



ABBHEY ETNA ROTARY SWAGER SPECIFICATIONS

SWAGER SERIES									
CAPACITIES	30	70	100	150	190	200	300	400	600
MAX. TUBE CAPACITY	.375"	.750"	1.000"	1.500"	2.250"	2.000"	3.000"	4.000"	6.000"
MAX. SOLID CAPACITY	.187"	.375"	.500"	.750"	.875"	1.000"	1.500"	2.000"	3.000"
WIDTH OF DIE	1.000"	1.375"	1.875"	2.500"	3.000"	3.250"	4.500"	5.750"	8.500"
THICKNESS OF DIE	.750"	1.125"	1.125"	1.625"	1.875"	2.250"	3.250"	3.750"	6.000"
NUMBER OF ROLLS	10	10	10	16	18	18	20	20	20
DIAMETER CAGE ROLL	1.125"	1.437"	1.562"	1.963"	2.125"	2.375"	2.718"	3.303"	4.800"
CENTER HEIGHT	36"	36"	36"	36"	38"	40"	42"	42"	44"
OVERALL HEIGHT	42"	47 1/8"	52"	54"	56"	86 3/8"	95 3/4"	97 1/2"	116"
FLOOR SPACE	17" x 21"	22 1/2" x 26 1/2"	26" x 35"	32" x 45"	32" x 46"	36" x 53"	40" x 64 1/8"	44" x 76 1/2"	48" x 95 1/2"
FLYWHEEL DIAMETER	10 3/8"	20"	28 1/2"	31 5/8"	31 5/8"	41 1/8"	47 3/4"	53 3/4"	63 1/4"
FLYWHEEL FACE	2 3/16"	4"	4 1/2"	5"	5"	6 1/2"	9"	10 3/4"	17"
MOTOR SPEED	1800	1750	1750	1150	1200	1150	860	690	575
NUMBER OF BELTS	2	3	4	5	5	8	8	10	11
BELT NUMBER	A-75	A-90	B-112	B-112	BP-116	B-158	C-180	C-195	D-240
DIA. HOLE THROUGH SPINDLE	5/8"	1 1/16"	1 5/16"	1 3/4"	2 9/32"	2 9/16"	3 3/16"	4 1/4"	6 1/2"
WT. MACHINE SKIDDED (LBS)	700	1430	2530	4500	6500	11250	19000	23400	44000
WT. ADDED PER 2" CHANGE	0	140	200	300	500	900	1100	1700	2300
RPM - SWAGER	600	400	375	200	200	175	165	145	120
HP - SWAGER	1	2	3	7.5	15	15	25	40	75
HAMMER BLOWS PER MIN.	6000	4000	3750	3200	3780	3150	3300	2900	2400
DIE LENGTHS AVAILABLE	1" - 2"	2" - 4" - 6"	3" - 4" - 6"	4" - 6" - 8" 10" - 12" 15" - 18"	6" - 8" - 12" 15" - 18"	6" - 8" - 10" 12" - 16"	6" - 8" - 10" 12" - 16"	6" - 8" - 10" 12" - 16" 24"	8" - 12" 16" - 18"

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1. The 150 swager is also available with a 3.000" wide die slot. The max. tube capacity is light gauge 2.000". The motor spec is 10 hp.
2. The 190 series max. tube capacity of 2.250" applies to light gauge tube only.
3. The 190 through 600 series swagers are available as two (2) or four (4) die units.
4. Abbey Etna also offers a 900 series swager which has a 8.000" max. tube capacity and a 4.000" max. solid capacity with an 8" to 16" die length.
5. The specifications shown above are typical of two (2) die swagers.

ROLL TYPE FEEDS

Feeds of this type are used when work is fed continuously through the dies or when it is being sized over a mandrel. Roll feeds can be mounted at either or both ends of a swager. Where they can be used, they will increase production to an important degree over manual feeds.

