

HF1 MDVX 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	ID Maximum mm	OD mm
200	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	170	200
250	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	220	250
300	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	270	300
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	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	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	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	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	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	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	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	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	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	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	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	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	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	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	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	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	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	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	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	1270	1300
1350	280	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	1320	1350



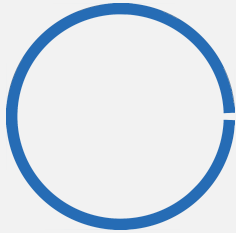
GREY AREA - Regular Solid Flights Zone



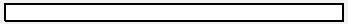
Regular flights are referred as flights who's internal diameter is equals to or greater than one third of their outer diameter.



BLUE AREA - Ribbon Flight Zone



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



WHITE AREA - Outside Blank or Machine Capacity Range

Disclaimer:

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