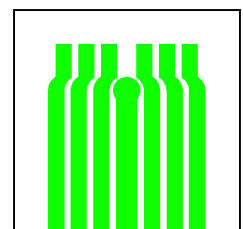


# MODEL BFA Tube End Sizer



The Model **BFA Tube End Sizer/Flarer** is an air operated vibrating type device that is designed to produce a final bell and flare on the end of a heat transfer coil tube extension. The bell and flare will allow for the insertion and brazing of return bends or other related fittings.

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*Customer Driven Designs*

**Tube Expansion**

# TRIDAN MODEL BFA

The TRIDAN Models BFA-2H & BFA-2V TUBE END SIZER & FLARERS are portable hand-held devices designed for the sizing and flaring of thin walled copper tube of diameters 5/16" (7.94mm) to 5/8" (15.875mm). Their operation is simple with the operator placing the specially designed combination sizing & flaring tool inside the tube end to be sized and flared, activating the trigger, and the tube end being sized to the proper inside diameter and the flare being formed.

## BASIC SIZER:

The BFA-2H & BFA-2V consist of the impact hammer with activating trigger, air line filter and lubricator, air pressure regulator, tool balancer and air hose. The Model BFA-2H is designed for longer finned length coils, which are normally sized and flared with the coil (hairpins bends) in the horizontal plane; while the Model BFA-2V is designed for shorter finned length coils, which are normally sized and flared with the coil (hairpin bends) in the vertical plane.

## SIZING COLLETS:

The interchange sizing and flaring tools are held in the BFA-2H and BFA-2V by a specially designed beehive spring retainer. The tools are made from S7 Tool Steel and heat treated to a 56/58 Rc. They are designed for a specific unsized tube ID and sized tube ID. The length of sizing portion is also preset by the design of the tool; however, the length of the flared portion is controlled by the operator.

## TECHNICAL SPECIFICATIONS

|   |   |
|---|---|
| <b>Tubes per Cycle</b>                  | <b>One(1)</b>                                   |
| <b>Tube Material</b>                    | <b>Copper</b>                                   |
| <b>Tube Wall Thickness</b>              | <b>.012" - .035" (0.3/0.88mm)</b>               |
| <b>Tube OD / Sized Depth / Sized ID</b> | <b>5/16" / 5/16" / .317" (7.94/7.94/8.05mm)</b> |
| <b>(standard sizing/flaring tools)</b>  | <b>3/8" / 5/16" / .380" (9.5/7.94/9.65mm)</b>   |
| <b>(special sizes available)</b>        | <b>1/2" / 3/8" / .505" (12.7/9.5/12.83mm)</b>   |
|   | <b>5/8" / 1/2" / .630" (15.88/12.7/16mm)</b>    |
| <b>Flare Angle</b>                      | <b>30 Degrees</b>                               |
| <b>Average Cycle Time</b>               | <b>3 Seconds</b>                                |
| <b>Blows(impacts) per Minute</b>        | <b>5200</b>                                     |
| <b>Collet Changeover Time</b>           | <b>1/2 Minute - approximate</b>                 |
| <b>Air Hose Length</b>                  | <b>6 Feet (1.8 Mtrs)</b>                        |

