

**“UNPARALLELED PERFORMANCE AND SAFETY UNDER PRESSURE!”**<sup>®</sup>



SelectForm<sup>®</sup>  
**Model 400 HPU**  
Hydraulic Power Unit

- Pressures from 0 up to 3,000 psi (207 bar)
- Power source for tube end forming tools
- Continuous duty cycle
- Cycle times as fast as 2 seconds
- Portable system mounted on casters
- Manufactured to customer specifications

**DESCRIPTION**

The SelectForm<sup>®</sup> Model 400 Hydraulic Power Unit is designed specifically to meet the needs of Airmo End Forming Tooling. This power unit is equipped with valves and circuitry to reliably operate hand-held and modular end forming tools. The standard Model 400 Hydraulic Power Unit is supplied with an integral oil to air heat exchanger for cooling the hydraulic fluid, and provides for a continuous duty cycle.

The Airmo SelectForm<sup>®</sup> hand-held or modular tooling can produce the end forms shown below. Tools can be mounted to the top of the hydraulic power unit using optional stand and clamps.

**COMMON END FORMS**



**OPERATION**

The SelectForm<sup>®</sup> Model 400 Hydraulic Power Unit when used with Airmo tooling is easy to operate. Simply insert the tube into the tool and actuate the electronically operated foot switch. The system cycles automatically, producing a finished form in 2 to 5 seconds. End forming tools can be quickly changed over using quick disconnect couplings.

**APPLICATION**

The SelectForm<sup>®</sup> Model 400 Hydraulic Power Unit can be operated as a stand alone unit or in-line with other processes.

End forming tools are used for manufacturing processes in a variety of industries, including:

- Aerospace/aircraft
- On/off road mobile vehicles
- Boiler manufacturers
- Outdoor power equipment
- Heat exchanger/radiator
- Plumbing fittings
- Military/defense
- Sports equipment
- Metal furniture
- Tube and pipe mills
- Nuclear/hydro-electric
- Boats/water craft

**SYSTEM CONFIGURATION**

- Machine Size: 25 in. x 17 in. x 35 in.  
(635 mm x 432 mm x 889 mm)
- Maximum Pressure: 3,000 psi (207 bar)
- Hydraulic Fluid: 10 US gallon (38 liters)
- Reservoir:
- Maximum Oil Flow: .66 gpm (2.5 lpm)
- Valves: 24 Vdc for safety
- Electrical: Tailored to electrical service used
- Options: Auxiliary top plate to mount clamps for holding larger tools

**OPERATING CONDITIONS**

- Temperature: 32° F to 120° F (0° C to 49° C)
- Cycle Time: 2 seconds for small end forming tools
- Noise Level: System runs quietly

**MAXIMUM PRESSURE**  
**3,000 psi**  
**207 bar**

SelectForm®  
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Hydraulic Power Unit

## BASIC SYSTEM

The Model 400 Hydraulic Power Unit basic system is configured as follows:

- **Electric motor**, 1.5 horsepower, tailored to customers electric service
- **Gear pump**, with pressure output of 3,000 psi (207 bar)
- **Electrical enclosure**, contains controls and circuitry to run system
- **Hydraulic fluid reservoir**, 10 US gallons (38 liters)
- **Reservoir oil level and temperature indicator**
- **Heat exchanger**, to maintain oil at safe temperature
- **Pressure gauge**, 3,000 psi (207 bar)
- **Pressure relief valves**, adjustable
- **Directional control valve**
- **Digital pressure switch & dwell timer**, for setting hold time duration and activating tool retraction
- **Integral filter with indicator**
- **Casters**, for easy portability
- **Foot pedal**, controls pressure cycle
- **Hydraulic hoses with quick disconnect couplings**

## POPULAR OPTIONS

Popular options available for the Model 400 Hydraulic Power Unit include:

- **Slide mechanism**, to initiate forming cycle by inserting tube into tool
- **Auxiliary stand with top plate**, provides work surface above power unit; convenient for mounting end forming tools
- **Tool clamp**, secures tool on top plate, auxiliary stand, or another work surface

## CUSTOM-DESIGNED OPTIONS

The Model 400 End Forming System can be custom-built with features such as:

- **PLC touch screen**, provides visual display for accurate, repeatable performance with no pressure loss
- **Optical touch switch**, uses LED indicators to sense finger placement to activate system pressure cycle
- **Hydraulic manifold**, ability to add multiple hydraulic hoses for mounting handle-held end forming tools



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