HF1 Intermediate Diameter Ultra Adjustable Flight Forming Machine

Pitch

OD mm	ID Minimum mm	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	ID Maximum mm	OD mm
350	75	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	320	350
400	75	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	370	400
450	75	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	420	450
500	90	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	470	500
550	100	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	520	550
600	100	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	570	600
650	100	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	620	650
700	100	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	670	700
750	100	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	720	750
800	125	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	770	800
850	125	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	820	850
900	125	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	870	900
950	125	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	920	950
1000	150	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	970	1000
1050	200	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1020	1050
1100	200	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1070	1100
1150	200	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1120	1150
1200	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1170	1200
1250	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1220	1250
1300	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1270	1300
1350	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1320	1350
1400	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1370	1400
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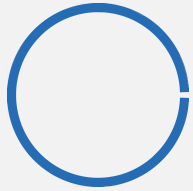
1650	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1620	1650
1700	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1670	1700
1750	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1720	1750
1800	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1770	1800
1850	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1820	1850
1900	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1870	1900
1950	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1920	1950
2000	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	1970	2000
2050	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2020	2050
2100	250	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2070	2100
2150	300	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2120	2150
2200	350	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2170	2200
2250	400	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2220	2250
2300	450	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2270	2300
2350	500	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2320	2350
2400	550	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2370	2400
2450	600	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2420	2450
2500	650	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2470	2500
2550	700	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2520	2550
2600	750	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2570	2600
2650	800	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2620	2650
2700	850	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2670	2700
2750	900	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2720	2750
2800	950	50	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	1000	1200	1400	1600	1800	2000	2200	2400	2600	2800	3000	3500	4000	2770	2800

GREY AREA - Regular Solid Flights Zone

BLUE AREA - Ribbon Flight Zone

WHITE AREA - Outside Blank or Machine Capacity Range

Regular flights are referred as flights who's internal diameter is equals to or greater than one third of their outer diameter.



Ribbon flights are referred as flights who's internal diameter is of not less than ninty percent of their outer diameter.

Disclaimer:

1 This chart is for 20mm thickness mild carbon steel, machine capacities for alternate thickness and material grade may vary.