

## Radial Tubular Forming Tool (RTF™)

Volant RTF tools are designed for both crimping and swaging operations. These tools use a hydraulic actuated piston and collet system to induce a radial compressive load that reduces the diameter of tubular product to create either a crimp or an end swage. Collet sets are designed for optimal performance and are specific to the tubular size and application.

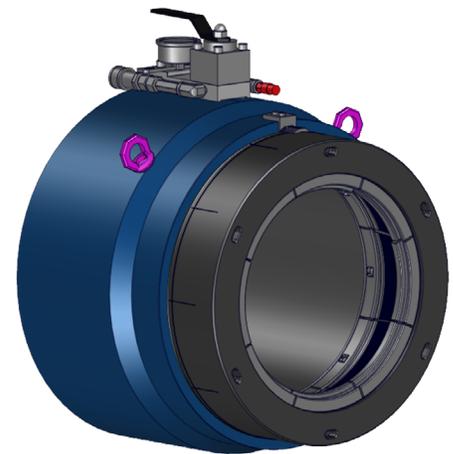
The RTF's simple architecture, result in a solid and robust tool that is portable and easy to handle; ideal for use in the field or a shop environment. For applications that may require a tight crimp or swage tolerance, a fine adjustment mechanism enables precise control of the final crimp or swage diameter.

### Tool Model: RTF-13.38 Specification Summary

Tool configured for 13.63" swaging

#### Base Tool Characteristics

Housing OD	in (mm)	20.9 (535)
Overall Length <sup>5</sup>	in (mm)	18.7 (475)
Base Tool Weight	lbs (kg)	500 (227)
Diametrical Stroke	in (mm)	0.414 (10.55)
Maximum Radial Force <sup>1</sup>	lbf (kN)	1,400,000 (6,200)
Piston Bore Diameter	in (mm)	13.8 (355)
Maximum Pressure Capacity	psi (MPa)	5,000 (34.4)
Base Tool PN		82089



#### Collet Size Specific Characteristics<sup>2</sup>

Nominal Collet Size <sup>3</sup>		Collet Style	Collet Part No.	Bell Part No.	Approximate Dressed Tool Weight	
(in)	(mm)				(lbs)	(kg)
13.38	339.9	Crimp	82037	82038	890	404
9.88	250.9	Crimp	82078	81230	840	382
9.63	244.6	Crimp	80062	81230	810	368
8.63	219.2	Crimp	80186	81230	835	379
7.63	193.8	Crimp	80070	81230	860	391
7.0	177.8	Crimp	80063	81230	880	400

**Give us a problem.** Or just drop us a line if you want to know more.

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## Collet Size Specific Characteristics<sup>2</sup>

Nominal Collet Size <sup>3</sup>		Collet Style	Approximate Dressed Tool Weight	
(in)	(mm)		(lbs)	(kg)
13.63	346.2	Swage	680	309
13.38	339.9	Swage	685	311
10.75	273.1	Swage	800	363
9.63	244.6	Swage	815	370
8.63	219.2	Swage	830	377
7.63	193.8	Swage	840	382
7.0	177.8	Swage	850	386
6.63	168.4	Swage	860	391
5.5	139.7	Swage	875	397

1. For details on radial force requirements for crimping or swaging contact Volant customer support at +1 780.784.7098
2. Common collet sizes shown, for any other collet sizes, profile or pipe diameters contact Volant customer support.
3. Components can be developed for configurations not shown.
4. Actual formed length depends on adequate stroke and load capacity.
5. Overall Length is shown for base tool equipped with the most common bell, part number 81230.

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