

F3 Forming machine for EO2-FORM high pressure tube connections

Machine Type	Order code F3	Order code PRO22
EO2-FORM basic unit for forming tube ends, ready to operate with magnetic gripper, holder and operator's handbook, but without tools, packed in a special transportation box		
Universal EO2-FORM F3 machine Tube OD 6-38/42 mm 400 V, 50 Hz, 3 phase 230 V, 50 Hz, 3 phase 440 V, 60 Hz, 3 phase Rental (monthly usage) Leasing (24 leasing rate)	EO2FORMF3400V EO2FORMF3230V EO2FORMF3440V EO2FORMF3RENTFEE EO2FORMF3LEASEFEE	
Production machine EO2-FORM PRO22 Tube OD 6-20/22 mm 400 V, 50 Hz, 3 phase Rental (monthly usage) Leasing (24 leasing rate)		EO2FORM400VPRO EO2FORMPRORENTFEE EO2FORMPROLEASEFEE
Accessories Type	Order code F3	Order code PRO22
Lubrication for forming pin: 0.25 L bottle EO-NIROMONT 1L re-fill pack EO-NIROMONT	EONIROMONTFLUESSX LUBSS	EONIROMONTFLUESSX LUBSS
Oil cooler kit	F3/COOLERKIT	included
Foot switch	F3/FOOTSWITCH	F3/FOOTSWITCH
Magnetic gripper for forming pin	F3/PINHOLDER	F3/PINHOLDER
Holder for forming die set	F3/DIEHOLDER	F3/DIEHOLDER
Clamping segments for die set	F3/DIECLAMP	F3/DIECLAMP
Clamping segment spring $\varnothing$ 8 mm	F3/DIECLAMPSRING8	F3/DIECLAMPSRING8
Clamping segment spring $\varnothing$ 12 mm	F3/DIECLAMPSRING12	F3/DIECLAMPSRING12
Operation manual: UK, DE, FR, IT, SWE	4033	EO2FORMPRO/MANUAL
Standard preventive maintenance	EO2FORMF3/INSPECTION	EO2FORMF3/INSPECTION

EO2-FORM F3 machines are shipped in special containers which should be kept for future transports to avoid damage. Please don't dispose the transport boxes!

Machine housing Type	Order code F3	Order code PRO22
Top machine cover	F3/HEADCOVER	F3PRO/08836014
Top tray	F3/TOPTRAY	F3/TOPTRAY
Door lock for tool compartment	F3/DOORLOCK	F3/DOORLOCK
Door hinge	F3/DOORHINGE	F3/DOORHINGE
Shock absorber for doors	F3/DOORSRING	F3/DOORSRING
Tool tray for inner tool compartment (top), 6x	F3/TOOLTRAYIN	F3/TOOLTRAYIN
Tool tray for inner tool compartment (bottom), 6x	F3/0883611	F3/0883611
Tool tray for tool compartment in doors, 2x	F3/TOOLTRAYDOOR	F3/TOOLTRAYDOOR
Die insert for tool tray (use screw M6)	F3/TOOLTRAYDIE	F3/TOOLTRAYDIE
Holder for magnetic gripper	F3/PINHOLDERTRAY	F3/PINHOLDERTRAY
Holder for holder	F3/DIEHOLDERTRAY	F3/DIEHOLDERTRAY
Plastic guide for forklift (use screw M6)	F3/FORKGUIDE	F3/FORKGUIDE
Front wheel with lock	F3/FRONTWHEEL	F3/FRONTWHEEL
Rear wheel	F3/BACKWHEEL	F3/BACKWHEEL



Foot switch



Magnetic gripper for forming pin



Holder for forming die set



Oil cooler kit

Assembly tooling

Sticker Type	Order code F3	Order code PRO22
EO2-FORM door label	F3/STICKERPARKER	F3PRO/STICKERPARKER
Short instructions on side	F3/STICKERINSTRUC	F3PRO/STICKERINSTRUC
Lubrication on front	F3/STICKERLUB	F3/STICKERLUB
Crane attachment (1 piece)	F3/STICKERCRANE	F3/STICKERCRANE
Forklift on front	F3/STICKERFORK	F3/STICKERFORK

Operation panel Type	Order code F3	Order code PRO22
Front panel counter	F3/FRONTCOUNTER	F3/FRONTCOUNTER
"START" switch (black with symbol)	F3/STARTSWITCH	F3/STARTSWITCH
"RESET" switch (blue)	F3/RESETSWITCH	F3/RESETSWITCH
"ON" switch (green)	F3/ONSWITCH	F3/ONSWITCH
"OFF" switch (red)	F3/OFFSWITCH	F3/OFFSWITCH
Emergency stop switch (red)	F3/STOPSWITCH	F3/STOPSWITCH

Tool Components Type	Order code F3	Order code PRO22
Bayonet bolt for forming pin	F2/PINBOLT	F2/PINBOLT
Screw for clamping die segments	F3/DIESCREW	F3/DIESCREW
Spare part kit for clamping die set (4x Pin Ø4, 4x Spring Ø8, 4x Spring Ø12, 4x Screws)	F3/DIEKIT	F3/DIEKIT



Pin for forming pin



Pin for clamping die set

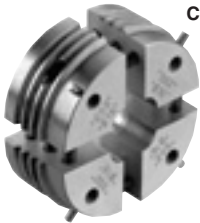
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Clamping die set MF3EO-2		Forming pin BF3EO-2		
				
Tube O.D. Ø	Clamping dies for steel and stainless steel tubes Order code	Ø x s	Forming pin for steel tubes Order code	Forming pin for stainless steel tubes Order code ¹⁾²⁾
06-L/S	MF3EO206	06x1.0 06x1.5 06x2.0	BF3EO206X1S BF3EO206X1.5S BF3EO206X2S	BF3EO206X1SS BF3EO206X1.5SS
08-L/S	MF3EO208	08x1.0 08x1.5 08x2.0 08x2.5	BF3EO208X1S BF3EO208X1.5S BF3EO208X2S BF3EO208X2.5S	BF3EO208X1SS BF3EO208X1.5SS
10-L	MF3EO210	10x1.0 10x1.5 10x2.0	BF3EO210LX1S BF3EO210LX1.5S BF3EO210LX2S	BF3EO210LX1SS BF3EO210LX1.5SS BF3EO210LX2SS
10-S	MF3EO210	10x1.5 10x2.0 10x3.0	BF3EO210SX1.5S BF3EO210SX2S BF3EO210SX3S	BF3EO210SX1.5SS BF3EO210SX2SS
12-L	MF3EO212	12x1.5 12x2.0	BF3EO212LX1.5S BF3EO212LX2S	BF3EO212LX1.5SS BF3EO212LX2SS
12-S	MF3EO212	12x1.5 12x2.0 12x3.0	BF3EO212SX1.5S BF3EO212SX2S BF3EO212SX3S	BF3EO212SX1.5SS BF3EO212SX2SS
15-L	MF3EO215	15x1.0 15x1.5 15x2.0	BF3EO215X1S BF3EO215X1.5S BF3EO215X2S	BF3EO215X1.5SS BF3EO215X2SS
16-S	MF3EO216	16x2.0 16x2.5 16x3.0	BF3EO216X2S BF3EO216X2.5S BF3EO216X3S	BF3EO216X2SS BF3EO216X2.5SS BF3EO216X3SS

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Tube O.D. Ø	Clamping dies for steel and stainless steel tubes Order code	Ø × s	Forming pin for steel tubes Order code	Forming pin for stainless steel tubes Order code ¹⁾²⁾
18-L	MF3EO218	18×1.5 18×2.0	BF3EO218X1.5S BF3EO218X2S	BF3EO218X1.5SS BF3EO218X2SS
20-S	MF3EO220	20×2.0 20×2.5 20×3.0 20×3.5	BF3EO220X2S BF3EO220X2.5S BF3EO220X3S BF3EO220X3.5S	BF3EO220X2SS BF3EO220X2.5SS BF3EO220X3SS BF3EO220X3.5SS
22-L	MF3EO222	22×1.5 22×2.0	BF3EO222X1.5S BF3EO222X2S	BF3EO222X1.5SS BF3EO222X2SS
25-S	MF3EO225	25×2.0 25×2.5 25×3.0 25×4.0	BF3EO225X2S BF3EO225X2.5S BF3EO225X3S BF3EO225X4S	BF3EO225X2SS BF3EO225X2.5SS BF3EO225X3SS BF3EO225X4SS
28-L	MF3EO228	28×2.0	BF3EO228X2S	BF3EO228X2SS
30-S	MF3EO230	30×3.0 30×4.0 30×5.0	BF3EO230X3S BF3EO230X4S BF3EO230X5S	BF3EO230X3SS BF3EO230X4SS BF3EO230X5SS
35-L	MF3EO238	35×2.0 35×3.0	BF3EO235X2S BF3EO235X3S	BF3EO235X2SS BF3EO235X3SS
38-S	MF3EO242	38×3.0 38×4.0 38×5.0 38×6/7	BF3EO238X3S BF3EO238X4S BF3EO238X5S BF3EO238X6+7S	BF3EO238X3SS BF3EO238X4SS BF3EO238X5SS BF3EO238X6+7SS
42-L		42×2.0 42×3.0	BF3EO242X2S BF3EO242X3S	BF3EO242X2SS BF3EO242X3SS

Tools for hose connection DIN 71550

					
Tube O.D. Ø	Clamping dies for steel and stainless steel tubes Order code	Ø × s	Forming pin for steel tubes Order code	Forming pin for stainless steel tubes Order code ¹⁾²⁾	
10	MF3EO210	10x1.5	BF3DIN7155010X1.5S		
12	MF3EO212	12x1.5	BF3DIN7155012X1.5S	BF3DIN7155012X1.5SS	
15	MF3EO215	15x2.0	BF3DIN7155015X2S		
18	MF3EO218	18x1.5	BF3DIN7155018X1.5S		
20	MF3EO220	20x2.5	BF3DIN7155020X2.5S		
22	MF3EO222	22x1.5	BF3DIN7155022X1.5S	BF3DIN7155022X1.5SS	
25	MF3EO225	25x2.0	BF3DIN7155025X2S	BF3DIN7155025X2SS	
28	MF3EO228	28x1.5 28x2.0	BF3DIN7155028X1.5S	BF3DIN7155028X1.5SS BF3DIN7155028X2SS	
30	MF3EO230	30x1.5		BF3DIN7155030X1.5SS	
32	MF3EO232	32x1.5	BF3DIN7155032X1.5S		
35	MF3EO235	35x2.0		BF3DIN7155035X2SS	

Tool compatibility: *Italic* = Tools for EO2-FORM F3 WorkCenter
Regular = Tools for EO2-FORM F3 and PRO22 WorkCenter

Please select clamping die and forming pin according to tube dimension and material.

1) All forming pins for stainless steel tubing are marked with a blue dot on front surface.

2) Stainless steel tools are TiN coated.

Clamping die sets which are only used for stainless steel tubes should be marked with the blue dot sticker to avoid use with steel tube.

Tool lifetime

Assembly tools are subject of wear and must be regularly (max. 50 assemblies) cleaned and checked (Checking instructions see chapter E). Worn out tools can cause dangerous assembly failures and must be replaced in time. Average tool lifetime is approx. 5000 cycles when properly used. Maximum lifetime can be achieved by following factors:

- Regular cleaning and checking
- Clean and corrosion-protected storage
- Proper de-burring and cleaning of tube end
- Proper tool selection and operation
- Use of specified lubricant