

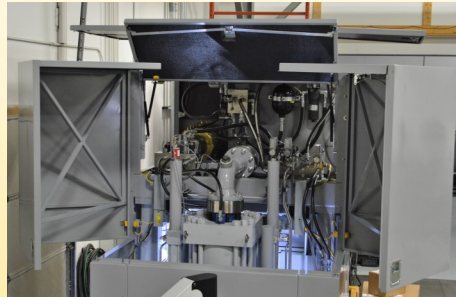
# INTERLAKEN TECHNOLOGY

“We’ll make it, or we’ll help you make it.”



## THF 0.5 Hydraulic Hydroforming System

The THF 0.5 system utilizes closed loop control of forces, motions, and pressures to produce high quality parts that cannot be manufactured by traditional processes. State-of-the-art control software allows users to develop intricate recipes that can be both time and event dependent. This ITC design optimizes tubes of 1/2” diameter or less and a thin wall of 0.02” or less.



### TOOLING...

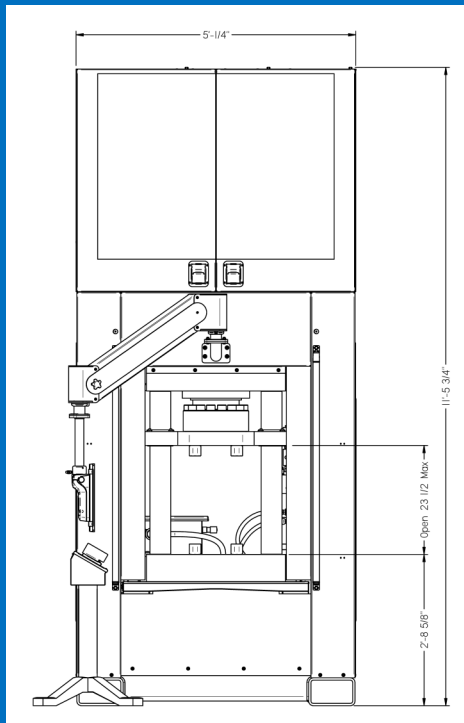
Tooling is designed to your specifications. Our die sets allow you to form tubes of various diameters. Exclusive die design, the control and data acquisition capabilities of the press, and the use of various pressures and end feeds will lead to a clear picture of material behavior.



The system is comprised of five sub-systems:

- A multi-axis servo-controlled hydraulic press with single-acting clamp and mode switching during the process.
- Servo-controlled Hydroforming Feed Actuators that are fully integrated within the tooling.
- A Servo-controlled Pressure Intensifier with pressure control valves. A variety of pressure and flow options are available.
- Interlaken designed tooling with easily changeable die inserts for differing cavity shapes that can be run with or without end feed.
- A B&R PC/Controller with 6th generation Intel i7 processor.

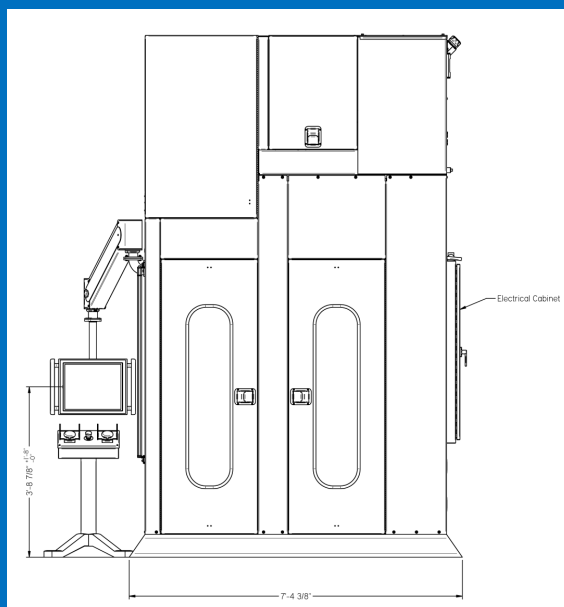
**Hydroformer - THF 0.5**



## Advantages of the Interlaken System...

- Tube Hydroforming reduces weight, reduces component part count, lowers assembly costs, and increases strength and stability
- Industrial PC based system
- Built in Ethernet/Internet connectivity capability
- High rate data acquisition
- Real time graphical interface
- Mode switching from stroke to pressure feedback for control
- Complete independent control of clamp, feeds, and pressure
- Highly repeatable process to maintain tight tolerances

SPECIFICATIONS	THF 0.5
Clamp Force	2255kN/230 Tons
Clamp Stroke	355mm/14 in.
Max Opening	597mm/23.5 in.
Clamp Control Modes	Position & Force
Forming Pressure	Max 551MPa/90,000psi
Minimum Digital Display for Stroke	0.01mm / 0.001 in.
Minimum Digital Display for Force	0.01kN / 0.001 tons
Power	35A, 460V, 3 phase, 60Hz
Cooling Water	5gpm max P @ 80°F
Emulsion Reservoir	13 gallons
HPS Oil Reservoir	110 gallons
Weight	13,500 lbs.
Press Footprint	5'W x 7'4"D x 11'6" tall



## OPTIONS...

- Intensifier Pressures and Volumes
- Custom voltages/Hz
- Feed Actuator Tonnage and Stroke
- Metric or English display

## INTERLAKEN TECHNOLOGY COMPANY, LLC

8175 Century Boulevard  
Chaska, MN 55318 USA  
952.856.4210  
Email: [sales@interlaken.com](mailto:sales@interlaken.com)  
Web: [www.interlaken.com](http://www.interlaken.com)



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