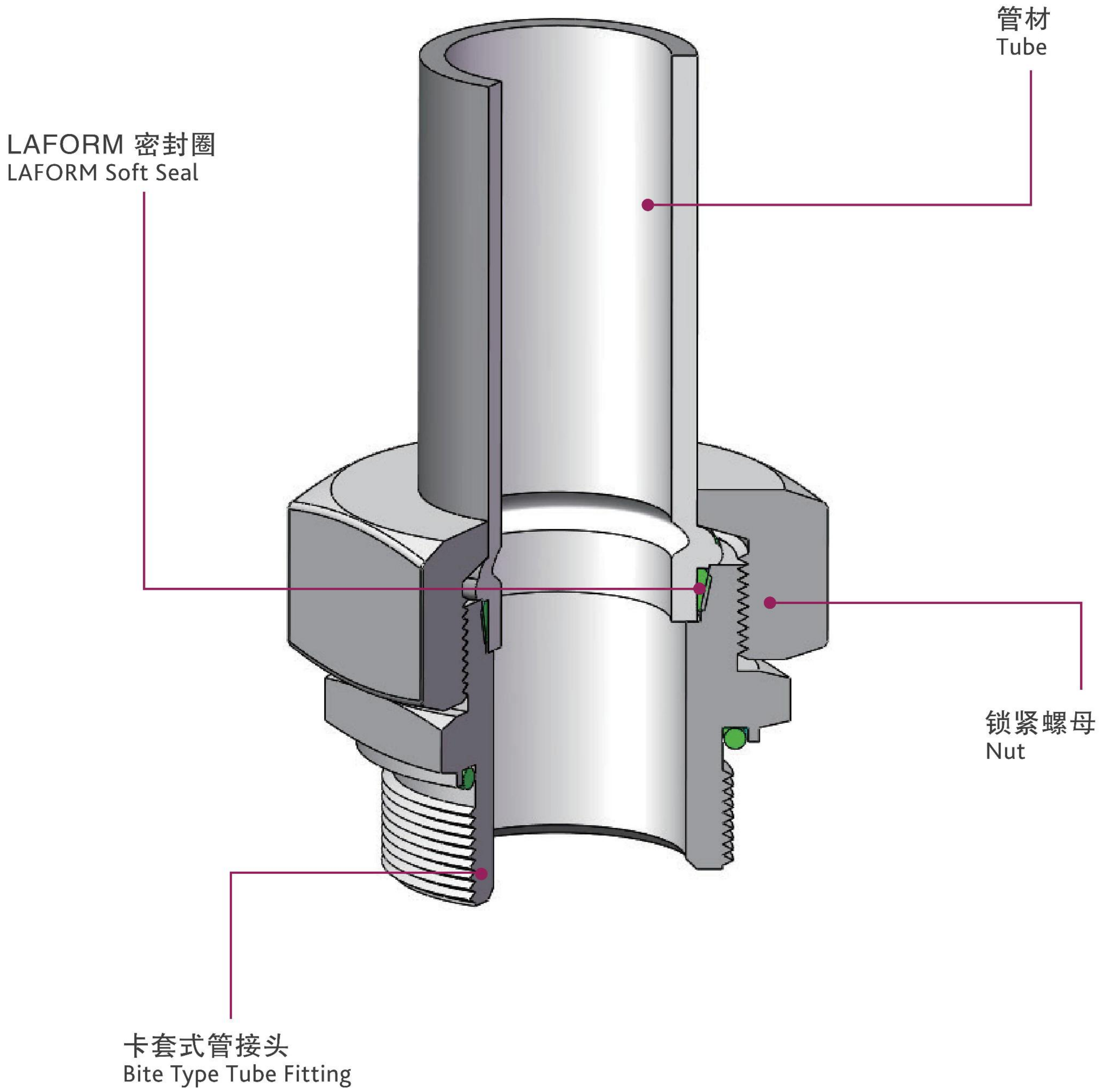
保持环法兰连接

RETAIN RING FLANGE SYSTEM



LAFORM 管端挤压成型密封连接

LAFORM&SEAL TUBE RESHAPING SYSTEM



钢管加工中心

TUBE PROCESSING CENTER



技术参数

Technical Data

	TPC642	AWX642
24° 卡套预装 24° PRE-ASSEMBLING	6x1-42x4mm	6x1-42x4mm
37° 扩口 37° FLARING	6x1-42x4mm	6x1-42x4mm
切管 CUTTING	MAXΦ100mm (4")
弯管 BENDING	6x1-42x4mm	6x1-42x4mm
去毛刺 DEBURRING	MAXΦ42x4mm	6x1-42x4mm
材质 MATERIALS	不锈钢/AISI316 TI-碳钢/ST37.4	不锈钢/AISI316 TI-碳钢/ST37.4
尺寸: 长×宽×高 DIMENSIONS LxWxH	2100x880x1270mm	980x500x1060mm
重量 WEIGHT	300KG	150KG
标准电压 STANDARD VOLTAGE	380V/50Hz/3Ph	380V/50Hz/3Ph
电机功率 MOTOR POWER	MAX4.05KW	MAX1.5KW
压缩空气流量 COMPRESSED AIR	115L/MIN
安全保护装置 SAFETY PROTECTION	Incl.	Incl.
操作板 CONTROL BOARD	Incl.	Incl.
液压油 OIL	Incl.	Incl.
模具盒 TOOL HOLDER	Incl.

标配

STANDARD



β形销
β PIN



电控手柄
ELECTRICAL BORAD

选配

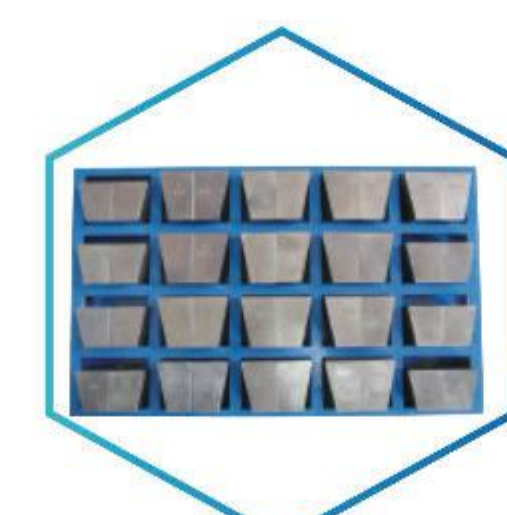
OPTIONAL



油刷/油壶
BRUSH/OIL HOLDER



卡套预装模具
PRE-ASSEMBLING DIES



37度扩口模具
37°FLARING DIES



37度扩口模块
37°FLARING BLOCK



弯管模具
BENDING DIES

卡套预装/扩口两用机

FLARING&CUTTING RING PRE-ASSEMBLY MACHINE



技术参数

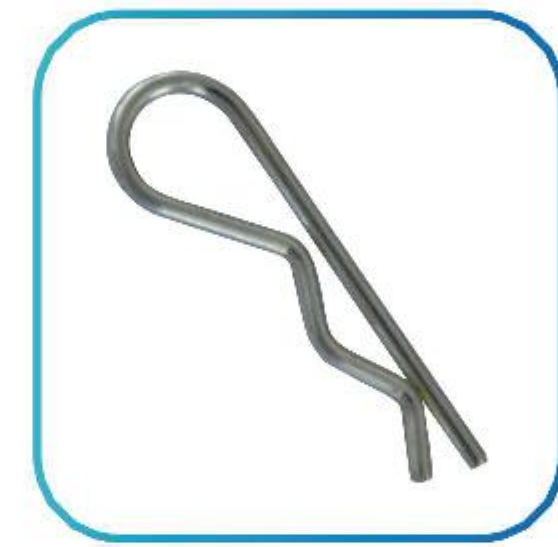
Technical Data

	UNIPRESS PRE-FL/01	M-UNIPRESS PRE-FL/01
24° 卡套预装 24°PRE-ASSEMBLING	6x1-42x4mm	6x1-42x4mm
37° 扩口 37°FLARING	6x1-42x4mm	6x1-42x4mm
材质 MATERIALS	6x1不锈钢/AISI316 TI-碳钢/ST37.4	6x1不锈钢/AISI316 TI-碳钢/ST37.4
重量 WEIGHT	59KG	41KG
尺寸: 长×宽×高 DIMENSIONS L×W×H	610×430×225mm	420×345×235mm
标准电压 STANDARD VOLTAGE	380V 50Hz 3PH
电机功率 MOTOR POWER	0.75Kw
液压油 OIL	Incl.	Incl.

套筒 Socket ΦMM	06L	06S	08L	08S	10L	10S	12L	12S	14S	15L	16S	18L	20S	22L	25S	28L	30S	35L	38S	42L	
挡板 Plate ΦMM	06		08		10		12		14	15	16	18	20	22	25	28	30	35	38	42	
37度扩口夹具 37 Flaring Clamps ΦMM	06	08	10	12	14	15	16	18	20	22	25	28	30	32	35	38	42				

标配

STANDARD



β形销
β PIN

选配

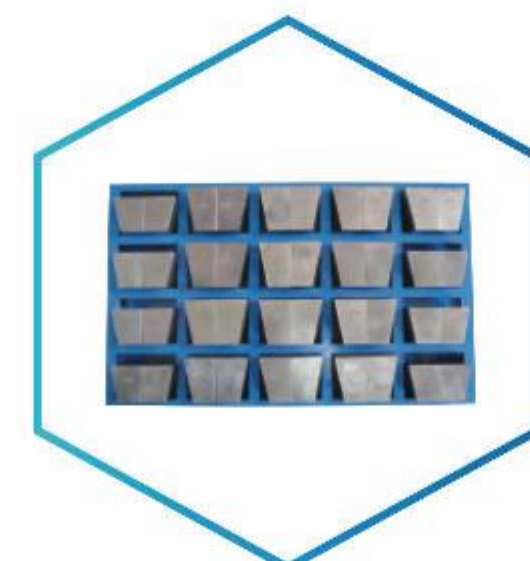
OPTIONAL



油刷/油壶
BRUSH/OIL HOLDER



37度扩口模块
37°FLARING BLOCK



37度扩口模具
37°FLARING DIES



卡套预装模具
PRE-ASSEMBLING DIES



直流电源12V
12V VOLTAGE



37度扩口顶杆、顶尖
37°FLARING PIN

弯管机

TUBE BENDING MACHINE



技术参数

Technical Data

	EHTB642	MHTB642
弯管 BENDING	6x1-42x4mm	6x1-42x4mm
材质 MATERIALS	不锈钢/AISI316 TI-碳钢/ST37.4	不锈钢/AISI316 TI-碳钢/ST37.4
尺寸：长×宽×高 DIMENSIONS L×W×H	735×910×940mm	880×420×710mm
重量 WEIGHT	125Kg	51KG
标准电压 STANDARD VOLTAGE	380V 50Hz 3PH (220V 50Hz 1PH可选)
电机功率 MOTOR POWER	1.5KW
操作板 CONTROL BOARD	Incl.
限位开关 LIMIT SWITCH	电子限位开关 ELECTRIC SWITCH	机械限位开关 MECHANICAL LIMIT SWITCH
液压油 OIL	Incl.
模具贮存支架 TOOLS HOLDER STAND	Incl.	Incl.

标配 STANDARD



电控手柄
ELECTRICAL BOARD

选配 OPTIONAL



油刷/油壶
BRUSH/OIL HOLDER

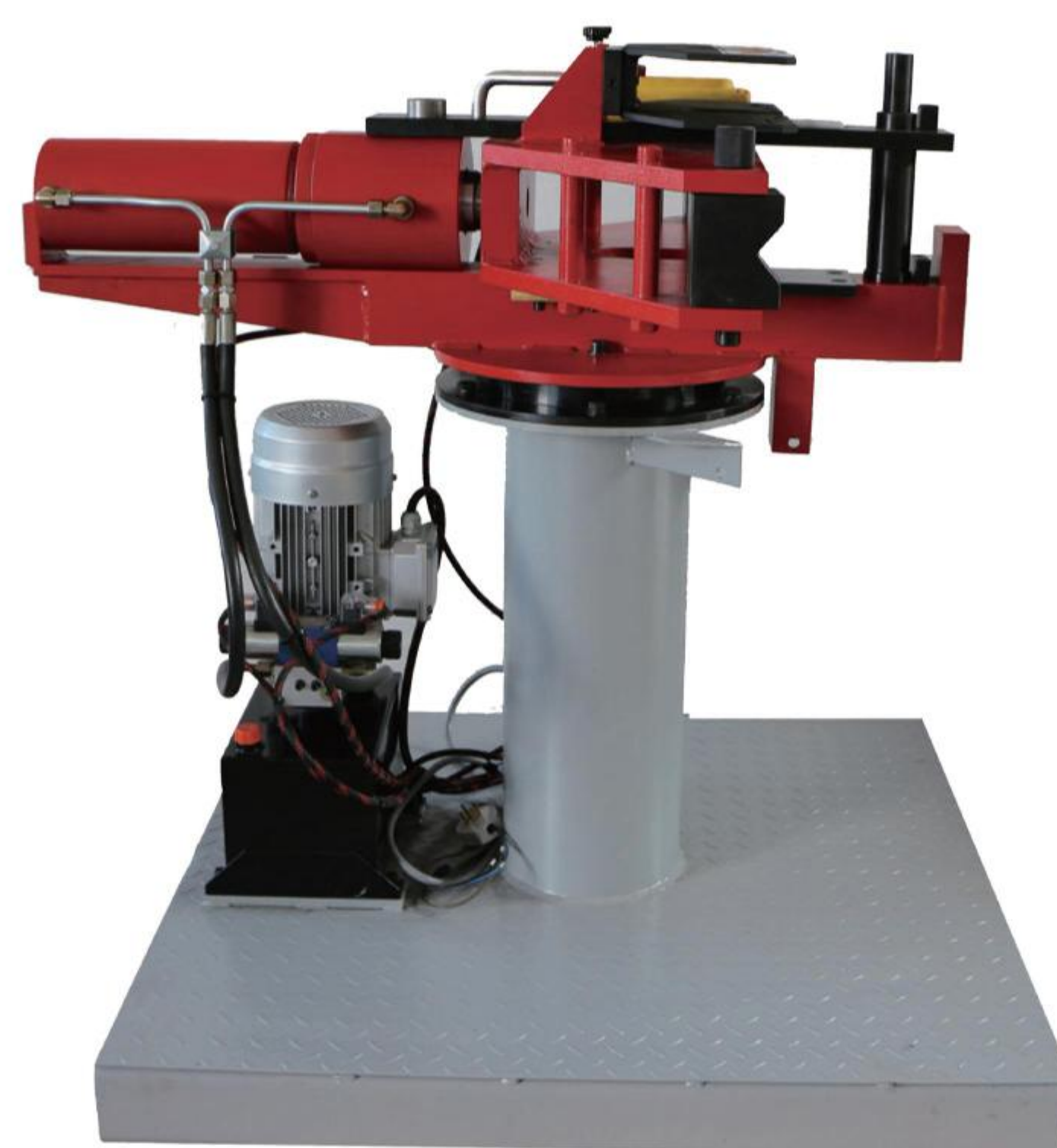
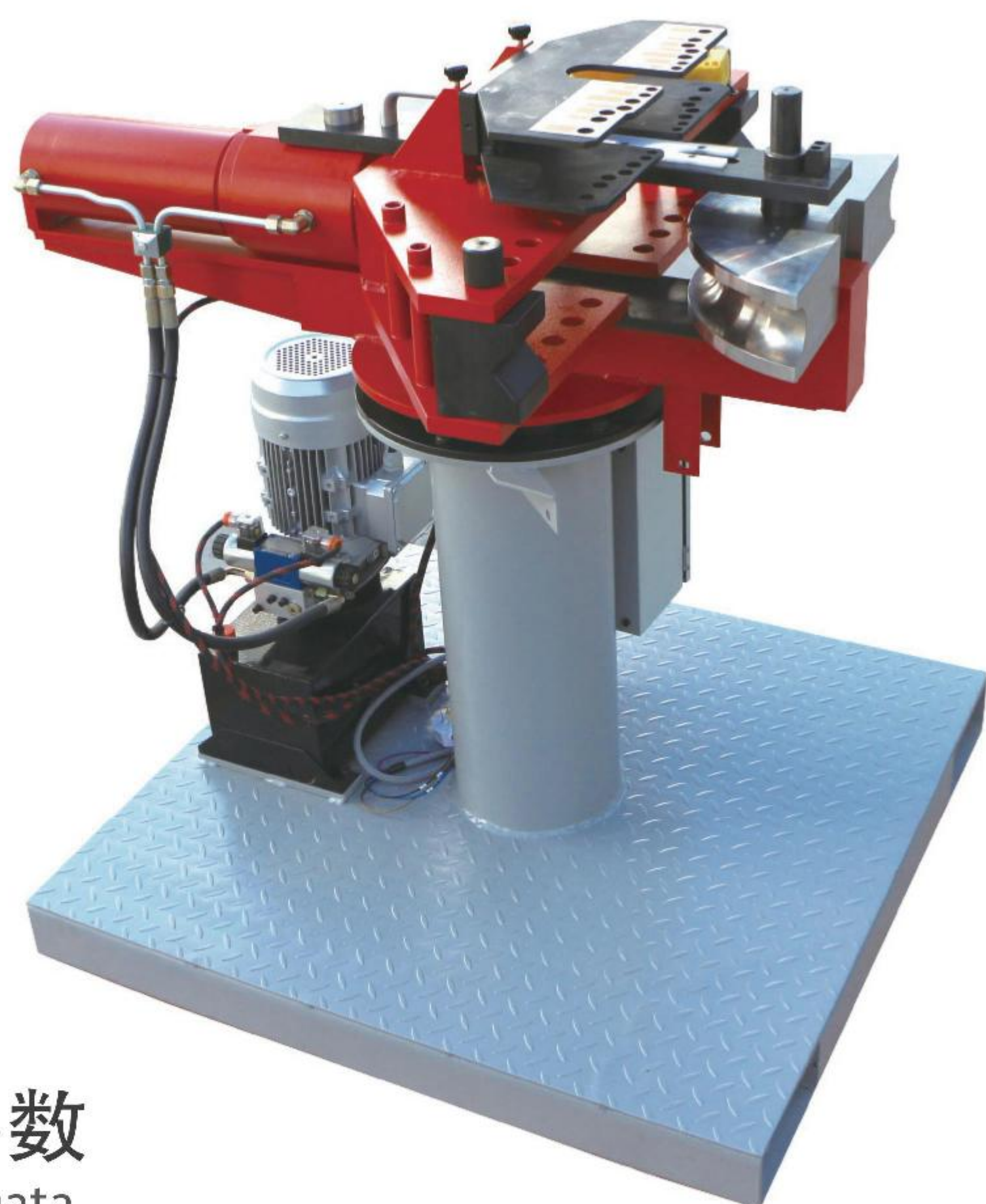


弯管模具
BENDING DIES

弯管模具 Bending Dies ΦMM	06	08	10	12	14	15	16	18	20	22	25	28	30	32	35	38	42
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移动式电动液压弯管机

REMOVABLE ELECTRIC HYDRAULIC TUBE BENDING MACHINE



技术参数

Technical Data

EHTB660	
管件直径范围 TUBE SIZE	6.0mm-60.3mm
管件最大壁厚 (碳钢管) CARBON STEEL TUBE THICKNESS	60.3mmx15mm
管件最大壁厚 (不锈钢管) STAINLESS STEEL TUBE THICKNESS	60.3mmx12.5mm
机器外形尺寸 (长×宽×高) DIMENSIONS:L×W×H	1000x960x1200mm
机器重量 WEIGHT WITHOUT DIES	500KGS(不含模具)
标准电压 STANDARD VOLTAGE	380V 50Hz 3PH
电机功率 MOTOR POWER	2.2Kw
工作压力 WORKING PRESSURE	200Bar
最大压力 MAX.PRESSURE	250Bar
用油量 CAPACITY OF OIL TANK	7.5L
油牌号 OIL BRAND	HLP46

标配 STANDARD



电控手柄
ELECTRICAL BORAD

选配 OPTIONAL



油刷/油壶
BRUSH/OIL HOLDER



弯管模具
BENDING DIES

旋压扩口机 (手动泵式)

MANUAL PIPE FLARING MACHINE




技术参数


Technical Data

FL-90	
标准电压 STANDARD VOLTAGE	380V 50Hz 3PH
电机功率 MOTOR POWER	0.37KW
蜗杆减速机速比 REDUCTION RATIO	i=80
系统最大压力 MAX PRESSURE	15MPa
外形尺寸: 长×宽×高 DIMENSIONS: L×W×H	780×580×1220mm
扩口管直径 (MM) TUBE DIAMETER	Φ15×1.5-Φ90×6.0MM
扩口角度 FLARING	37°/90°
总重 WEIGHT	280KG

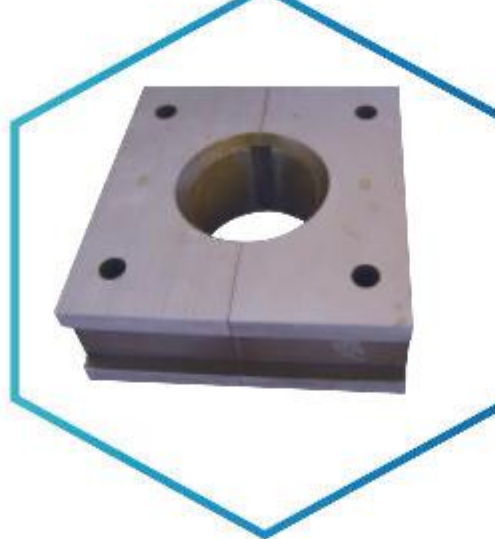
选配
OPTIONAL




37度旋压头
37°FLARING CONE



90度旋压头
90°FLARING CONE



扩口管夹
FLARING CLAMP



油刷/油壶
BRUSH/OIL HOLDER

37度旋压头 37°FLARING PIN	Φ10-Φ38	Φ38-Φ60	Φ60-Φ76	Φ76-Φ90
90度旋压头 90°FLARING PIN	Φ10-Φ42	Φ42-Φ90		
扩口管夹 FLARING CLAMP	Φ10-Φ90			

电动式旋压扩口机

ELECTRIC PIPE FLARING MACHINE



技术参数

Technical Data

	FL-90E	FL170E
标准电压 STANDARD VOLTAGE	380V 50Hz 3PH	380v50Hz 3PH
电机功率 MOTOR POWER	2.05KW	3.3KW
蜗杆减速机速比 REDUCTION RARIO	i=80	i=80
系统最大压力 MAX PRESSURE	8MPa	17MPa
旋压工作压力 WORKING PRESSURE	4MPa	15MPa
扩口管直径 TUBE DIAMETER	Φ15x1.5-Φ90x6.0 (碳钢Carbon Steel)	φ 16x2.0- φ 170x8.0
扩口角度 FLARING DEGREE	37/90°	37/90°
尺寸: 长×宽×高 DIMENSIONS: L×W×H	770x580x1250mm	1490x1285x1485
重量 WEIGHT	350KG	1450KG

标配 STANDARD



胶皮锤
RUBBER HAMMER

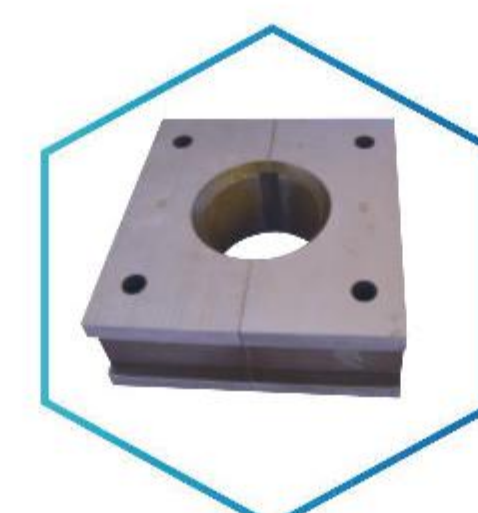
选配 OPTIONAL



37度旋压头
37°FLARING CONE



90度旋压头
90°FLARING CONE



扩口管夹
FLARING CLAMP



油刷/油壶
BRUSH/OIL HOLDER

37度旋压头 37° Flaring Cone	Φ10-Φ38	Φ38-Φ60	Φ60-Φ76	Φ76-Φ90	Φ90-Φ115	Φ115-Φ140	Φ140-Φ170
90度旋压头 90° Flaring Cone	Φ10-Φ42	Φ42-Φ90	Φ90-Φ115	Φ115-Φ170			
扩口管夹 Flaring Clamp	Φ10-Φ90	Φ16-Φ170					

钢管内外去毛刺机

INTERNAL & EXTERNAL TUBE DEBURRING MACHINE



技术参数

Technical Data

TD642	
去内毛刺 INTERNAL DEBURRING	6-42MM
去外毛刺 EXTERNAL DEBURRING	6-42MM
材质 MATERIALS	不锈钢/AISI316- Ti-碳钢/ST37.4
重量 WEIGHT	33KG
标准电压 STANDARD VOLTAGE	220V 50Hz 1PH
电机功率 MOTOR POWER	0.2Kw
尺寸: 长×宽×高 DIMENSIONS: L×W×H	380×420×320mm
转速/每分钟 REVOLUTIONS/MINUTE	75转/分 75r/min.
内、外去毛刺刀具 INT./EXT.DEBURRING TOOLS	Incl.

 标配
STANDARD



内、外去毛刺刀具
INT./EXT.DEBURRING TOOLS

LAFORM 管端挤压成型机

LAFORM TUBE RESHAPING MACHINE



技术参数

Technical Data

	WF642A	WF642C
管径范围 TUBE DIAMETER RANGE	8-42MM	8-42MM
加工壁厚 WALL THICKNESS	1.5-5.0MM	1.5-5.0MM
最大加工长度 MAX LENGTH	6000MM (根据客户需求加长) (according to clients'demand)	6000MM (根据客户需求加长) (according to clients'demand)
送料方式 FEEDING WAY	手动 MANUAL	手动 MANUAL
加工速度 WORKING SPEED	2Pcs/min	2Pcs/min
电机功率 MOTOR POWER	2.8KW	2.8KW
标准电压 STANDARD VOLTAGE	380V 50Hz 3PH	380V 50Hz 3PH
最大压力 MAX HYDRAULIC PRESSURE	60MPa	60MPa
油箱容量 CAPACITY OF OIL TANK	5L	5L
重量 WEIGHT	240KG	380KG
尺寸: 长×宽×高 DIMENSIONS:L×W×H	900×750×260mm	960×550×1060mm
夹具 CLAMP	8-42MM (根据客户需求定制) (according to clients'need)	8-42MM (根据客户需求定制) (according to clients'need)
顶具 DIE	8-42MM (根据客户需求定制) (according to clients'need)	8-42MM (根据客户需求定制) (according to clients'need)

标配 STANDARD



油刷/油壶
BRUSH/OIL HOLDER

选配 OPTIONAL



夹具/顶具
CLAMP/DIE

LAFORM 管端挤压成型机

LAFORM TUBE RESHAPING MACHINE



伺服控制系统，可根据管径的变化选择不同的成型压力。节能，环保、高效。大功率冷却器，适用批量管路连接。新机型美观、操作便捷，维修方便。

Servo control system;According tube diameter adjust reshaping pressure;Energy conservation and environmental protection, high efficiency ;High power cooling applicable to mass production .New design shape ,easy operation and maintainance.

技术参数

Technical Data

	WF642S
管径范围 TUBE DIAMETER RANGE	8-42MM
加工壁厚 WALL THICKNESS	1.5-5MM
最大加工长度 MAX LENGTH	6000MM (根据客户需求加长)
送料方式 FEEDING WAY	手动(Manual)
加工速度 WOOKING SPEED	2Pcs/min
电机功率 MOTOR POWER	5.5KW
标准电压 STANDARD VOLTAGE	380v 50HZ 3PH
最大压力 MAX HYDRAULIC PRESSURE	60MPa
油箱容量 CAPACITY OF OIL TANK	15L
重量 WEIGHT	450KG
尺寸：长×宽×高 DIMENSIONS:LxWxH	1150x685x1050mm
夹具 CLAMP	8-42MM
顶具 DIE	8-42MM

标配 STANDARD



油刷/油壶
BRUSH/OIL HOLDER

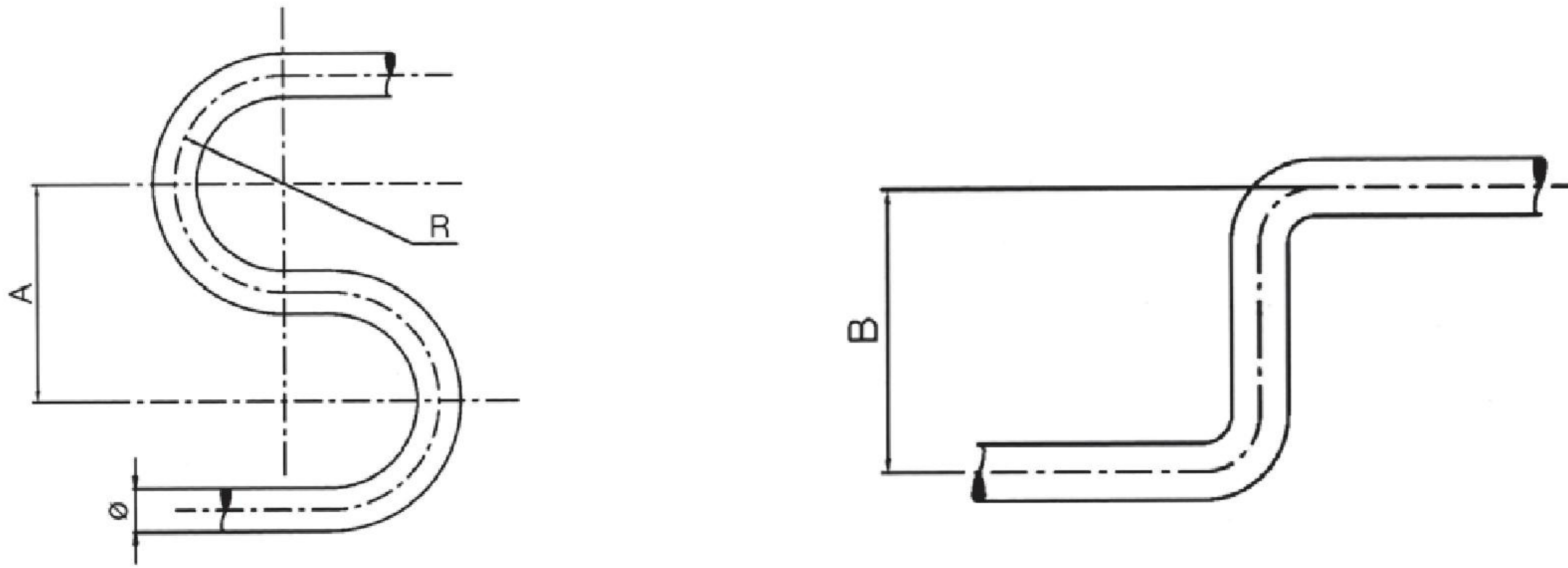
选配 OPTIONAL



夹具/顶具
CLAMP/DIE

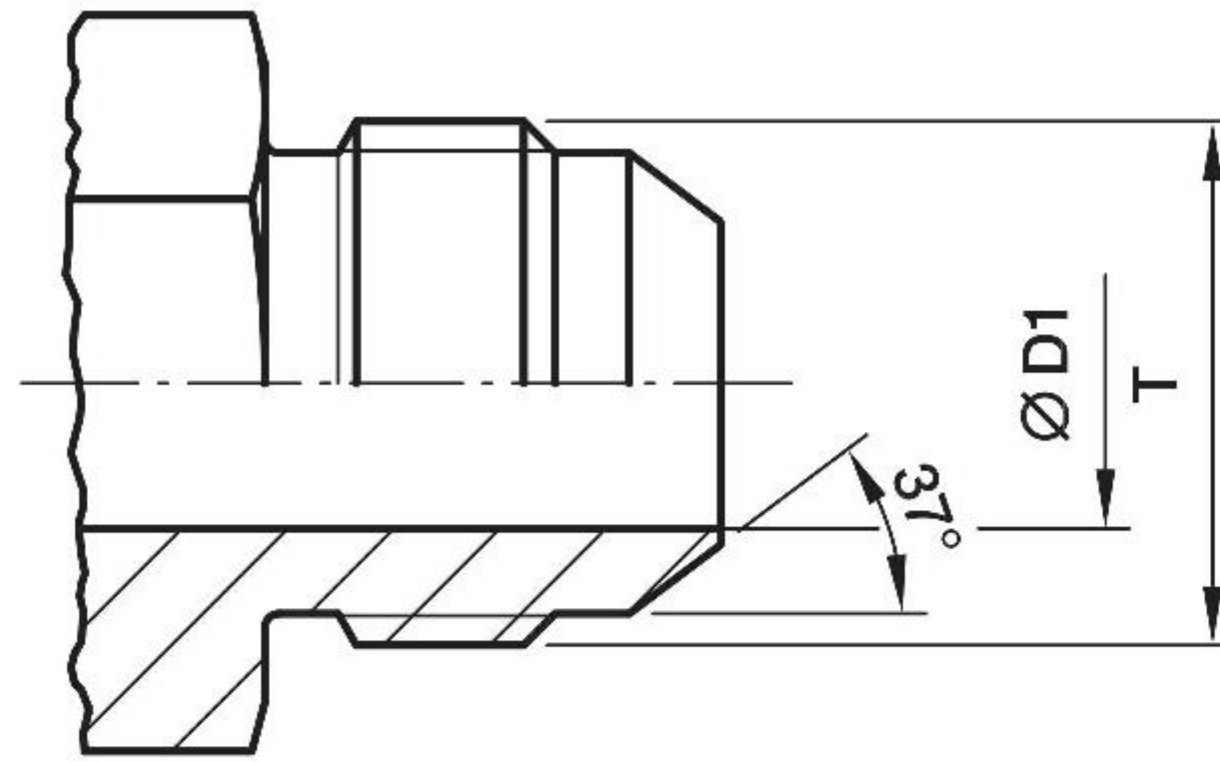
弯管半径参数表

BENDING RADIUS



Bending tool for tube ϕ	Bending radius (mm)	Max bending angle	A(mm)	B(mm)
6	15	170°	60	70
8	16.5	170°	60	70
10	27.5	170°	70	115
12	32.7	170°	80	120
14	46	170°	110	180
15	46	170°	110	180
16	48	170°	110	180
18	48	170°	110	190
20	66	160°	140	230
22	66	160°	140	240
25	81.5	160°	170	270
28	81	160°	180	300
30	98.5	150°	220	300
32	101	150°	220	300
35	125.5	120°	250	440
38	116	120°	250	440
42	126	120°	250	440
1/8"	27.5	170°	70	115

Triple-Lokend® (ISO 8434-2/SAE J514)/dimensions

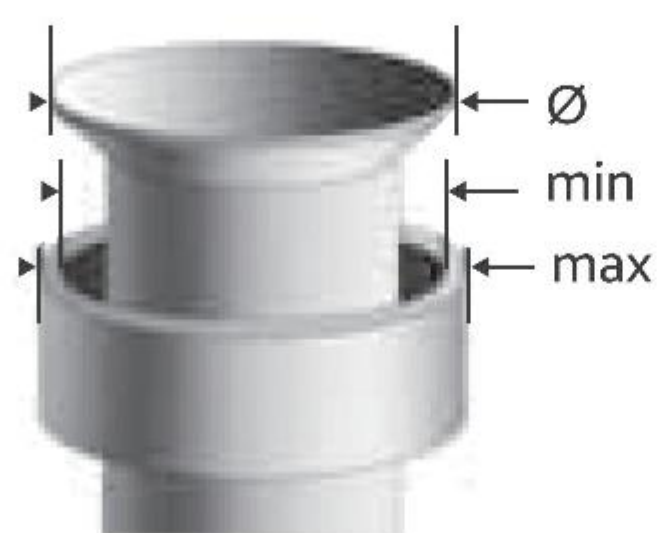


Size	Tube O.D.		T UN/UNF	T Major thread Ømm	ØD1 mm
	inch	mm			
4	1/4	6	7/16-20	11.0	4.5
5	5/16	8	1/2-20	12.5	6.0
6	3/8	10	9/16-18	14.0	7.5
8	1/2	12	3/4-16	19.0	10.0
10	5/8	14, 15, 16	7/8-14	22.0	12.5
12	3/4	18, 20	1 1/16-12	27.0	15.5
14	7/8	22	1 3/16-12	30.0	18.0
16	1	25	1 5/16-12	33.0	21.5
20	1 1/4	28, 30, 32	1 5/8-12	41.0	27.5
24	1 1/2	35, 38	1 7/8-12	47.5	33.0
28*	1 3/4	42	2 1/4-12	57.0	39.0
32	2	—	2 1/2-12	63.5	45.0

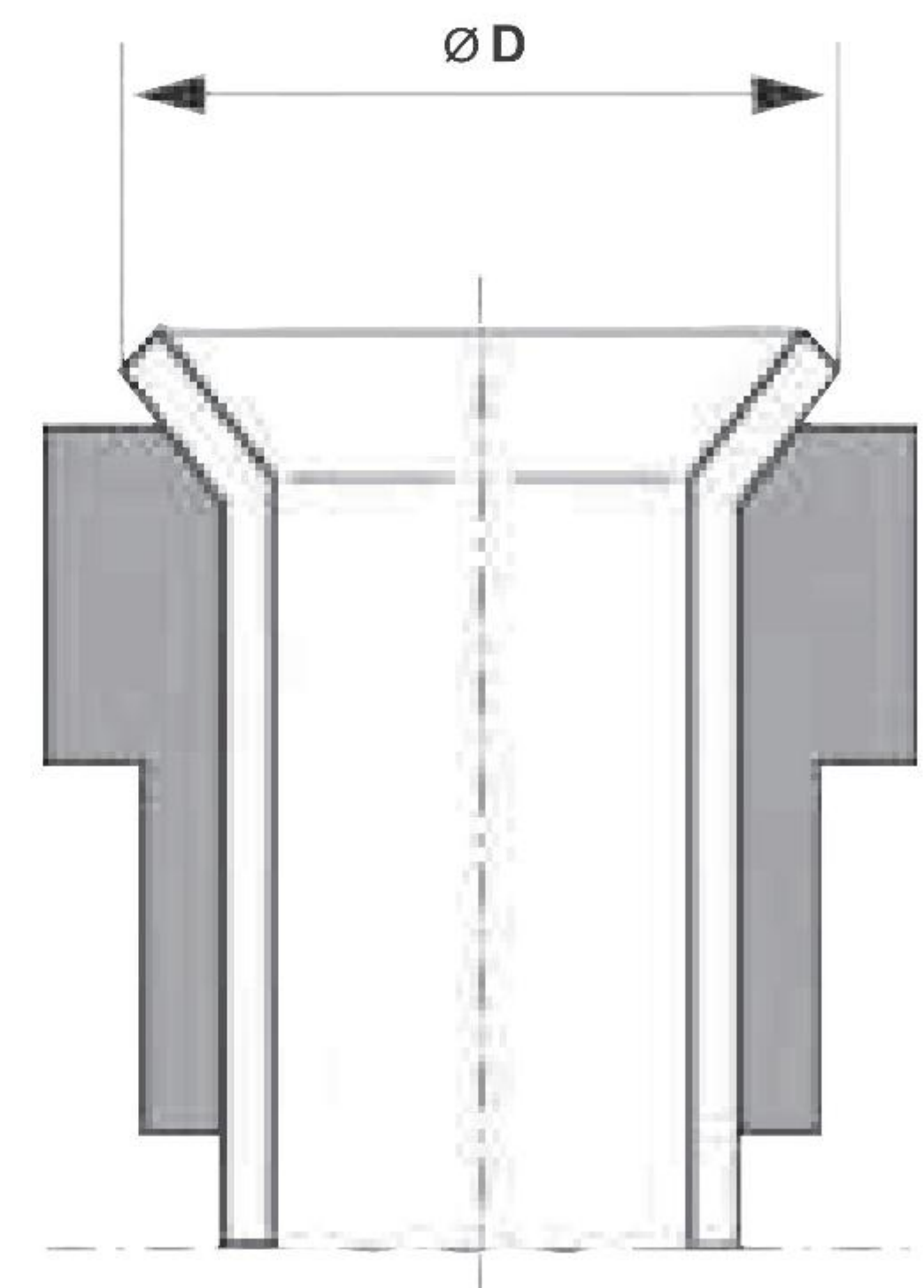
*Size 28 is not part of SAE J514 or ISO 8434-2.

All dimensions shown are nominal for identification only.
Small deviations may be found between SAE J514 or ISO 8484-2 on bore sizes.

Suitable Flare



Tube O.D.		D	
mm	inch	Min.	Max.
6	1/4"	8.6	9.7
8	5/16"	10.2	11.3
10	3/8"	11.7	12.7
12	1/2"	16.0	17.3
14		19.3	20.2
15		19.3	20.2
16	5/8"	19.3	20.2
18		23.4	24.7
20	3/4"	23.4	24.7
22	7/8"	26.5	27.8
25	1"	29.7	31.0
28		37.6	38.9
30		37.6	38.9
32	1.1/4"	37.6	38.9
35		43.2	45.3
38	1.1/2"	43.2	45.3
42		52.0	54.8
	2"	59.2	61.2




37°-Flare acc. ISO 8434-2 not compatible with Flare according DIN 3949.

注：依据派克Parker标准

F37 FLANGE ASSEMBLY INTRUCTIONS

Checking of flare



Tube O.D. [mm]	Ø D ± 1mm [mm]
16X2.0	20.0
18X2.0	22.5
20X2.0	24.5
20X2.5	24.5
25X2.5	29.0
25X3.0	29.0
30X3.0	36.5
30X4.0	36.5
32.9X3.5	40.0
33.4X4.6	38.0
38X2.5	44.0
38X3.0	44.0
38X4.0	44.0
38X5.0	44.0
42X3.0	48.0
42X4.0	48.0
48.3X3.7	56.0
50x3.0	58.0
50X5.0	58.0
50X6.0	58.0
60X3.0	68.0
60X5.0	68.0
60X6.0	68.0
60.3X3.9	68.5
65X8.0	76.0
73x7.0	82.8
75X3.0	82.8
75X5.0	82.8
88.9X3.05	100.3
90X3.5	100.3
90X5.0	100.3
90X9.0	100.3
100X4.0	on request
115X4.0	126.0
125X4.0	139.0
140X4.5	151.0
141.3X6.55	151.0
165X5	177.5

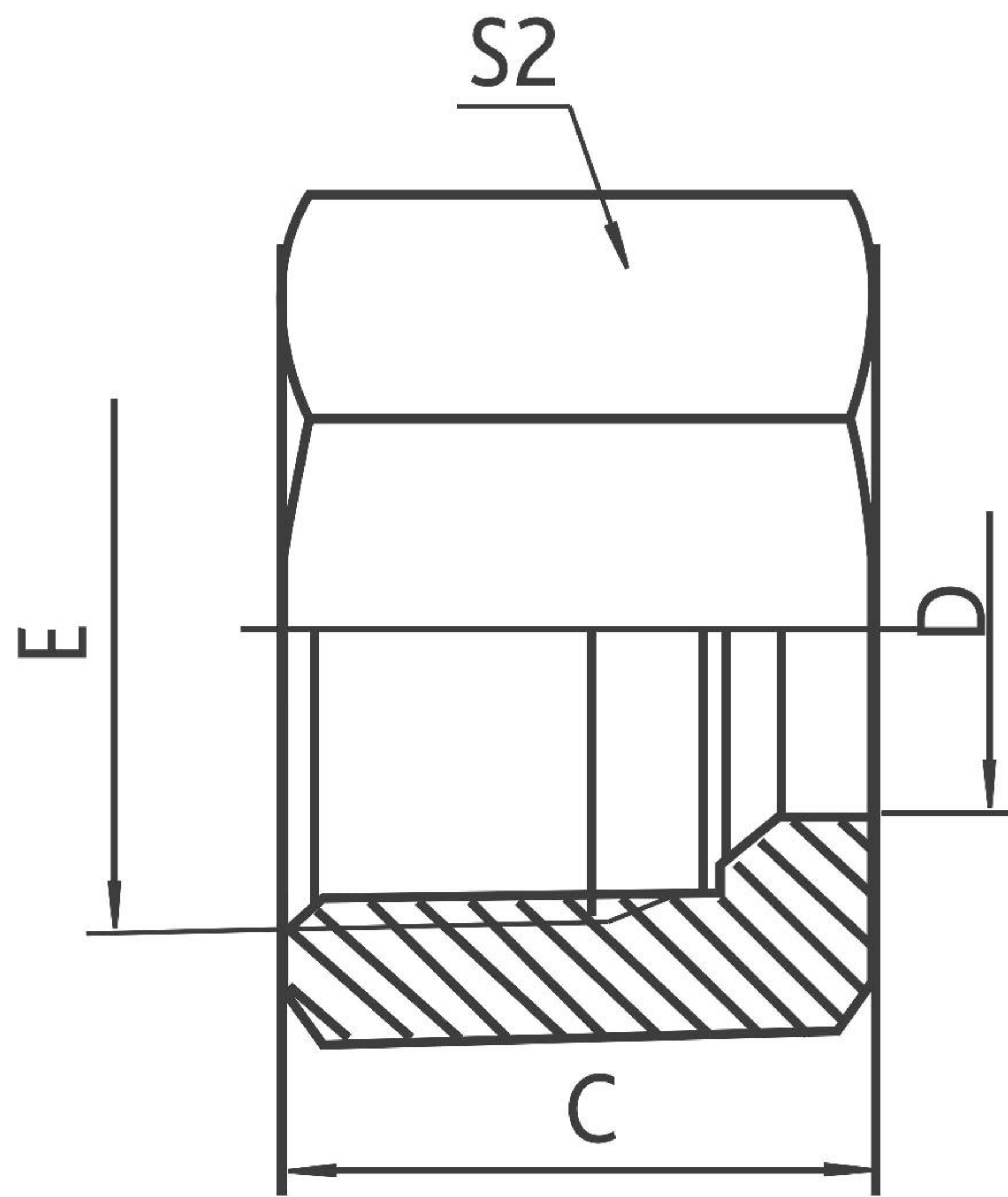
推荐的钢管

STEEL TUBE

表：额定压力PN/管尺寸RADxS

100bar	160bar	250bar	315bar	400bar	630bar
4x0.5					
6x1	6x1	6x1	6x1	6x1.5	6x2
8x1	8x1	8x1	8x1.5	8x2	8x2.5
10x1	10x1	10x1.5	10x2	10x2.5	10x3
12x1	12x1.5	12x2	12x2.5	12x3	12x4
14x1.5	14x1.5	14x2	14x2.5	14x3	14x5
15x1.5	15x1.5	15x2	15x3	15x3.5	
16x1.5	16x1.5	16x2	16x2.5	16x3	
18x1.5	18x1.5	18x2	18x2.5		
20x1.5	20x2.5	20x2.5	20x3	20x3.5	
22x1.5	22x2	22x2.5	22x3		
25x2	25x2	25x3	25x4	25x4.5	
28x2	28x2	28x3			
30x2	30x2.5	30x4	30x5	30x6	
35x2	35x3	35x4			
38x2.5	38x4	38x5	38x6	38x7	
42x3	42x4	42x5			
50x5	50x5	50x6	50x8	50x9(50x8) ¹⁾	
60x5	60x5	10x1.5	10x1.5	60x10 ¹⁾	
65x4	65x5	65x8	65x8		
75x12.5	75x12.5	75x12.5	75x12.5	75x12.5 ¹⁾	
80x8	80x8	80x8			
88x14	88x14	88x14	88x14	88x14 ¹⁾	
101.6x16 ¹⁾	101.6x16 ¹⁾	101.6x16 ¹⁾	101.6x16 ¹⁾	101.6x16 ¹⁾	
114.3x17.5 ¹⁾	114.3x17.5 ¹⁾	114.3x17.5 ¹⁾			
120x20	120x20	120x20			

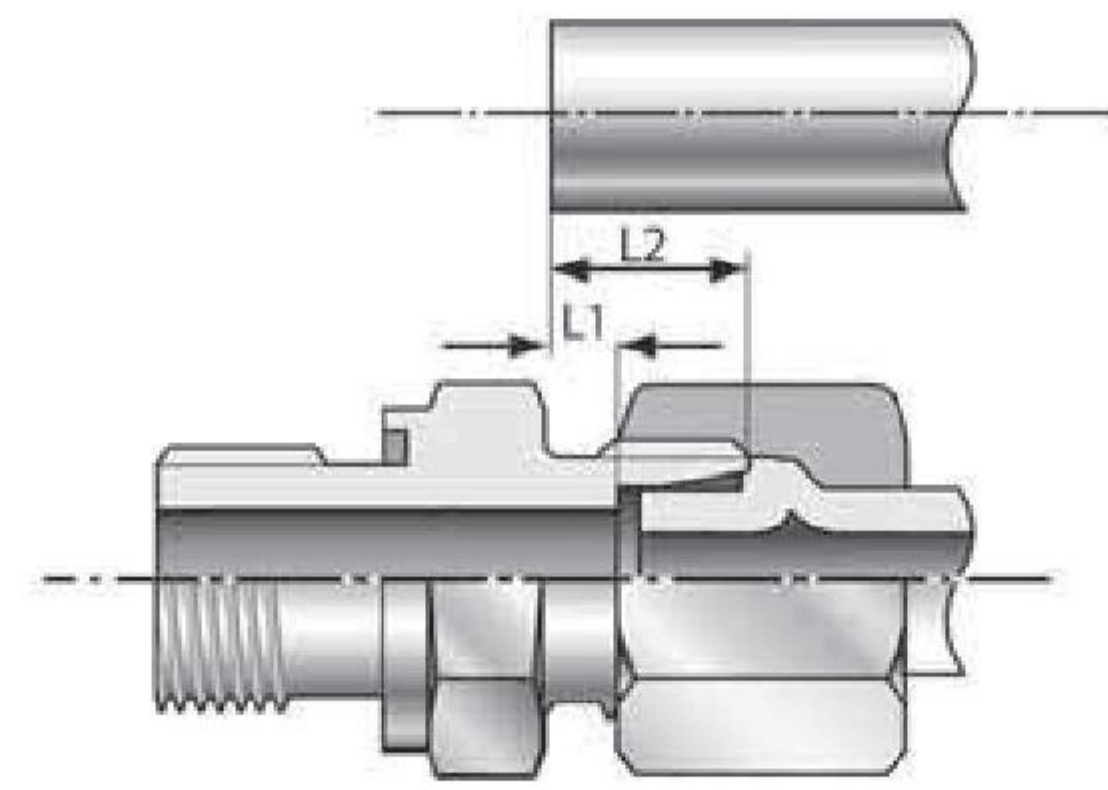
¹⁾材料1.0581+N制成的管材



NL、NS 卡套螺母 RETAINING NUTS

代号 PART NO.	螺纹 THREAD E	管子外径 D TUBE O.D.	尺寸DIMENSIONS			压力等级 Mpa
			C	D	S2	
NL-12	M12x1.5	6	14.5	6	14	轻系列 L
NL-14	M14x1.5	8	14.5	8	17	
NL-16	M16x1.5	10	15.5	10	19	
NL-18	M18x1.5	12	15.5	12	22	
NL-22	M22x1.5	15	17	15	27	
NL-26	M26x1.5	18	18	18	32	
NL-30	M30x2	22	20	22	36	
NL-36	M36x2	28	21	28	41	
NL-45	M45x2	35	24	35	50	
NL-52	M52x2	42	24	42	60	
NS-14	M14x1.5	6	16.5	6	17	
NS-16	M16x1.5	8	16.5	8	19	
NS-18	M18x1.5	10	17.5	10	22	
NS-20	M20x1.5	12	17.5	12	24	
NS-22	M22x1.5	14	20.5	14	27	
NS-24	M24x1.5	16	20.5	16	30	
NS-30	M30x2	20	24	20	36	
NS-36	M36x2	25	27	25	46	
NS-42	M42x2	30	29	30	50	
NS-52	M52x2	38	32.5	38	60	

Tube length determination (L1, L2)
确定管子长度 (L1, L2)



Note: A tolerance of ± 0.5 mm must be taken into consideration for dimensions L1 and L2 after reshaping!

注：再成形后，尺寸L1和L2必须计入 ± 0.5 mm的公差！



Steel
钢 St 37.4 / 52.4**

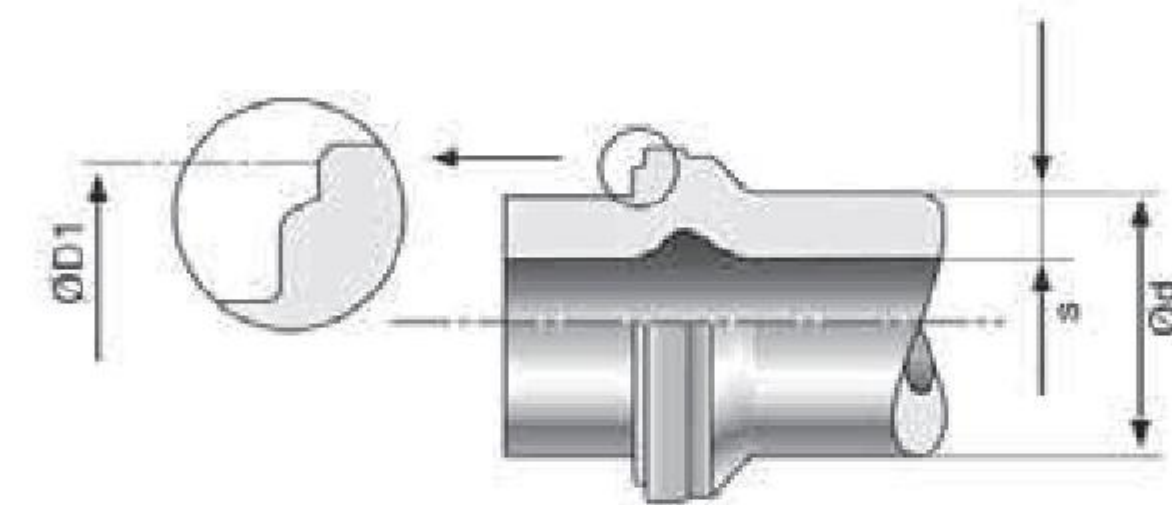
LAFORM								
d [mm]	s [mm]						L1 [mm]	L2 [mm]
	1,5	2	2,5	3	3,5	4	5	6
6 L/S	6,5 13,5							
8 L/S	7,0 14,0	6,5 13,5						
10 L	7,0 14,0	6,0 13,0	6,0 13,0	5,5 12,5				
10 S	6,5 14,0	5,5 13,0	5,5 13,0	5,0 12,5				
12 L	7,0 14,0	6,5 13,5	6,0 13,0	4,5 11,5				
12 S	6,5 14,0	6,0 13,5	5,5 13,0	4,0 11,5				
15 L	6,5 13,5	6,5 13,5	6,0 13,0					
16 S		7,0 15,5	6,5 15,0	7,0 15,5	5,5 14,0	5,0 13,5		
18 L		6,5 14,0	6,5 14,0	6,0 13,5				
20 S		8,5 19,0	8,0 18,5	7,5 18,0	7,5 18,0	7,5 18,0		
22 L		7,0 14,5	7,0 14,5	6,5 14,0				
25 S		9,0 21,0	8,0 20,0	8,0 20,0	8,5 20,5	8,0 20,0	7,5 19,5	
28 L		6,5 14,0	6,5 14,0	6,5 14,0	7,0 14,5			
30 S			8,5 22,0	9,0 22,5		9,0 22,5	9,0 22,5	8,5 22,0
35 L			8,0 18,5	8,0 18,5		8,5 19,0	8,0 18,5	
38 S				9,5 25,5		9,5 25,5	10,0 26,0	10,0 26,0
42 L				8,0 19,0	8,0 19,0	8,5 19,5		

d [mm]	A1* [mm]	A2* [mm]	B1 [mm]	B2 [mm]	ØD1min [mm]
6 L/S	69	56	90	64	9,2
8 L/S	66	52	88	60	11,3
10 L/S	62	48	84	57	13,6
12 L/S	62	48	85	57	15,8
15 L	69	56	90	64	18,6
16 S	73	58	99	68	19,8
18 L	79	65	102	74	21,6
20 S	85	66	115	77	24,5
22 L	87	72	112	83	25,6
25 S	114	93	148	106	29,6
28 L	103	87	129	98	31,6
30 S	121	98	157	112	34,7
35 L	112	93	144	106	39,2
38 S	127	102	169	116	42,8
42 L	114	94	146	107	46,2

* If installation problems require a shorter straight tube length than indicated in the table, bending must be carried out after reshaping (see Tube bending tools).

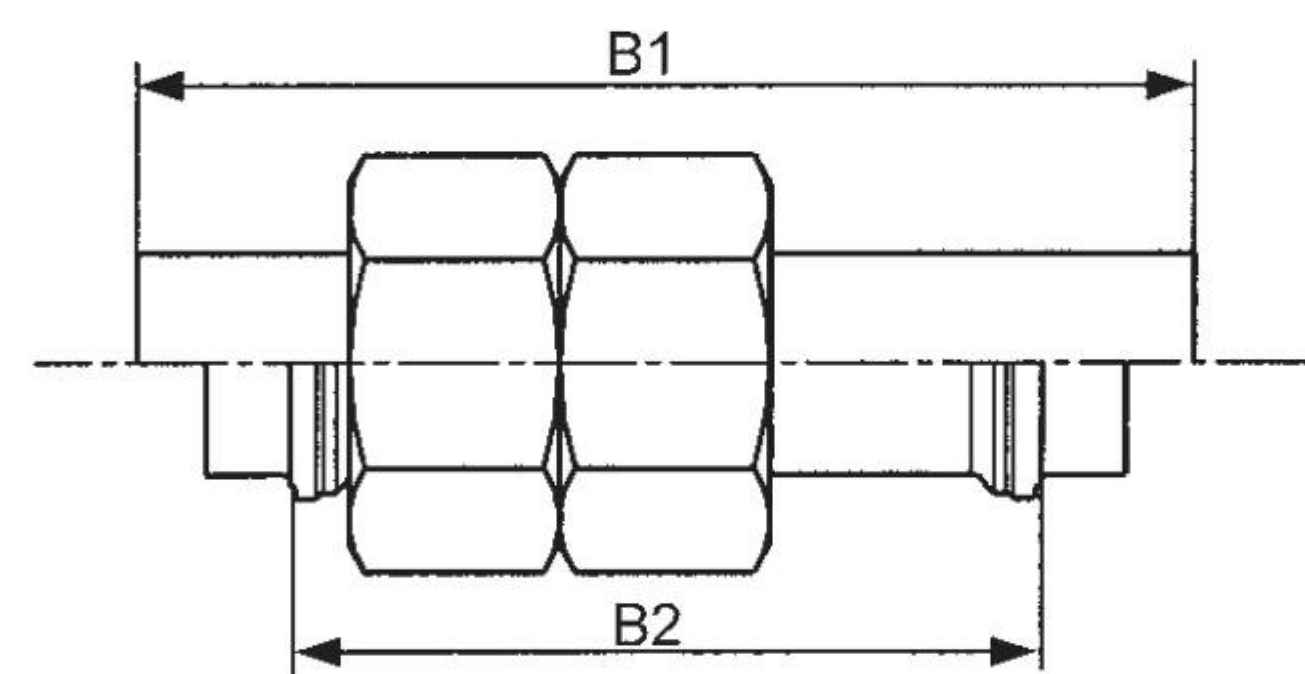
* 如果出现安装问题，需要直管长度小于表中规定的长度，必须在再成形后弯管（请参见弯管工具）。

Control diameter (D1min)
控制直径 (D1最小)

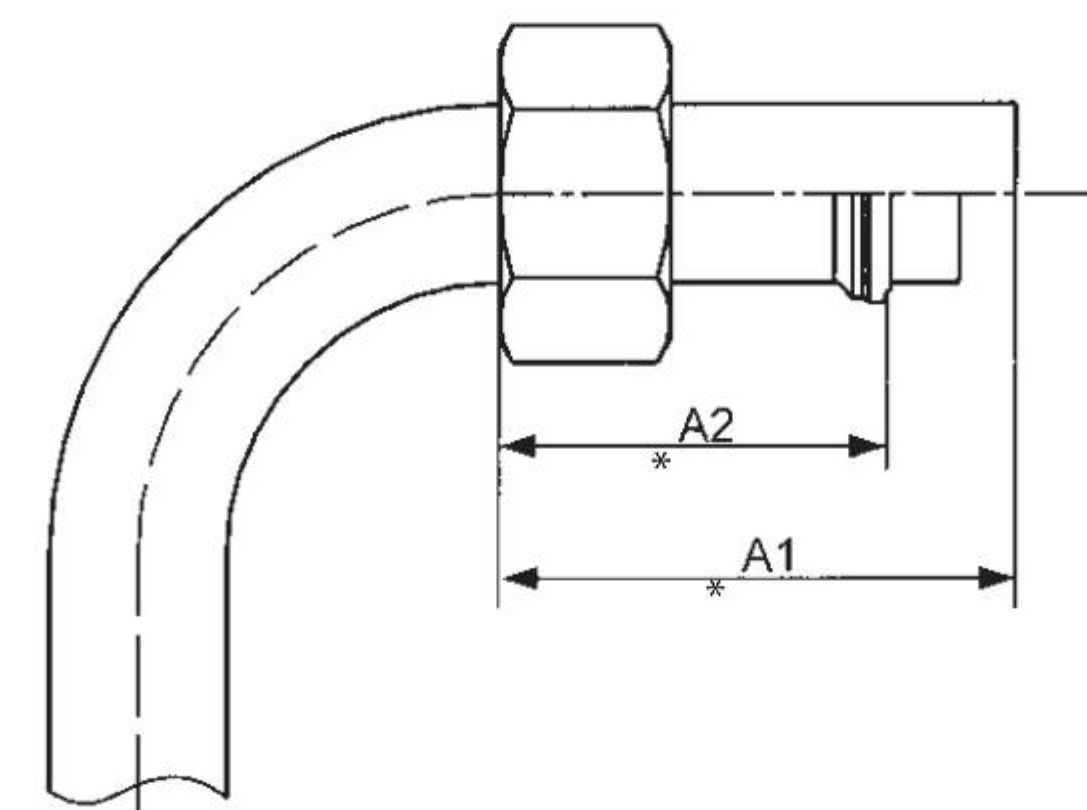


Minimum tube lengths for clamping for straight and bent tubes
直管和弯管的最小抱紧管子长度

直管和弯管的最小抱紧管子长度



Straight tube length (B)
直管长度 (B)



Minimum straight tube length (A)
最小直管长度 (A)

Clamping jaws for LAFORM plus steel St 37.4/52.4



Tube OD Rohr-AD Tube <input checked="" type="checkbox"/> ext. [mm]	Wall thickness [mm]								
	1	1,5	2	2,5	3	3,5	4	5	6
	Reference			Best.-Nr.			Réf.		
6	WAL610897	WAL615765							
8	WAL612561	WAL615766							
10	WAL612562	WAL615767							
12	WAL612563	WAL615768							
15		WAL615769							
16			WAL615770				WAL615770		
18			WAL615771						
20									
22			WAL615773						
25			WAL615774						
28			WAL615775						
30				WAL615776			WAL615776		
35				WAL615777			WAL615777		
38					WAL615778		WAL615778		
42					WAL615779				

Reshaper for LAFORM plus steel St 37.4/52.4



without internal support



with internal support

Tube OD Rohr-AD Tube <input checked="" type="checkbox"/> ext. [mm]	Wall thickness [mm]								
	1	1,5	2	2,5	3	3,5	4	5	6
	Reference			Best.-Nr.			Réf.		
6	WAL612284	WAL615820							
8	WAL612555	WAL615821	WAL615822						
10	WAL612557	WAL615823	WAL615824	WAL615825	WAL615826				
12	WAL612559	WAL615827	WAL615830	WAL615831	WAL615832				
15		WAL615833	WAL615836	WAL615839					
16			WAL615842	WAL615845	WAL615848		WAL615849		
18			WAL615850	WAL615853	WAL615856				
20			WAL615857	WAL615860			WAL615864		
22			WAL615865	WAL615995	WAL615868	WAL615869			
25			WAL615870	WAL615873	WAL615876	WAL615877	WAL615878	WAL615994	
28			WAL615879	WAL615882	WAL615885	WAL615888			
30				WAL615889	WAL615892		WAL615895		WAL615896
35				WAL624009	WAL615897		WAL615900	WAL615901	
38					WAL615902		WAL615905	WAL615906	WAL615907
42					WAL615908	WAL615911	WAL615914		

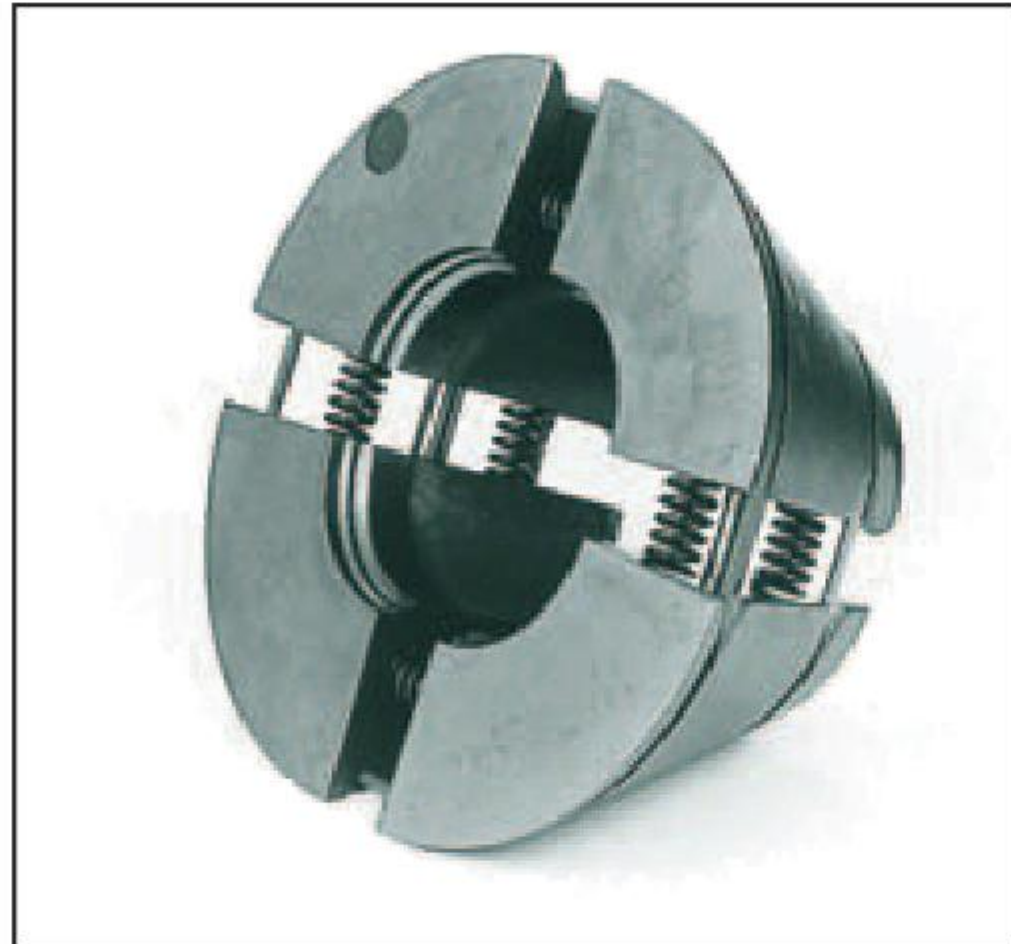
Reshaping without internal support

Reshaping with internal support

* Tube dimension 38 x 6 mm, reshaping of tube material steel St 37.4/52.4 is only possible with WF642D



Clamping jaws for LAFORM plus stainless steel 1.4571



Tube OD Rohr-AD Tube ext. [mm]	Wall thickness [mm]								
	1	1,5	2	2,5	3	3,5	4	5	6
	Reference			Best.-Nr.			Réf.		
6	WAL610897	WAL615765							
8	WAL612561	WAL615766							
10	WAL612562	WAL615767							
12	WAL612563	WAL615768							
15		WAL615769							
16			WAL615770						
18			WAL615771						
20			WAL615772						
22			WAL615773						
25			WAL615774			WAL615774			
28			WAL615775						
30			WAL615776				WAL615776		
35				WAL615777			WAL615777		
38				WAL615778			WAL615778		
42				WAL615779					

Reshaper for LAFORM plus stainless steel 1.4571



without internal support



with internal support

Tube OD Rohr-AD Tube ext. [mm]	Wall thickness [mm]								
	1	1,5	2	2,5	3	3,5	4	5	6
	Reference			Best.-Nr.			Réf.		
6	WAL612284	WAL615917							
8	WAL612903	WAL615918							
10	WAL612904	WAL615919	WAL625036						
12	WAL612560	WAL615920	WAL615921						
15		WAL615922	WAL615925						
16			WAL615928	WAL615931	WAL615934				
18			WAL615935	WAL615938	WAL615941				
20			WAL615942	WAL615945	WAL615948				
22			WAL615949	WAL615952	WAL615955				
25			WAL624816	WAL615956	WAL615959		WAL615960		
28			WAL615961	WAL615964	WAL615967				
30				WAL615970	WAL615973		WAL615976	WAL615977	
35					WAL615978		WAL615981	WAL615982	
38					WAL615983		WAL615986	WAL615989	
42					WAL615991				

Reshaping without internal support

Reshaping with internal support

* Tube dimension 38 x 6 mm, reshaping of tube material stainless steel 1.4571 is only possible with WF642D



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