Machiningfabtech

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Precision Engineering Solutions

Expert in CNC machining services, sheet metal fabrication, and tube bending services for diverse industries with ISO certification.

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The Overview for CNC tube bending service

Specifications	
Materials Used	**Steel**
	(A106, A500 Type 1-5, A513 Type 1-5, A53, ROPS, HREW)
	Aluminum:
	(B210, 1100, 2024, 3003, 5052, 6061, 6063)
	Stainless Steel:
	(A249, A269, 303, 304, 304 L, 309, 310, 316, 316 L, 317L, 410, 416)
Tube Size	Bend
	Round Tubing
	Up to 8 5/8 inch diameter
	Square Tubing
	Up to 8 inch diameter
	Fabrication
	3/8 to 10 inches Diameter
	All bending and fabrication up to 27 feet length
Tolerance	+/- 0.005 inches
	Multi Axis CNC for close tolerances
Tube Shapes	Round
	Square
	Rectangular
	Oval
Production Runs	From prototyping to high volume production
Designing Assistance	Some basic ideas that can help in reducing the overall cost of a part by designing the part to be manufacturing friendly are provided below. For a more in depth analysis send us your drawings, or call one of our engineers.
	Tube Bending Considerations:
	CLR- Center Line Radius: Typical CLR is 3x the OD of the tube without mandrels. It is possible to bend on a 1 or 2xD bend, but not without more complex tooling. Tooling costs also increase when comparing a plug mandrel to 3-ball mandrel & wiper die. The tighter the radius, the more tooling required and the more expensive the part.
	Use the same CLR for all bends unless prohibited by design restraints.
	Straight between bends: Allow 3x the OD of straight for clamping between bends and from the edge of the tube. This reduces the overall cost of part by reducing additional trim operations and increasing the bend rate. Bends closer than 3xD require compound tooling increasing tooling cost and reducing bend rates.
Quality Process and Certifications	ISO 9001:2015
	AWS D1.1, D1.2 & D1.3 Welding
	SGS
	Statistical Process Control (SPC)
Preferred Drawing File Formats	SolidWorks Files, Part, Assembly, Drawing, DXF, DWG, Adobe Photoshop Files, Adobe Illustrator Files, Template, Parasolid, IGES, STEP AP203/214, ACIS, VDAFS, VRML, STL, Catia Graphics, ProE Part, ProE Assembly, UGII, Inventor Part, Inventor Assembly, Solid Edge Part, Solid Edge Assembly, CADKEY, IDF, Rhino Files
Secondary Services	Swaging / Flaring
	Coping
	Beading
	Drilling
	Flattening
	Flaring
	Machining
	Milling
	Notching
	Piercing
	Punching
	Slotting
	Swaging
	Threading
	PEM, Rivnut and Weldnut attachments
	Flow Drilling and tapping
Industries Served	At Bassett, we take on all jobs that fit our capabilities, for any industry. Below are examples of industries we have served in the past. We have created true turnkey components, weldments and assemblies for, but not limited to the following industries:
	Agricultural, Alternative Energy, Appliance, Architectural, Automotive, Computers, Construction, Defense, Distribution, Electronic, Entertainment, Fabrication, Furniture, Hardware, Health and Fitness, Heating and AC, Heavy Equipment, Lawn and Garden, Material Handling, Nuclear, Petroleum and Mining, Race Car & Stock Car, Refrigeration, Retail & Display, Solar Energy, Wind Energy