

Spiral Helix Model 3600 Tubeformer

Pre-Installation Checklist



We are very pleased about your decision to buy Spiro® machines, which grants high quality and reliability. We learned from our long experience that a well executed installation and a profound training of your staff is the basis for a well working end product. To give you the best chances having this, we need your help. Please read the form and make sure the required preparations are made. Then fill in the boxes below and send a copy of page 1 back to Spiro®.

As soon you have made the preparations and we have received this form, we shall organise a visit from one of our field engineers to install your machine.

Please note that extra costs may occur if your preparation procedures have not been completed prior to the installation.

Thank you in advance for your cooperation

1. The Tubeformer is unpacked and placed in its final position. Read the Safety Instruction for lifting the machine (page 2), before it is moved out of the box.	
2. A separate, isolated electrical power cable, 3 Phase and earth is ready for connection to the machine control supply 3x400 V / 63A.	
3. During the installation you need an electrician, ready to connect the machine on the request from our engineer.	
4. The voltage variation on the power supply for the machine control (max. $\pm 10\%$ allowed) is checked and a stabiliser is installed if necessary.	
5. A recommended lubricant is ready to be used in machine. Please see page 2 for recommended lubricants for the material you will be using in the machine	
6. A recommended oil (20 litre) is ready for the hydraulic system. Please see page 3 for recommended oils.	
7. The material (the coil of galvanized steel, with a strip width of 137, 140 or 150 depending on chosen FRU) is ready for the fabrication of the projected tubes.	
8. The tools for the installation: a bore hammer and drill for the bore hammer in $\varnothing 12\text{mm}$ and $\varnothing 16\text{mm}$ is on place and prepared by you.	
9. The floor where the machine, table and decoiler are standing must be in level, with a maximum height difference of $\pm 10\text{mm/m}$. The area must be plain and made of concrete, or equivalent material, and bear up $\geq 2000\text{kg/m}^2$ to facilitate the installation and attachment to the floor.	
10. The compressed air supply for the Tubeformer (200l/min and never lower pressure than 5 bar), with a flexible hose (inside $\varnothing 10\text{mm}$) is ready for connection to the machine.	

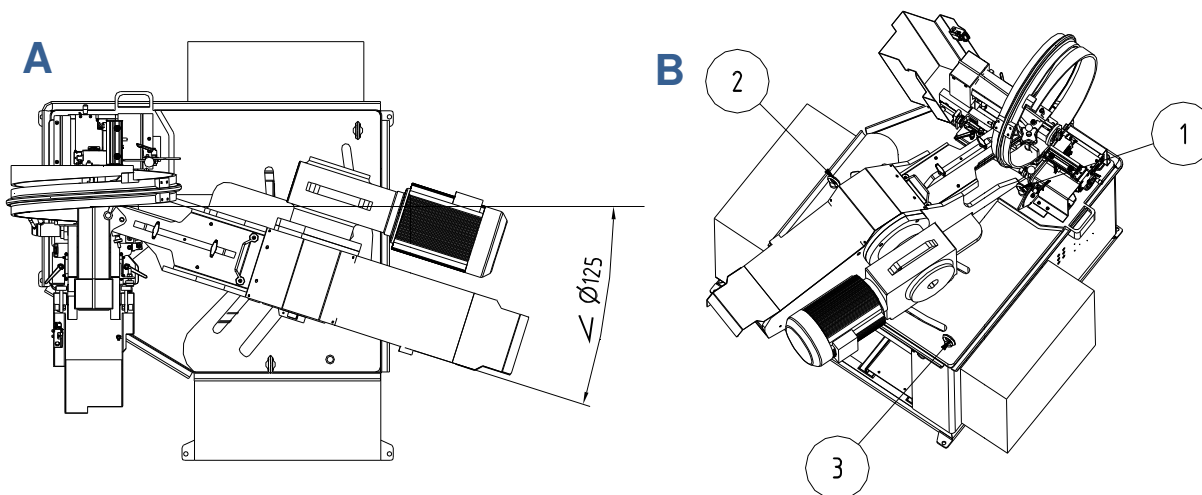
If there are any questions, please contact us and we will be happy to assist you.

Safety instructions

Lifting and transporting the machine within the production area

Never transport or lift the machine, when it is loaded with material.

- A. Adjust the angle of the Rollerhousing to dimension 125, according to the scale.
- B. Secondly, attach the 3 lifting eyebolts that are indicated with numbers on the picture below. The 3 supplied wires are then to be attached, with the order of lengths according to the picture and list.
 1. L= 1040mm
 2. L= 1080mm
 3. L= 1130mm



Recommended lubricants

Subsystem	Shell	Castrol	Esso	Mobile	Texaco Caltex	Total	Chevron	Binol	Arrow	Statoil
Forming Head and galvanized Steel						Scilia AS	GB Oil 19C			
	Dromus Oil BS	Syntilo R	Cutwell 40	Mobilmet 170	Soluble Oil C	Lactuta LT	Soluble Oil T	Binol Cool 102 (101)	Syncut	Cool way G
Forming heads stainless steel	Metalina GL		Sterromar 220	Mobilmet 427	Transulte x A		GB Oil 32			
	Scotch tape 5421 and water soluble oil									
Forming heads Aluminum					Way Lubricant 68	Scilia AS				
	Scotch tape 5421 and water soluble oil									

Recommended oil for the hydraulic system

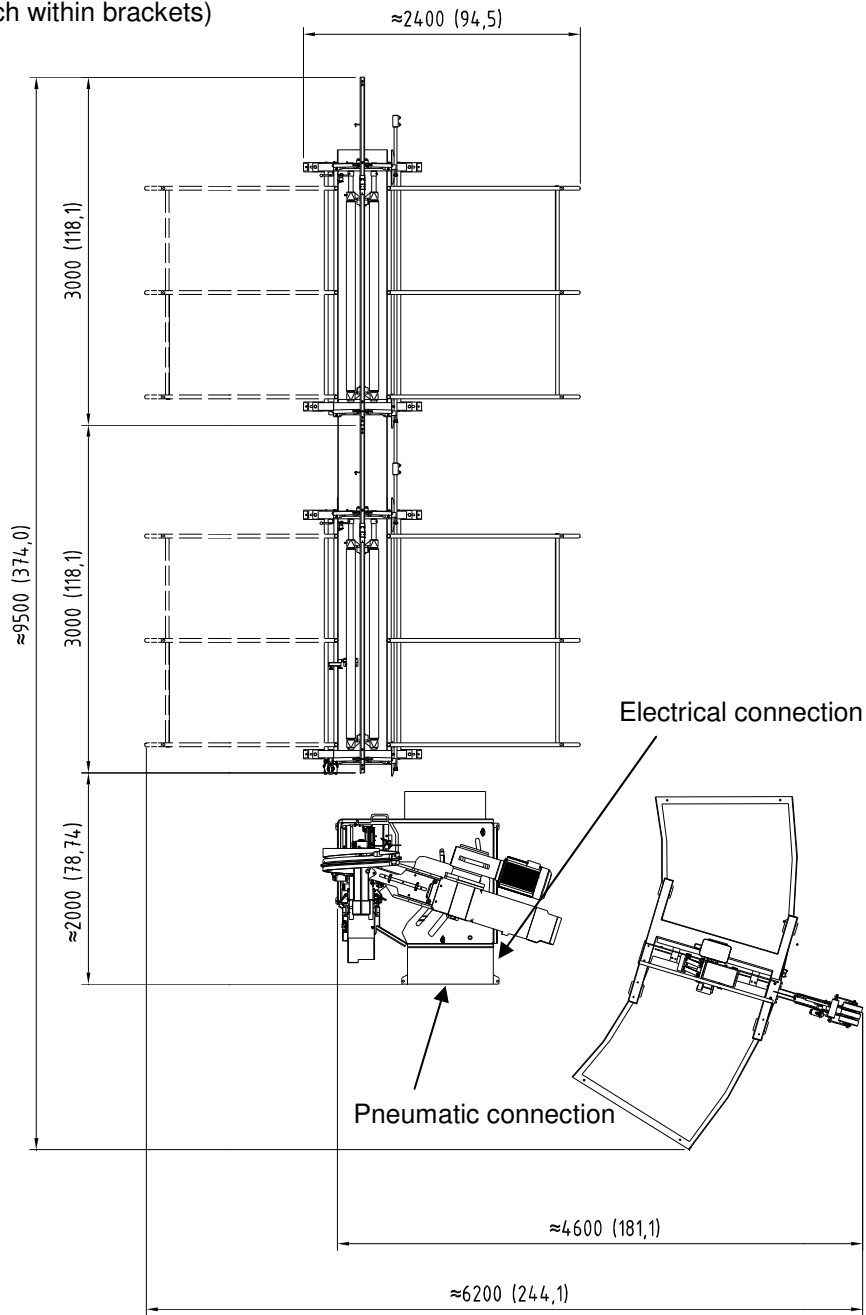
	ISO	ELF	Esso	Mobil	Total	Shell	Motorex	Panolin
HLP (DIN 51 524/T2)	32	Elfolna DS 32	NUTO H 32	Mobil DTE 24	Azoll ZS 32	Tellus 32	Corex HLP 32	HLP ISO 32 HLP Plus 32
HM (ISO 6743/4)	46	Elfolna DS 46	NUTO H 46	Mobil DTE 25	Azoll ZS 68	Tellus 46	Corex HLP 46	HLP ISO 32 HLP Plus 32
	68	Elfolna DS 68	NUTO H 68	Mobil DTE 26	Azoll ZS 68	Tellus 68	Corex HLP 68	HLP ISO 68 HLP Plus 68
HVLP (DIN 51 524/T3)	32	Hydrelf DS 32	Univis N 32	Mobil DTE 13M	Equivis ZS 32	Tellus T and ST 32	Corex HV 32	HLP UNI 32
HV (ISO 6743/4)	46	Hydrelf DS 46	Univis N 46	Mobil DTE 15M	Equivis ZS 46	Tellus T and ST 46	Corex HV 46	HLP UNI 46
	68	Hydrelf DS 68	Univis N 68	Mobil DTE 16M	Equivis ZS 68	Tellus T and ST 68	Corex HV 68	HLP UNI 68
HEES (VDMA 24 568)	32						Oekosynt 2246	HLP Synth 32
HE (ISO 6743/4)	46		Univis Bio SHP 46		Hydrobio 46	Naturell E HFE	Oekosynt 2268	HLP Synth 46
	68							HLP Synth 68

ISO 32 – Cold environment
ISO 68 – Warm environment

Layout

Tubeformer 1602 with two Run Off Tables and a DCV 1200

Dimensions in mm (inch within brackets)



Tubeformer 1602 with two Run Off Tables and a DCH 3000

