

## RNM SERIES HOT SPINNING MACHINE SPECIFICATIONS:

MODEL	RNM 24	RNM 41	RNM Jumbo
Operations Performed	Necking In Operation Bottom Closing Operation	Necking In Operation Bottom Closing Operation	Necking In Operation
Work Piece	Seamless Pipes with one or two open ends	Seamless Pipes with one or two open ends	Seamless Pipes with one or two open ends
Machine Operation	Automatic	Automatic	Automatic
Production Rate (Operation / hour)	40 80	30 45	8 10
Control	SIEMENS CNC SINUMERIK 840D	SIEMENS CNC SINUMERIK 840D	SIEMENS CNC SINUMERIK 840D

**Work-Piece Dimensions**

Outside diameter maximum	mm	236	406	660
Outside diameter minimum	mm	60	220	400
Length maximum	mm	1.700	2.200	12.000
Length minimum	mm	400	800	4.000
Thickness maximum	mm	6	15	20
Thickness minimum	mm	1,5	3	6

**Main Drive**

Spindle Drive Motor Rating	kW	75	129	370
Adjustable Spindle Drive Rotation Speed @ Performance	rpm	0 - 1000	0 - 900	0 - 640

**Forces**

Total Longitudinal Force	kN	95	180	500
Torque of Roller Swivel Slide	Nm	15.000	50.000	

**Motion & Feed Rates**

Longitudinal Slide Stroke	mm	350	570	
Swivel Operation Angle Range	°	0 - 100	0 - 100	by linear motion
Radial Slide Stroke	mm	12	15	

**Induction Heating System**

Heating Power Capacity	kW	450	800	1.500
Number of Induction Coils for Different Diameter Groups		2	2	upon request

**Utility Supply**

Electrical connection for power components		400V / 50Hz / 3ph	400V / 50Hz / 3ph	400V / 50Hz / 3ph
Control voltage for electrical components	V	24DC	24 DC	24 DC
Approximate connected electric load	kW	650	1.070	2025

**Overall Machine Dimensions (approx.)**

Length	mm	4.000	15.300	23.000
Depth	mm	6.900	7.400	6.000
Height from floor level	mm	2.900	3.300	3.500

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**35** YEARS  
OF QUALITY

THE ULTIMATE  
HOT SPINNING MACHINE  
RNM - SERIES

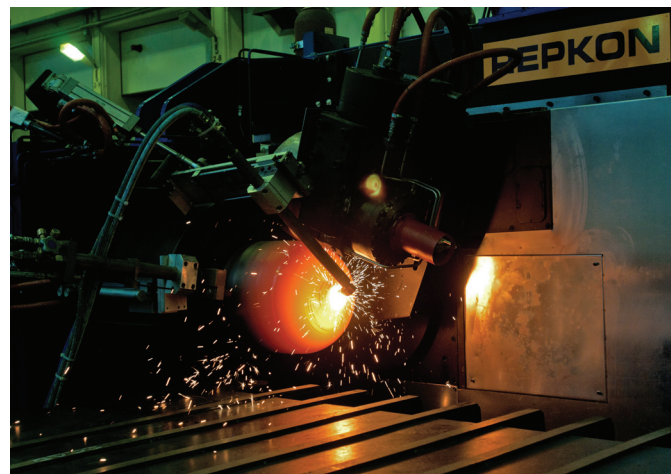
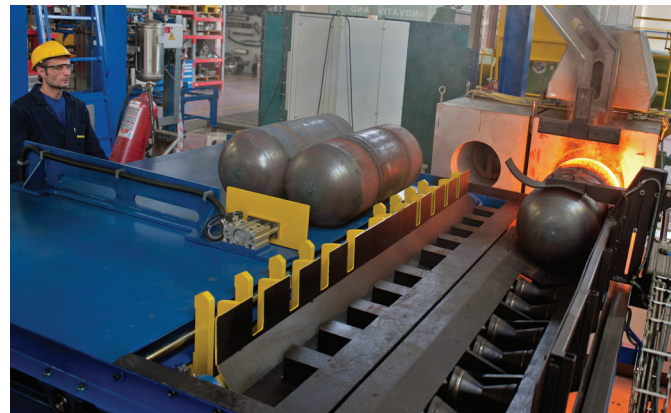
**REP KON**

*..setting flowforming 'free'.*

# BEST HOT SPINNING MACHINES INDUSTRY HAS TO OFFER:

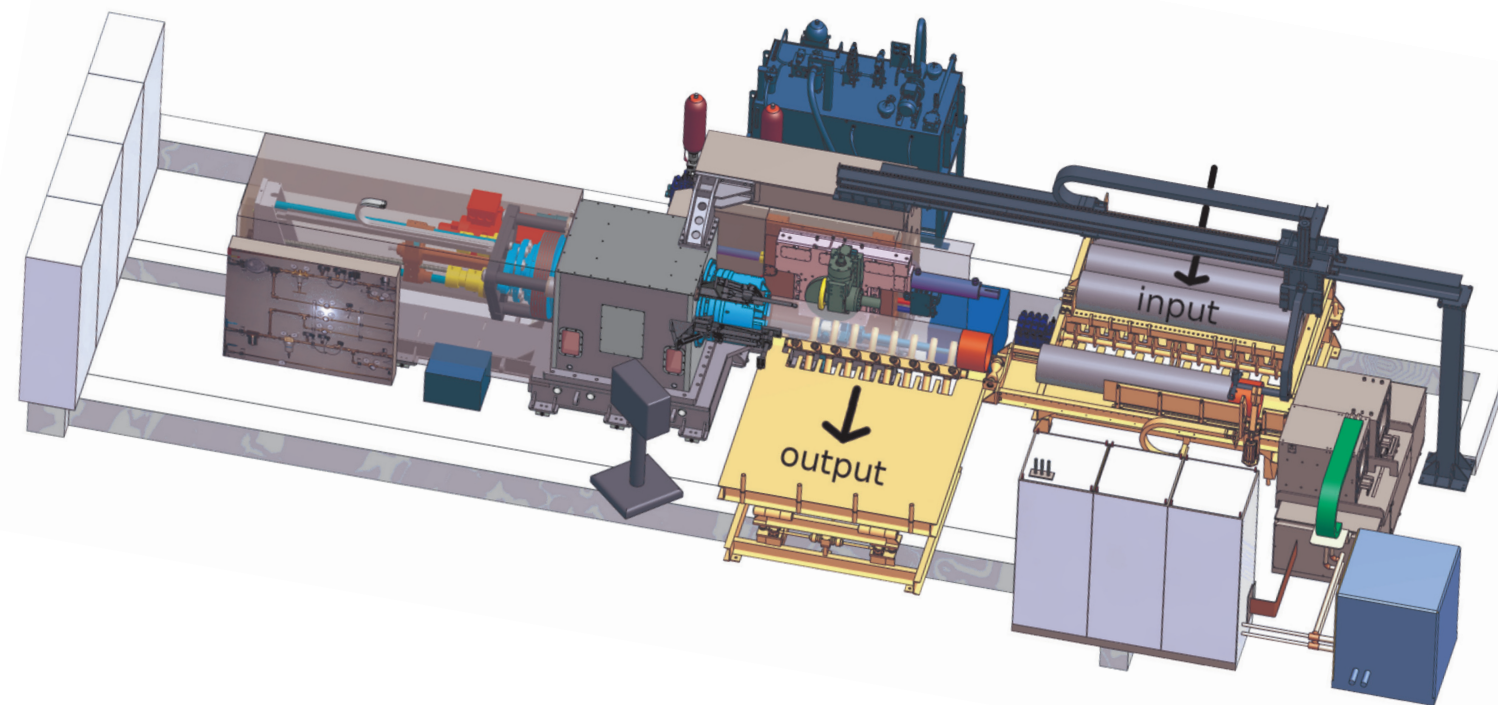
Repkon is proud to introduce the ultimate hot spinning machines. Designed and manufactured by REPKON, the new generation Hot Spinning Machines are:

- RNM 24
- RNM 41
- RNM Jumbo



RNM 41

These fully automated hot spinning machines substantiate full range of technical enhancements to optimize operational efficiency in short cycle times, ensuring impeccable process quality. The CNC controlled machines are specially designed for heavy duty operations with exceptionally robust structure and optimized throughput, using state-of-the-art technology and high performance components.



**OPERATIONS PERFORMED:** Fully automated, RNM 24 (up to 240 mm outer diameter) and RNM 41 (up to 410 mm outer diameter) perform both necking-in and bottom closing operations with relevant tooling. RNM Jumbo, on the other hand, performs necking-in operation on both ends of jumbo cylinders up to 12.000 mm in length and 660 mm outer diameter.

## MAIN FEATURES OF REPKON RNM SERIES HOT SPINNING MACHINES

- Fully integrated induction heating furnace aligned with machine's working axis, in order to minimize auxiliary times
- Induction heater with double coil for different diameter tubes with automatic change, yielding faster and more homogenous heating
- Automatic, servo CNC controlled loading-unloading and transfer system with integrated tables for easy and speedy load / unload
- Energy fail-free high force work-piece clamping system, whereby heavy duty clamping jaws are closed in default position by gas cylinders for safety
- Fixed hydraulic work piece unclamping system to optimize forming process & auxiliary times
- Robust machine bed with base plate enabling direct factory site installation
- Servo CNC controlled, ball-screw driven ejector with high-pressure hydraulic rod clamps allowing gapless positioning to length and quick ejection
- Shortest change over times by replacing only guide tube, ejector plate and clamp shoes without need for adjustment or adaptor pieces
- Vertical roller slide ensuring perfect geometry and rigidity for flawless surface forming and ruling out scale precipitation onto the machine thus extending the life span of equipment
- Fabricated steel roller slide support frame providing precise rigidity to achieve smooth work contours at the edges of forming area
- Ability to manufacture longer conical forms by extended horizontal slide stroke
- Scale collection tray for convenient maintenance
- Excellent maintenance accessibility around the chuck and roller slide area for preventive and corrective maintenance
- High precision servo valve control of slide movements allowing for the production of perfect contour shaped parts
- Preloaded longitudinal slide guide ways with roller shoes
- Remote diagnostic maintenance service via tele-service