

HF1 Small Diameter Ultra Adjustable Flight Forming Machine

Pitch

OD mm	ID Minimum mm	Pitch													ID Maximum mm	OD mm
		20	50	100	150	200	250	300	350	400	450	500	550	600		
50	20	20	50	100	150	200	250	300	350	400	450	500	550	600	30	50
100	20	20	50	100	150	200	250	300	350	400	450	500	550	600	80	100
150	40	20	50	100	150	200	250	300	350	400	450	500	550	600	130	150
200	40	20	50	100	150	200	250	300	350	400	450	500	550	600	180	200
250	50	20	50	100	150	200	250	300	350	400	450	500	550	600	230	250
300	60	20	50	100	150	200	250	300	350	400	450	500	550	600	280	300
350	100	20	50	100	150	200	250	300	350	400	450	500	550	600	330	350
400	175	20	50	100	150	200	250	300	350	400	450	500	550	600	380	400
450	200	20	50	100	150	200	250	300	350	400	450	500	550	600	430	450
500	200	20	50	100	150	200	250	300	350	400	450	500	550	600	480	500
550	200	20	50	100	150	200	250	300	350	400	450	500	550	600	530	550



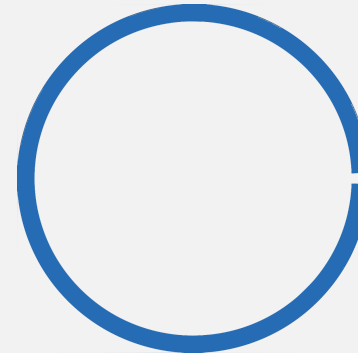
GREY AREA - Regular Solid Flights Zone



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.

Disclaimer:

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