

RAM FORMING SCHEDULE 80 PIPE



Proto-1 Manufacturing recently modified one of its RAM-70 forming presses to accomplish a 9-inch-deep cold expansion on 3.5-inch schedule 80 pipe. Intended for use in fluid and gas transmission applications or other pipe-over-pipe connections, the machine makes the expansion in less than 5 seconds.

The machine uses a 70 ton hydraulic ram forming cylinder in place of the usual 40 ton cylinder. It also has a standard 70-ton clamp cylinder, laser optic safety sweep, and an optional jib crane for die changeover. Because of the extreme tool pressure involved, the usual six-hit progressive shuttle toolholder was dropped and a simpler single-hit setup was used in its place.

The custom machine was delivered with tooling to perform both 3.5-inch schedule 80 and 2.5-inch schedule 40 expansions.