

TFB Wiper Dies

It's not the price of the wiper die itself that makes it costly or inexpensive. It's how the wiper die performs. A precisely machined TFB wiper die, one that can be positioned quickly and is properly supported by the bend die, will produce good bends, have a longer tool life, and will be the most cost efficient. Conversely, the most expensive wiper die is the one that takes longer to position, produces marginal bends, requires frequent operator repairs, and has more down time than running time. And it may even cost more.

TFB wiper dies are available for round, square, and rectangular tubes and for shapes and extrusions. You can choose either Ampco bronze or steel, with optional Kro-Lon® surface.



Figure 4-1. With moderate thumb nail pressure, the wiper's leading edge must deflect evenly all around, often 0.005" to 0.010" (0.13 mm to 0.26 mm).

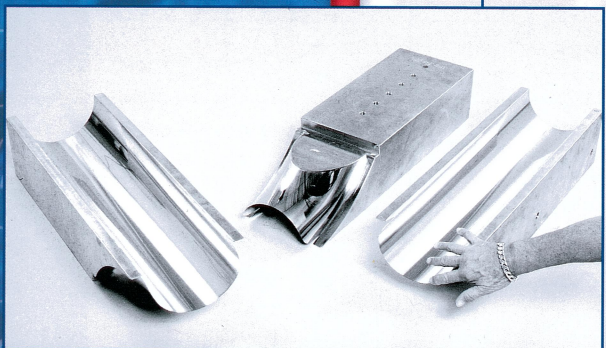


Figure 4-2. To prevent tube scratches and prolong tool life, the new TFB wiper die finishing process provides extraordinary polished tube grooves and C.L.R. machined surface.

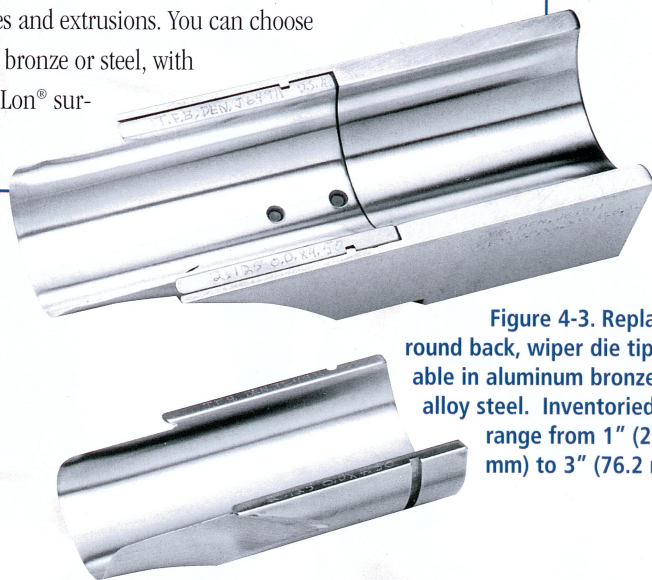


Figure 4-3. Replaceable, round back, wiper die tips, available in aluminum bronze or alloy steel. Inventoried sizes range from 1" (25.4 mm) to 3" (76.2 mm).

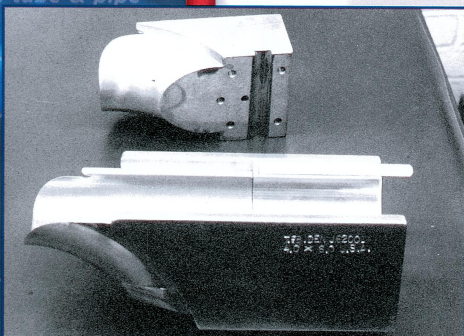


Figure 4-4. The ultimate wiper die, with Kro-Lon® on special steel and lube holes on both tube groove and C.L.R. surfaces.

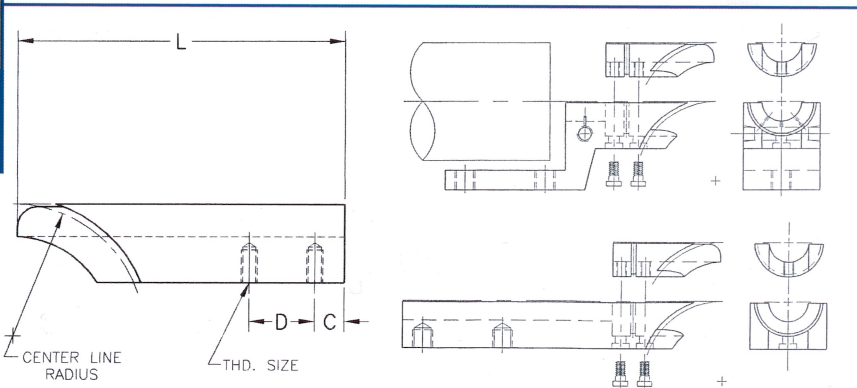


Figure 4-5. Conventional, square back, wiper die and wiper die tips, with standard and offset holders to clear collet and reduce drop length.