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Computerized Extrusion Die Stretcher

Model CEDS-3x8

- Touch screen programming with tilt adjustment
- Ball screw with step motor drive
- Stores up to ten stretch sequences
- Password protection
- Quick release mechanism for fast replacement of the extrusion dies
- Air clamps with polyurethane soft jaws or stainless steel hard jaws
- Optional attachment for tubing feed & withdrawal



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GENERAL INFORMATION

Interface Associates' Extrusion Die Stretching Machine (figure 1), is a compact, computer controlled, bench-top system designed to draw down a variety of tubing sizes and materials, such as PE, PA, PTFE, and PEEK. The process enhances material strength and improves O.D./I.D. tolerances. The machine can be used for tubing neck down, heat-shrink tubing sizing, producing protective welding sleeves, jacketing short shafts, sizing balloon sheaths, and heat setting folded balloons. The maximum draw distance is 8.0 inches. For longer stretch lengths inquire about our Model Number EDS-3x26 (up to 26") or Model EDS-3X68 (up to 68").

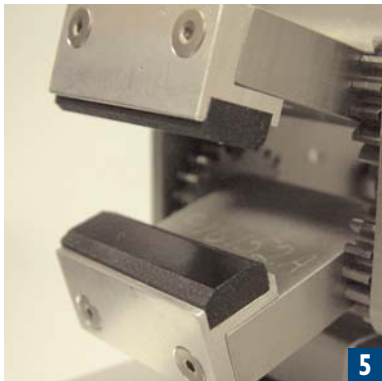
The machine allows for precise selection of tubing stretching parameters, and automatic control of the sequence and timing of individual steps of the tubing forming cycle. A precision stepper-motor driven ball screw assembly controls the tubing stretch. All parameters, such as temperature, draw speed, and draw distance, can be quickly changed by the operator using the front panel controls and icons on the touch screen. Up to ten stretch sequence programs can be stored in memory and easily recalled when the need arises. Password protection is also provided to ensure against unauthorized changes to a validated process.

OPERATION

During operation, thinned down tubing ends are inserted through any or all of three precision extrusion dies and gripped by an air-actuated clamp. The clamp then pulls the tubing through the die (figure 2), which is heated to the user-defined temperature. The machine can perform one step or two step pulls. During the two step pull, the tubing tail is drawn through the die a short distance of 0.5 or 1.0 inches and then the jaws release, move back close to the die, grip the tube again by its stronger section and perform the final pull. Tubing neckdown can be performed with or without a mandrel inside the tube.



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OPTIONS

Optional **Tubing Feed and Withdrawal Mechanism** for straight withdrawal. 502219

Narrow heater block option, to move in closer to the extrusion dies.

Extrusion Dies are sold separately. They are fabricated from 440C stainless steel, heat treated to RC 62 and diamond polished to a mirror finish. The dies are available in sizes 0.014 to 0.126 in 0.001 inch increments.

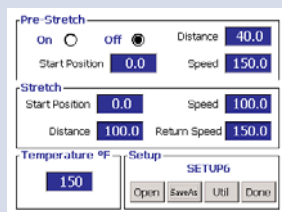
SUMMARY OF FEATURED PHOTOS

Figure 3 - Detail of the heater block with heat shield and dies installed. By removing two retaining screws, dies can be quickly removed and changed to a different size.

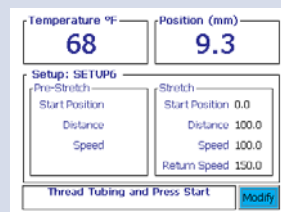
Figure 4 and 5 - Scissor action air clamp shown with serrated stainless steel hard jaws. An extra set of soft jaws equipped with urethane pads are also supplied with the machine.

SPECIFICATIONS

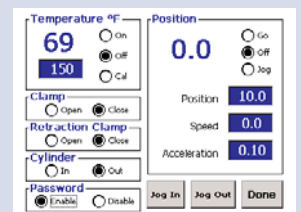
Power Requirements:	110VAC, 60Hz, 520 Watts (220VAC, 50Hz available)
Size:	15.25"W x 21.0"D x 12.0"H
Weight:	48 lbs
Capacity:	3 tubes side by side, 0.020 to 0.125 (0.5mm to Ø 3.1mm)
Maximum Stretch Distance:	195mm
Minimum Stretch Speed:	0.5mm/sec
Maximum Stretch Speed:	150mm/sec
Temperature Range:	Ambient to 450 °F (260 °C)
Maximum Pull Force:	66Lb (30Kg)



Set-up and store parameters



Run machine in automatic mode



Run Machine in manual mode

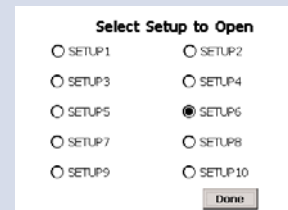


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Enter or change password



Recall stored programs