

# Manchester Tool and Die Model 24022

## Model 24022 Servo Roll Former



The 24022 is an electrically controlled tube end forming machine for rolling and cutting grooves or serrations with tube capacity up to 3/4" (19mm)

diameter. The machine operates by first advancing the grooving head independently. Once in position, the spinning head containing either rolling or cutting tools close over a clamped tube. The position, closure distance and servo flag stop are individually controlled through the machine HMI. The spinning head speed is adjustable from 300 - 1,200 R.P.M.

The design of the machine eliminates any mechanical adjustments which greatly decreases the setup time and increases productivity. Part setup parameters are stored as recipes through the HMI. This machine accepts the same tooling as the hydraulic 24008-HS and 24020 servo models. These machines also provide easy access for tooling changeovers and service, energy savings and noise reduction.



**Contact MTD for more information:**  
Call 260-982-8524 or email at [quotes@mtdbkb.com](mailto:quotes@mtdbkb.com)

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## MTD SPECIFICATIONS

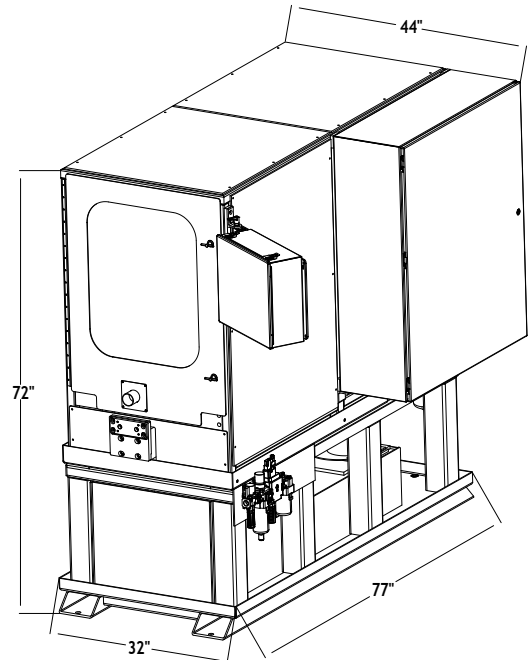
### Standard Equipment

- Tube O.D. Capacity: .75" (19mm)
- Maximum Jaw Opening: 1.25" (31.75mm)
- Spindle Drive Unit: 5HP Variable Speed
- Recirculating System: ¾ HP Graymills Pump
- Clamp Cylinder: 4" Bore with Toggle System
- Air Required: 60 to 80 PSI & 3 CFM
- Electrical Required: Customer Specifications
- Servo Flag Stop
- Part Present Sensor with Programmable Flag Delay
- Recipe Storage through HMI
- 12 Month Warranty

### Valuable Options

- Autoload & Unload Systems
- Custom Cycle Start Initiators
- Light Curtains
- Custom Painting
- C.E. Certification

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## ADVANCED FEATURES

- All Adjustments through HMI
- Stroke & Closure independently controlled
- Quickly Changeover to Roll or Cut Grooves
- Easy Access for Tooling Changeover and Service
- Machine Fault Diagnostics through HMI
- Compact Footprint

Machine Weight is Approximately: 3,800 lbs.

Manchester Tool & Die, Inc. also works with the customer to create machines for unique applications.



### Manchester Tool & Die, Inc.

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