

CONDUIT MACHINES

Engineered Armouring Solutions

For the continuous production of interlocked, square locked and fully interlocked flexible metal conduits.

GENERAL OVERVIEW

Calmec's CT1C Conduit Machines offer:

- True triple drive system; AC vector or servo motor controlled
- Tooling heads for 1, 2 and 3 sets of form rollers, dependent on profiles required
- Tooling heads balanced at every fixed angle position for maximum operational speeds with minimal vibration
- Nominal 1-1/4", 2", and 4" machine sizes
- Aluminum, steel, and stainless steel materials
- 3/8" to 3/4" wide strip
- For traverse wound strip coils; 6", 9" and 12" nominal widths, with maximum pad weights up to 1,500 lbs
- Electric strip tensioning system with automatic self-adjustment; no wear items
- Pneumatic coil chucking
- Colour touch screen process setup and control
- Automatic lubrication regulation dependent on strip speed

Calmec CT1C Conduit Machines are designed for the continuous production of flex (FMC), reduced wall flex (RWFMC), square locked and fully interlocked flexible metal conduits. They produce round conduit for use with cables, hoses, and deep sea umbilicals for offshore oil applications. For square locked and fully interlocked conduit, the strip is formed to the desired profile and helically wrapped around a mandrel using multiple compression rollers. For flex products, specialized curlers are used to form the conduit.

KEY FEATURES

- Head assembly designed for positive and fast tool changeover
- On the 2" and 4" CT1C machines, multiple fixed head angles with balanced positions provide optimum positive placement and higher running speeds
- Hardened tooling for longer wear
- Off-line tooling setups
- Multiple profiles and strip configurations available
- Menu driven colour touch screen for full product range, with recipe specific parameters & tooling requirements, display of system parameters, and maintenance screens
- LED lighting throughout
- Optional Conduit Oscillator and Breaking Roller Assemblies for increased product flexibility



Calmec Precision Limited
1400 Bonhill Road
Mississauga, ON Canada
011-1-905-677-7976
sales@calmec.com
www.calmec.com



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MULTIPLE MOTOR DRIVE SYSTEM

- Four independent AC vector or optional servo motors; for the main spindle, strip feed, strip tensioning, and Cater Puller
- True full motor system, no differential or gear box required; drives digitally synchronized
- Multiple drives eliminate the mechanical variator, PIV, or differential and all the associated mechanical maintenance issues
- Digital drives allow for repeatable, precise and accurate menu set-ups
- Drives can also operate independently for set-up purposes, meaning the strip feed rolls can be run while the tooling head remains stationary; a safer and efficient tooling setup
- Electrical control of strip feed rate with digital setting and display

SPECIFICATIONS

MACHINE MODEL	MAX. SIZE	MAX. MACHINE SPEED	MAX. LINE SPEED	STRIP WIDTH RANGE
CT1C - 32	1 1/4" (32MM)	1100 RPM	30 FEET/ MINUTE	3/8" -1/2"
CT1C - 50	2" (50MM)	1200 RPM	35 FEET/ MINUTE	3/8" - 3/4"
CT1C - 100	4" (100MM)	1000 RPM	30 FEET/ MINUTE	3/8" - 3/4"



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