

# T-DRILL

COLLARING UNIT S-54

State-of-the-art unit for high volume  
production of T-DRILL Collars.



IT'S THE TOOLS

THAT SAY HOW GOOD YOU ARE.

# S-54 COLLARING UNIT

## S-54 COLLARING UNIT

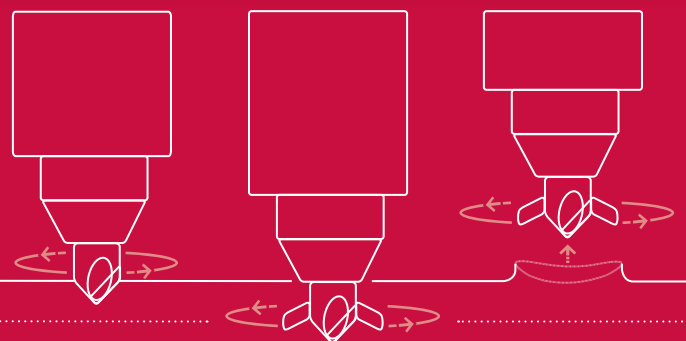
The industry standard machine for the manufacture of collars in tubes. This system is used by manufacturing in the automotive, air conditioning (HVAC), radiant heat, and solar industries as well as many others. It is capable of producing collars in tube from 8 - 108 mm ( $\frac{5}{16}$  to  $4 \frac{1}{8}$ ) in copper, aluminum, steel, stainless steel, brass and other malleable materials. Collar sizes from 6 - 54 mm ( $\frac{1}{4}$  to  $2 \frac{1}{8}$ ). Please find more from the technical data and capability charts.

T-Drill collars gives the most reliable tube joints being used with the most extreme applications. Use T-Drill - no leakages.



## T-DRILL PROCESS

T-DRILL Collaring is the Industry Standard tube branching method for automotive and air-conditioning (HVAC) industries worldwide.



## S-54 MANUAL FEED TABLE (MFT)

---

The S-54, when fitted with the Manual Feed Table, is used for low to mid volume production of manifolds. The table is manually moved by the operator after each collar is produced.



## S-54 AUTOMATIC FEED TABLE (AFT)

---

The S-54, when fitted with the Automatic Feed Table, provides the collaring solution for making manifolds automatically. This is a cost effective alternative to the state of the art Tube Collaring System.



## S-54 TUBE COLLARING SYSTEM (TCS)

---

The S-54 TCS is state of the art automatic collaring system. It is used for the automatic production of manifolds providing the best use of floor space.

This system with PC-controls is fully programmable with 2 axis motion controls. Optional bar code reader can be attached to control to read in the production data and select the right program.



## S-54 FLEXIBLE MANUFACTURING SYSTEM (FMS)

---

S-54 collaring unit is modular and it can be easily placed to manual- or fully automatic robot based flexible manufacturing cells or systems.



# OTHER T-DRILL MACHINERY

## TCC SERIES

High volume Chipless tube cut-off systems

## SP-55 & SP-110

T-Drill Tube End Spinners for closing, reducing and expanding copper tubes

# DO IT WITH T-DRILL

CUT COSTS – IMPROVE QUALITY – INCREASE PROFIT.

- No T-fittings
- No costly inventories
- No tube cutting
- Only one brazed joint

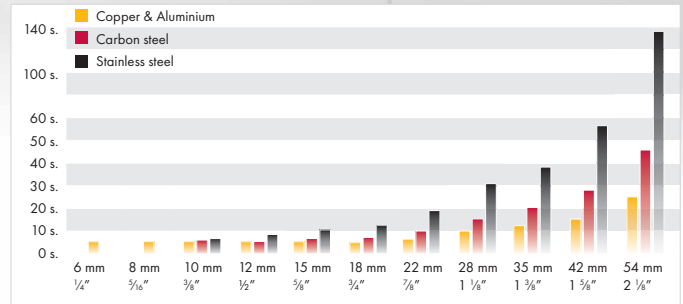
- Minimized inspection cost
- Less chance for leakage or call-backs
- Improved flow characteristics

## Technical data

	COPPER ALUMINIUM	STEELS
Collaring range	6-54 mm / ¼" - 2 ½"	10-54 mm / ¾" - 2 ½"
Run tube range	8-108 mm / ⅜" - 4 ¼"	10-108 mm / ¾" - 4 ¼"
Rated power	3 kW	3 kW
Air supply	6 bar/90 psi	6 bar/90 psi
Air consumption	50 l/min / 1.765 ft³/min	50 l/min / 1.765 ft³/min
Weight (basic unit)	200 kg/450 lbs	200 kg/450 lbs
Noise level	<70dB(A)	<70dB(A)

The information included in this brochure is subject to revision without notice.

## Collaring times



## Max. wall thickness for copper

RUN TUBE OUTSIDE DIAMETER	BRANCH TUBE OUTSIDE DIAMETER									
	6 mm ¼"	8 mm ⅜"	10 mm ⅝"	12 mm ½"	15 mm ⅝"	18 mm ¾"	22 mm ⅞"	28 mm 1 ¼"	35 mm 1 ⅜"	54 mm 2 ½"
8 mm ⅜"	0.5 .020	0.5 .020								
10 mm ⅝"	0.8 .030	0.8 .030	1.0 .040							
12 mm ½"	0.8 .030	1.0 .040	1.0 .040	1.0 .040						
15 mm ⅝"	0.8 .030	1.0 .040	1.0 .040	1.0 .040	1.2 .045					
18 mm ¾"	0.8 .030	1.0 .040	1.0 .040	1.0 .040	1.2 .045	1.2 .045				
22 mm ⅞"	0.8 .030	1.0 .040	1.2 .045	1.2 .045	1.5 .060	1.5 .060	1.5 .060			
28 mm 1 ¼"	0.8 .030	1.0 .040	1.2 .045	1.2 .045	1.5 .060	1.5 .060	2.0 .080	1.5 .060		
35 mm 1 ⅜"	0.8 .030	1.0 .040	1.2 .045	1.2 .045	1.5 .060	1.5 .060	2.0 .080	2.0 .080	1.5 .060	
54 mm 2 ½"	0.8 .030	1.0 .040	1.2 .045	1.2 .045	1.5 .060	1.5 .060	2.0 .080	2.0 .080	2.0 .080	2.0 .080
79 mm 3 ⅜"	0.8 .030	1.0 .040	1.2 .045	1.2 .045	1.5 .060	1.5 .060	2.0 .080	2.0 .080	2.5 .100	2.0 .080
104 mm 4 ⅜"	0.8 .030	1.0 .040	1.2 .045	1.2 .045	1.5 .060	1.5 .060	2.0 .080	2.0 .080	2.5 .100	2.0 .080

## Max. wall thickness for steels

RUN TUBE OUTSIDE DIAMETER	BRANCH TUBE OUTSIDE DIAMETER								
	10 mm ¾"	12 mm ½"	15 mm ⅝"	18 mm ¾"	22 mm ⅞"	28 mm 1 ¼"	35 mm 1 ⅜"	54 mm 2 ½"	
10 mm ¾"	0.8 .030								
12 mm ½"	0.8 .030	0.8 .030							
15 mm ⅝"	1.0 .040	1.0 .040	1.0 .040						
18 mm ¾"	1.0 .040	1.0 .040	1.2 .045	1.0 .040					
22 mm ⅞"	1.0 .040	1.0 .040	1.2 .045	1.2 .045	1.2 .045				
28 mm 1 ¼"	1.0 .040	1.0 .040	1.2 .045	1.2 .045	1.2 .045	1.2 .045			
35 mm 1 ⅜"	1.0 .040	1.0 .040	1.2 .045	1.2 .045	1.4 .055	1.2 .045	1.2 .045		
42 mm 1 ⅝"	1.0 .040	1.0 .040	1.2 .045	1.2 .045	1.4 .055	1.4 .055	1.4 .055		
54 mm 2 ½"	1.0 .040	1.0 .040	1.2 .045	1.4 .055	1.4 .055	1.4 .055	1.4 .055	1.2 .045	
79 mm 3 ⅜"	1.0 .040	1.0 .040	1.2 .045	1.4 .055	1.6 .063	1.6 .063	1.6 .063	1.6 .063	1.6 .063
104 mm 4 ⅜"	1.0 .040	1.0 .040	1.2 .045	1.4 .055	1.6 .063	1.6 .063	1.6 .063	1.6 .063	1.6 .063

The charts above are for guidance only. Depending on material specification, increased values may apply.

MANUFACTURER:

REPRESENTED BY:

# T-DRILL

P.O.Box 20, FIN-66401 LAIHIA, Finland  
 Tel. +358 6 475 3333  
 Telefax +358 6 475 3300  
 e-mail: sales@t-drill.fi  
 www.t-drill.fi