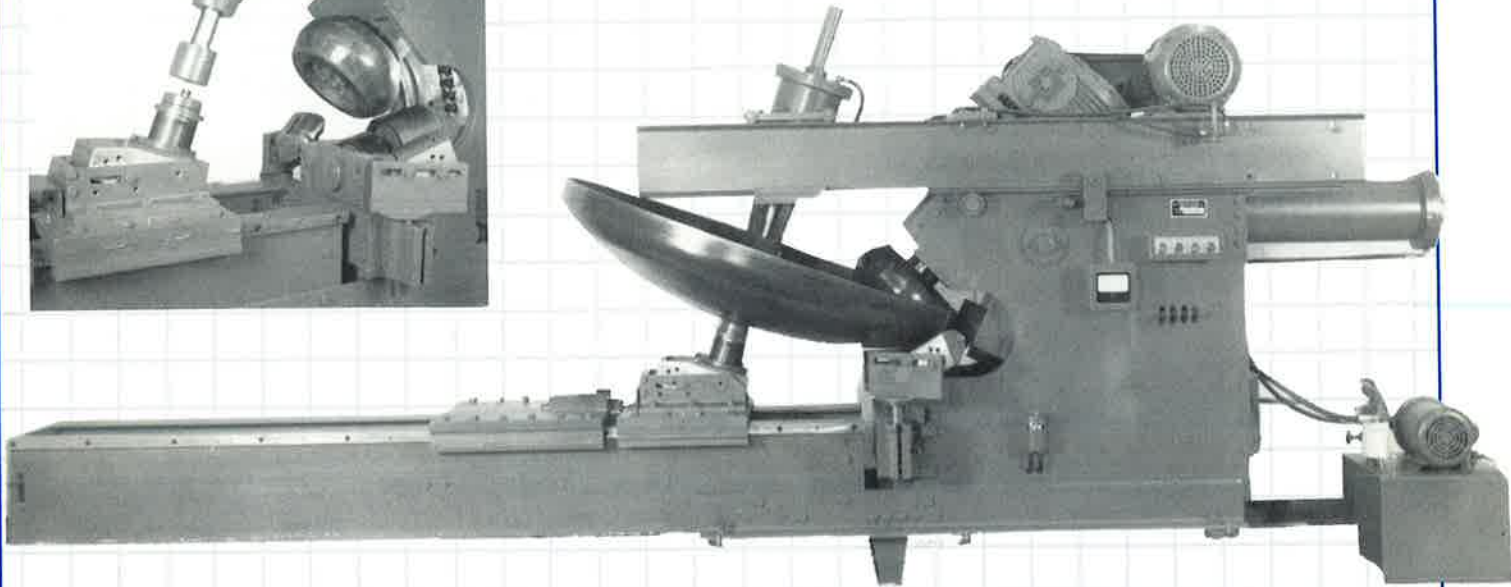
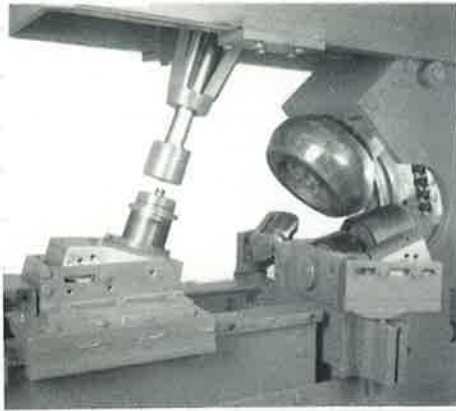


# MODELS 3, 4, 6, 8 & 9

## Flanging Machines



### GENERAL INFORMATION

In today's market, the Blue Valley line of Flanging Machines gives customers a simple and affordable alternative means of producing a variety of work pieces using an operation that has a less-stressful effect on the material than competitive methods.

The method is a bending or breaking action, much like a press brake, except the work piece is rotating. The upper roll on all our machines supplies this rotational drive and, at the same time, is the focal point where the flange is formed. Thus, the inside radius (knuckle radius) is determined by the radius machined on to the interchangeable upper roll.

**Custom Design** — Standard Blue Valley Flanging machines are readily adaptable to special applications. The required custom tooling and set-up can be designed by us or from customer supplied drawings.

### CAPACITY

The machine ratings are in mild steel. Blue Valley Flanging Machines are suited for other types of materials, however, when stainless steel or high-strength alloys are used, machine capacities must be down-rated.



Manufacturer of Metalforming Machines  
*Specializing in Tank Heads, Since 1928*

6834 Truman Road  
Kansas City, Missouri 64126  
U.S.A.

Phone (816) 231-1480  
Fax (816) 483-0059

### CAPACITY

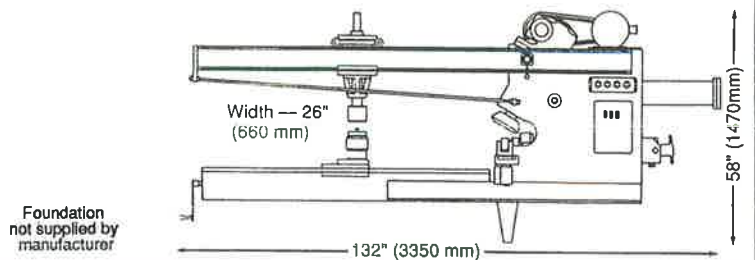
The capacity of a certain machine is defined by the largest radius upper roll that each Blue Valley Flanging Machine will accommodate, as well as, the thickness of the material that is being formed. When forming any type head, it is important to understand that the machine is not capable of performing beyond the limits that are defined by the geometry and size of the work piece.

Please see the reverse side for line drawings of Blue Valley Flanging Machine Models 3, 4, 6, 8 and 9. You will note the specific capacities for each model, as well as, drive motor and hydraulic power unit horsepower, shipping weight, foundation requirements and dimensions.

**We recommend that you contact us with your requirements and let us help you select the right Blue Valley Flanging Machine for your working needs.**

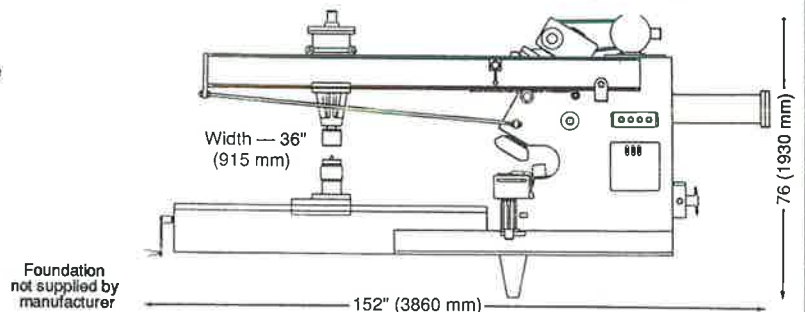
### Model No. 3—1/4" Capacity Flanging Machine

- For flat heads (flange only style) work pieces
- 1/4" (6 mm) max./14 ga. (2 mm) min. thickness
- 12' (3600 mm) max./20" (500 mm) min. diameter
- 1/4" (6 mm) and 3/4" (19 mm) knuckle radii are standard upper rolls supplied\*\*
- 5 HP drive motor—1 HP, 10 gal. free-standing hydraulic power unit
- Crated shipping weight—4,000 lbs.



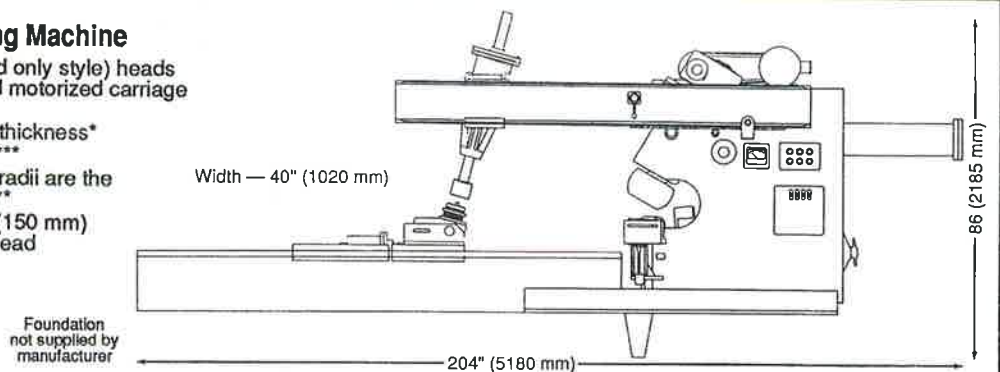
### Model No. 4—3/8" Capacity Flanging Machine

- As standard equipment, for flat (flanged only style) heads
- Options: Dished head attachments and motorized carriage to assist positioning of work piece
- 3/8" (9 mm) max./14 ga. (2 mm) min. thickness\*
- 12' (3600 mm) max./20" (500 mm) min. diameter\*\*\*
- 1/4" (6 mm) and 3/4" (19 mm) knuckle radii are the standard upper flat head rolls supplied\*\*
- 2" (50 mm) knuckle radius is the standard upper dished head roll supplied with dished head attachments\*\*
- 7-1/2 HP drive motor—1 HP, 10 gal. free-standing hydraulic power unit
- Crated shipping weight—6,800 lbs.



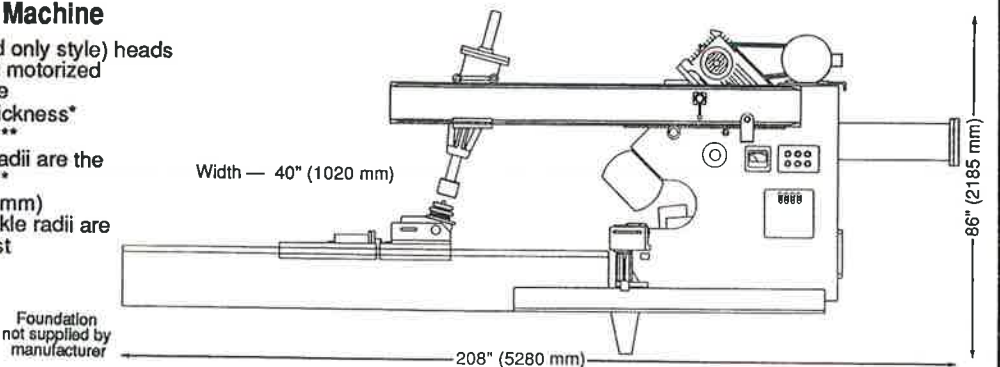
### Model No. 6—5/8" Capacity Flanging Machine

- As standard equipment, for flat (flanged only style) heads
- Options: Dished head attachments and motorized carriage to assist positioning work piece
- 5/8" (16 mm) max./14 ga. (2 mm) min. thickness\*
- 20' (6000 mm) max./24" min. diameter\*\*\*
- 1/4" (6 mm) and 3/4" (19 mm) knuckle radii are the standard upper flat head rolls supplied\*\*
- 2" (50 mm) 3-1/2" (90 mm) and 5-3/4" (150 mm) knuckle radii are the standard dished head rolls supplied with dished head attachments\*\*
- 10 HP drive motor—3 HP, 20 gal. free-standing hydraulic power unit
- Crated shipping weight—11,600 lbs.



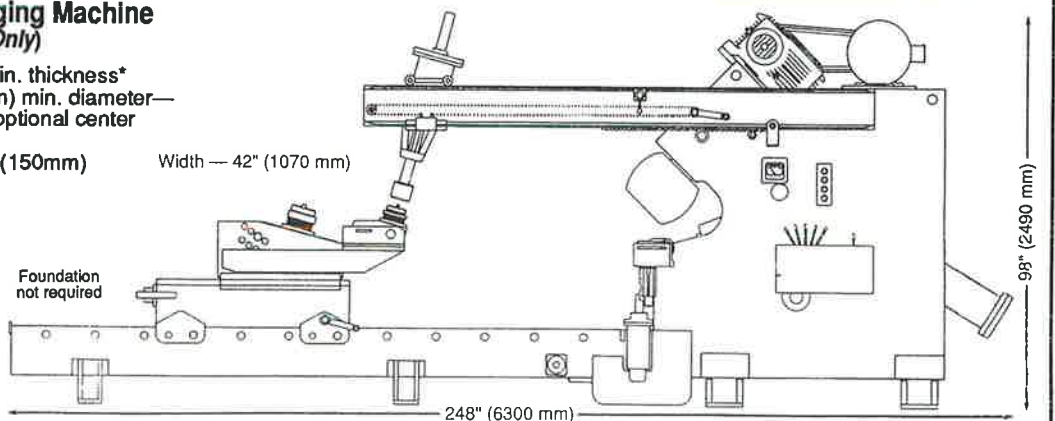
### Model No. 8—1" Capacity Flanging Machine

- As standard equipment, for flat (flanged only style) heads
- Options: Dished head attachments and motorized carriage to assist positioning work piece
- 1" (25 mm) max./14 ga. (2 mm) min. thickness\*
- 20' (6000 mm) max./28" min. diameter\*\*\*
- 3/8" (10 mm) and 1" (25 mm) knuckle radii are the standard upper flat head rolls supplied\*\*
- 2" (50 mm) 3-1/2" (90 mm) 5-3/4" (150 mm) 7-1/4" (185 mm) and 8" (200 mm) knuckle radii are the standard dished head rolls and must be purchased separately\*\*
- 20 HP drive motor—3 HP, 20 gal. free-standing hydraulic power unit
- Crated shipping weight—12,800 lbs.



### Model No. 9—1" Capacity Flanging Machine (For Dished Heads Only)

- 1" (25 mm) max./14 ga. (2 mm) min. thickness\*
- 18' (5400 mm) max./48" (1200 mm) min. diameter—30" (760 mm) min. diameter with optional center attachment\*\*\*\*
- 2" (50 mm) 3-1/2" (90 mm) 5-3/4" (150 mm) 7-1/4" (185 mm) 8" (200 mm) 10" (250 mm) and 12" (300 mm) knuckle radii are the standard upper dished head rolls and must be purchased separately\*\*
- 50 HP drive motor—5 HP, 20 gal. free-standing hydraulic power unit
- Shipping weight—20,000 lbs.



\*When using thinner materials, it becomes difficult to achieve the larger corner radii and straight flange.

\*\* Non-standard rolls can be supplied and are quoted individually. The largest dished head roll that can be supplied on a given machine is the largest standard dished head roll listed.

\*\*\* These figures are max./min. diameter's for flat (flanged only style) heads.

\*\*\*\* These figures are max./min. diameter's for standard flanged and dished style heads.