

# Manchester Tool and Die

## Model M10-E Series

### Multi-Platform Tube End Forming System

The Manchester model M10-E series is an electrically controlled tube end forming/roll forming machine with tube capacity up to 3/4" (19mm) diameter.

The end forming station is an M71-E-6 or M71-E-3 model ram. The M71-E-6 has a servo driven, six position rotary shuttle and the M71-E-3 has a pneumatically driven, three position shuttle. These are easily programmed through the machines HMI. The ram is servo driven through a mechanical linkage system and also allows for independent stroke speed adjustment. This station also accepts the same tooling at the M71-H & M71-E models.

The roll forming station uses the 24020 model 5HP variable speed ball screw unit. The spinning head speed is adjustable from 300 - 1,200 R.P.M. This station also accepts the same tooling as the hydraulic 24008-HS model.

Both stations can be operated either consecutively or simultaneously by an operator or integrated automation. And the clamp system for both stations is a pneumatic linkage system.



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

[www.mtdtube.com](http://www.mtdtube.com)

# Model M10-E Series Multi-Platform Tube End Forming System

## MTD SPECIFICATIONS

### Standard Equipment

- Air Required: 95 PSI & 4-5 CFM
- Electrical Required: Customer Specifications
- Servo Flag Stops
- Part Present Sensors
- Recipe Storage through HMI
- 12 Month Warranty

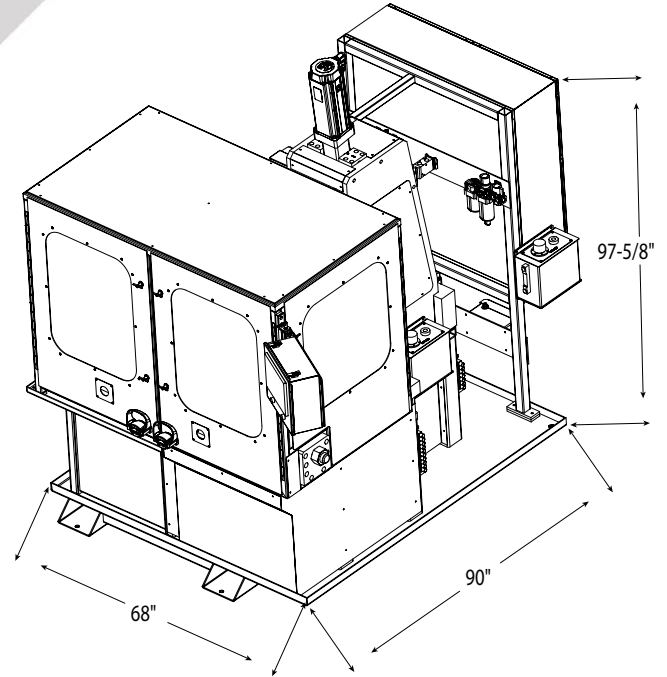
### End Forming Station

- Tube O.D. Capacity: 1.5" (38mm)
- Cycle Time: 2.0 to 9.2 seconds\*
- Ram System: Servo Driven Toggle with 6" of stroke
- Clamp System: Pneumatically Driven Toggle with 8" Bore Cylinder
- Available in 6 stroke rotary or 3 stroke swing

### Roll Forming Station

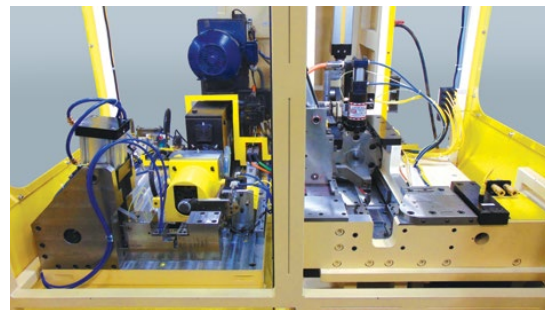
- Tube O.D. Capacity: .75" (19mm)
- Cycle Time: 4.3 seconds\*
- Main Drive Unit: 5HP variable speed drive with Ball Screw Unit
- Recirculating System: 3/4" HP Graymills Pump
- Clamp Cylinder: 4" Bore with Toggle System

\*Cycle time depends on end form & machine parameters



## VALUABLE OPTIONS

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



**Machine  
Weight is  
Approx:  
6,800 lbs.**

**CALL FOR AVAILABLE STOCK MACHINES**



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

### Manchester Tool & Die, Inc.

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