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## New E02-FORM tools for stainless steel tubes (16-42 mm): Clamping dies and Forming Pins



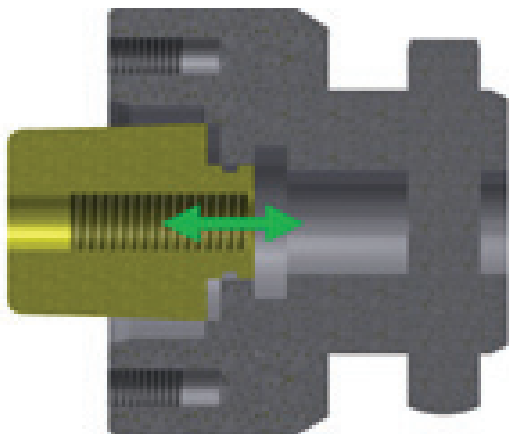
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# New E02-FORM tools: Clamping Dies and Forming Pins

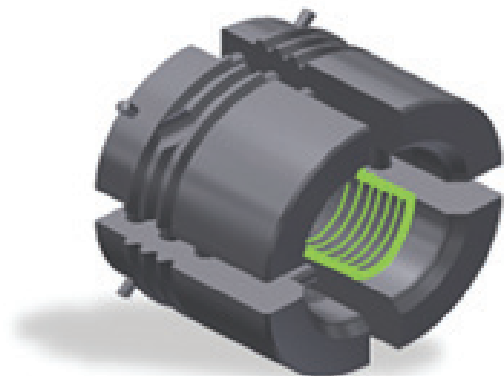
## What is new?

New tools for **stainless steel tubes** with outside diameter from 16 mm to 42 mm.

**Forming Pins**



**Clamping Dies**



- Axial moveable inner pin
- Splitting of the occurring forces for pulling-out of the forming pin
- Cone shaped inner pin
- Cone shaped tube-seat

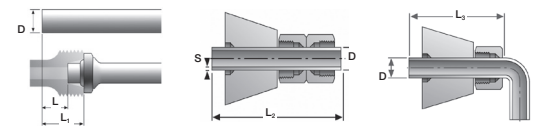
- Number of clamping groves increased by 20 %
- Material with increased hardness
- Increase of tool lifetime
- New order codes

Tube-outside diameter in mm	Forming pins		Clamping dies	
	Steel	Stainless Steel	Steel	Stainless Steel
6 - 42	6 - 42	6 - 15	6 - 42	6 - 15
		16 - 42 <b>NEW</b>		16 - 42 <b>NEW</b>

# Instructions:

- Using the new Forming Pin (Stainless Steel 16 - 42) in combination with the old clamping die could cause forming results beyond the tolerance range.
- The new Clamping Die can not be used with EO-3® forming or tools for hose connections DIN 7155.
- The new tools do not make lubrication of the tube-end with EO-NIROMONT APPLICATOR obsolete!
- Updates of the length surcharges are listed in the following short instruction:

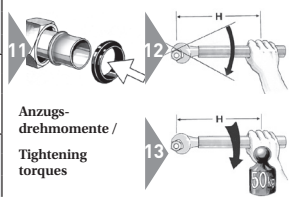
## WorkCenter F3 Kurzanleitung Bitte beachten Sie die ausführliche Bedienungsanleitung / Short instruction Please refer to machine manual Stand 08/2015



D	S	L Stahl Steel	L Edel- stahl Stainless Steel	L <sub>1</sub> Stahl Steel	L <sub>1</sub> Edel- stahl Stainless Steel	L <sub>2</sub>	L <sub>3</sub>
6L	1,0	6,0	6,0	13,0	13,0	90	63
	1,5	6,0	6,0	13,0	13,0		
8L	1,0	5,5	5,5	12,5	12,5	92	65
	1,5	5,5	5,5	12,5	12,5		
	2,0	5,0	-	12,0	-		
10L	1,0	5,5	5,5	12,5	12,5	95	68
	1,5	5,0	6,0	12,0	13,0		
	2,0	5,0	6,0	12,0	13,0		
12L	1,5	5,0	5,5	12,0	12,5	95	70
	2,0	5,0	5,5	12,0	12,5		
	2,5	5,0	6,5	12,0	13,5		
15L	1,0	5,0	6,5	12,0	13,5	102	75
	1,5	5,0	6,0	12,0	13,0		
	2,0	5,0	6,0	12,0	13,0		
18L	1,5	5,5	6,0	13,0	13,5	110	80
	2,0	5,5	6,5	13,0	14,0		
	2,5	6,0	6,0	13,5	13,5		
22L	2,0	6,5	7,0	14,0	14,5	120	90
	2,5	7,0	7,0	14,5	14,5		
	2,5	7,0	7,0	14,5	14,5		
28L	2,0	5,5	7,0	13,0	14,5	140	98
	2,5	7,0	7,5	14,5	15,0		
35L	2,0	7,0	8,5	17,5	19,0	170	115
	3,0	8,5	10,5	19,0	21,0		
	2,0	7,5	7,5	18,5	18,5		
42L	3,0	9,0	10,5	20,0	21,5	190	125
	4,0	9,0	-	20,0	-		

D	S	L Stahl Steel	L Edel- stahl Stainless Steel	L <sub>1</sub> Stahl Steel	L <sub>1</sub> Edel- stahl Stainless Steel	L <sub>2</sub>	L <sub>3</sub>
6S	1,0	6,0	6,0	13,0	13,0	92	65
	1,5	6,0	6,0	13,0	13,0		
	2,0	5,5	-	12,5	-		
8S	1,0	5,5	5,5	12,5	12,5	92	68
	1,5	5,5	5,5	12,5	12,5		
	2,0	5,0	-	12,0	-		
10S	1,5	5,0	6,0	12,0	13,5	100	70
	2,0	5,0	6,0	12,0	13,5		
	2,5	5,0	6,0	12,5	13,5		
12S	1,5	5,0	6,5	12,5	14,0	100	72
	2,0	5,0	6,0	12,5	13,5		
	2,5	5,0	6,0	12,5	13,5		
16S	2,0	5,5	6,5	13,5	15,0	135	98
	2,5	5,5	6,5	13,5	15,0		
	3,0	5,0	6,5	13,0	15,0		
20S	2,0	7,0	7,0	17,5	18,5	155	112
	2,5	7,0	8,0	17,5	18,5		
	3,0	7,0	8,0	17,5	18,5		
	3,5	7,0	-	17,5	-		
25S	2,0	8,5	8,5	20,5	20,5	140	98
	2,5	8,5	9,0	20,5	21,0		
	3,0	8,0	9,5	20,0	21,5		
	4,0	8,5	9,5	20,5	21,5		
30S	3,0	8,5	9,5	22,0	23,0	165	122
	4,0	9,5	10,0	23,0	23,5		
	5,0	8,5	9,0	22,0	22,5		
38S	3,0	10,0	9,5	26,0	25,5	190	135
	4,0	10,0	11,0	26,0	27,0		
	5,0	11,0	12,5	27,0	28,5		
	6/7	11,5	12,5	27,5	28,5		

Prüfmaße / Measuring		
Abmessung Size	min Ø [mm]	max Ø [mm]
6-L/S	8,3	10,3
8-L/S	10,3	12,3
10-L	12,5	14,3
12-L	14,5	16,3
15-L	18,0	20,3
18-L	21,0	24,0
22-L	25,5	27,8
28-L	31,5	33,8
35-L	39,0	42,5
42-L	46,0	49,5
10-S	13,0	15,5
12-S	15,0	17,5
14-S	17,5	19,5
16-S	19,5	21,5
20-S	24,0	27,5
25-S	29,5	34,0
30-S	34,5	39,0
38-S	42,5*	47,0






Anzugs-  
drehmomente /  
Tightening  
torques

Abmessung Size	H [mm]
22-L	400
28-L	500
35-L	800
42-L	1000
38-S	1200

\*Ø 42,0 mm freigeprüft mit Edelstahlrohr  
\*Ø 42,0 mm successfully tested with SS tubes



# Tools for WorkCenter F3 and WorkCenter PRO22

						
Tube OD Ø	Clamping Dies for Steel tubes Order code	Clamping Dies for Stainless Steel tubes Order code	Ø × s	Forming Pin for Steel tubes Order code	Forming pin for Stainless Steel tubes Order code	EO-3® Forming Pin Order code
06-L/S	<b>MF3EO2P306</b>	MF3EO2P306	06 × 1.0 06 × 1.5 06 × 2.0	BF3EO206X1S BF3EO206X1.5S BF3EO206X2S	BF3EO206X1SS BF3EO206X1.5SS	BF3P306X1 BF3P306X1.5
08-L/S	<b>MF3EO2P308</b>	MF3EO2P308	08 × 1.0 08 × 1.5 08 × 2.0 <b>08 × 2.5</b> <b>BF3EO208X2.5S</b>	BF3EO208X1S BF3EO208X1.5S BF3EO208X2S	BF3EO208X1SS BF3EO208X1.5SS	BF3P308X1 BF3P308X1.5
10-L	<b>MF3EO2P310</b>	MF3EO2P310	10 × 1.0 10 × 1.5 10 × 2.0	BF3EO210LX1S BF3EO210LX1.5S BF3EO210LX2S	BF3EO210LX1SS BF3EO210LX1.5SS BF3EO210LX2SS	BF3P310X1.5
10-S	<b>MF3EO2P310</b>	MF3EO2P310	10 × 1.5 10 × 2.0 <b>10 × 3.0</b> <b>BF3EO210SX3S</b>	BF3EO210SX1.5S BF3EO210SX2S	BF3EO210SX1.5SS BF3EO210SX2SS	BF3P310X1.5
12-L	<b>MF3EO2P312</b>	MF3EO2P312	12 × 1.5 12 × 2.0	BF3EO212LX1.5S BF3EO212LX2S	BF3EO212LX1.5SS BF3EO212LX2SS	BF3P312X1.5 BF3P312X2
12-S	<b>MF3EO2P312</b>	MF3EO2P312	12 × 1.5 12 × 2.0 <b>12 × 3.0</b> <b>BF3EO212SX3S</b>	BF3EO212SX1.5S BF3EO212SX2S	BF3EO212SX1.5SS BF3EO212SX2SS	
15-L	<b>MF3EO2P315</b>	MF3EO2P315	15 × 1.0 15 × 1.5 15 × 2.0	BF3EO215X1S BF3EO215X1.5S BF3EO215X2S	BF3EO215X1.5SS BF3EO215X2SS	BF3P315X1.5 BF3P315X2
16-S	<b>MF3EO2P316</b>	MF3EO2P316SS	16 × 2.0 <b>16 × 2.5</b> <b>16 × 3.0</b> <b>BF3EO216X3S</b>	BF3EO216X2S	BF3EO216X2SS <b>BF3EO216X2.5SS</b> <b>BF3EO216X3SS</b>	BF3P316X2
18-L	<b>MF3EO2P318</b>	MF3EO2P318SS	18 × 1.5 18 × 2.0	BF3EO218X1.5S BF3EO218X2S	BF3EO218X1.5SS BF3EO218X2SS	BF3P318X1.5 BF3P318X2
20-S	<b>MF3EO2P320</b>	MF3EO2P320SS	20 × 2.0 <b>20 × 2.5</b> <b>20 × 3.0</b> <b>20 × 3.5</b> <b>BF3EO220X3.5S</b>	BF3EO220X2S	BF3EO220X2SS <b>BF3EO220X2.5SS</b> <b>BF3EO220X3SS</b>	BF3P320X2 <b>BF3P320X2.5</b>
22-L	<b>MF3EO2P322</b>	MF3EO2P322SS	22 × 1.5 22 × 2.0	BF3EO222X1.5S BF3EO222X2S	BF3EO222X1.5SS BF3EO222X2SS	BF3P322X2
25-S	<b>MF3EO2P325</b>	MF3EO2P325SS	25 × 2.0 25 × 2.5 25 × 3.0 25 × 4.0	BF3EO225X2S BF3EO225X2.5S BF3EO225X3S BF3EO225X4S	BF3EO225X2SS BF3EO225X2.5SS BF3EO225X3SS	BF3P325X2.5 BF3P325X3
28-L	<b>MF3EO2P328</b>	MF3EO2P328SS	28 × 2.0 28 × 2.5 28 × 3.0	BF3EO228X2S BF3EO228X2.5S BF3EO228X3S	BF3EO228X2SS BF3EO228X2.5SS	BF3P328X2
30-S	<b>MF3EO2P330</b>	MF3EO2P330SS	30 × 2.5 30 × 3.0 30 × 4.0 30 × 5.0	BF3EO230X3S BF3EO230X4S BF3EO230X5S	BF3EO230X3SS BF3EO230X4SS	BF3P330X2.5 BF3P330X3 BF3P330X4
35-L	<b>MF3EO2P335</b>	MF3EO2P335SS	35 × 2.0 35 × 2.5 35 × 3.0	BF3EO235X2S BF3EO235X3S	BF3EO235X2SS BF3P335X2.5SS BF3EO235X3SS	BF3P335X2.5 BF3P335X3
38-S	<b>MF3EO2P338</b>	MF3EO2P338SS	38 × 3.0 38 × 4.0 38 × 5.0 38 × 6/7	BF3EO238X3S BF3EO238X4S BF3EO238X5S BF3EO238X6+7S	BF3EO238X3SS BF3EO238X4SS BF3EO238X5SS	BF3P338X3 BF3P338X4 BF3P338X5
42-L	<b>MF3EO2P342</b>	MF3EO2P342SS	42 × 2.0 42 × 3.0	BF3EO242X2S BF3EO242X3S	BF3EO242X2SS BF3EO242X3SS	BF3P342X3



### Compatibility of the tools:

Orange = Tools for WorkCenter F3

Black = Tools for WorkCenter F3 and PRO22

New Order codes

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Application photo (Title top left):  
Tunnel boring machine S-300  
By courtesy of Herrenknecht AG.



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