

**Model 1447-6DT foot operated****SHEET METAL SHRINKING AND STRETCHING MACHINE**

Originally developed for use in the aircraft industry on aluminum parts, the 1447-6DT is now widely used by the entire metal working industry because of its ability to:

- Remove wrinkles and fit sections normally formed in presses or drop hammers.
- Form rolled, extruded and formed angles and tees.
- Produce double curvatures from flat sheets.

The machine performs efficiently on most metals.

The Model 1447-6DT combines shrinking and stretching capabilities into one unit and provides the following advantages:

- Eliminates time consuming hand de-wrinkling and hammering operations.
- Eliminates expensive form blocks and special anvils.
- Increases work output and reduces operator fatigue.
- Eliminates use of special dies or presses in forming various shapes and contours on angles, tees and other sections.
- Cold-worked material results in higher material strengths.

The Model 1447-6DT, ideal for short production runs and prototype work, requires little floor space in assembly or manufacturing areas. For longer production runs, the TCE-ERCO Model 312BDT power shrinker/stretcher is more effective. A Model 1447-12DT (12" throat) foot-operated machine is also available.

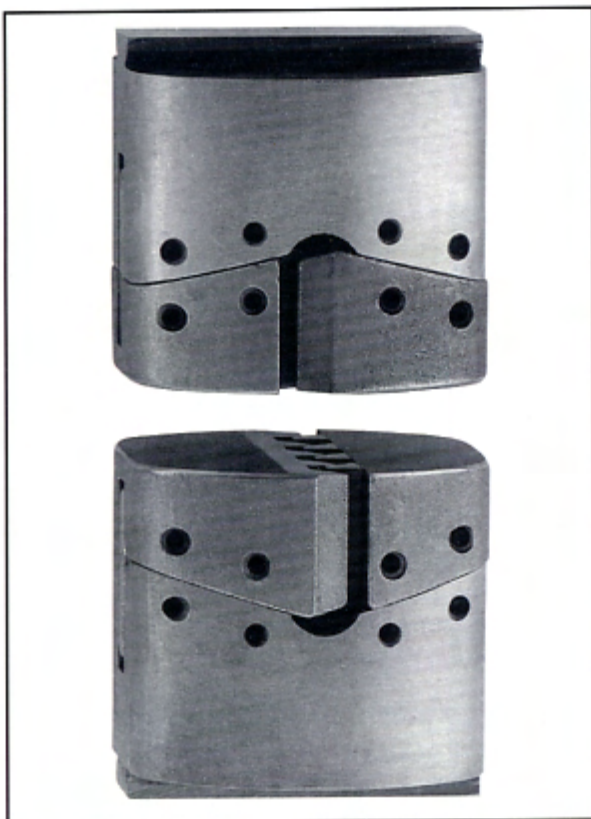
**CONSTRUCTION**

The cast "C" frame foot-operated shrinker and stretcher has a 6" throat depth and is mounted on a welded steel floor pedestal. The pendulum motion of the foot pedal and the cam mechanism inside the "C" frame, which is balanced by adjustable weights on the treadle rod, controls the stroke of the ram.

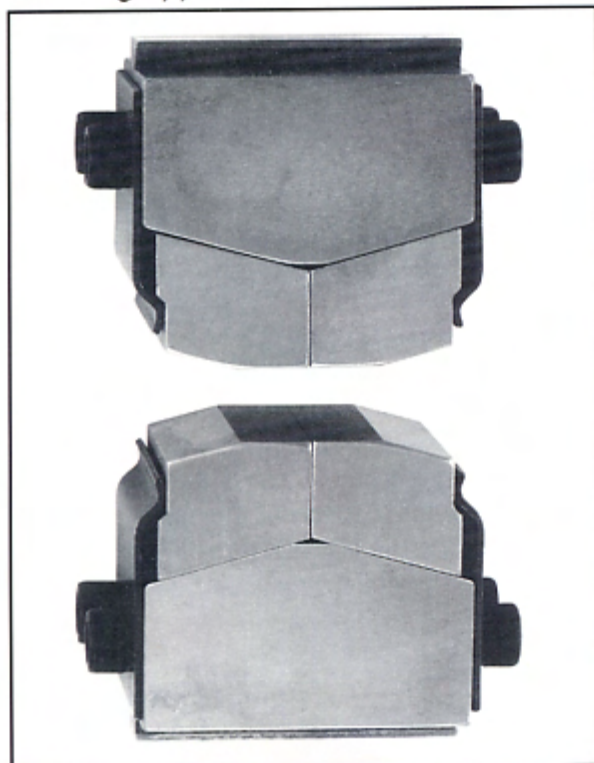
**SPECIFICATIONS****Model 1447-6DT**

Capacity maximum metal	
Thickness of 70,000 PSI tensile .....	5/64 in.
Depth of throat .....	6 in.
Distance from floor to	
working surface jaws .....	43 1/2 in.
Stroke of ram .....	1/4 in.
Overall height .....	50 in.
Overall length .....	23 in.
Overall width .....	16 in.
Net weight .....	330 lbs.
Shipping weight, crated .....	430 lbs.
Shipping weight, export boxed .....	510 lbs.
Box dimensions .....	20" W x 55" H x 29" L





**Standard shrinking jaws:** This is the most widely used assembly. Other designs are available for specialized shrinking applications.



**Standard stretching jaws:** This assembly is suitable for the vast majority of stretching applications.

## OPERATION

Operation of the Model 1447-6DT foot operated shrinker and stretcher is very simple. The operator needs only a few minutes to acquire the knack of feeding the material through the jaws to obtain the desired shapes. The shaping is accomplished swiftly with a minimum number of strokes of the ram. *No jaw adjustment is necessary for different thicknesses of metal.*

## SHRINKING AND STRETCHING JAW ASSEMBLIES

The Model 1447-6DT can be equipped with shrinking jaw and/or stretching jaw assemblies. They are easily interchangeable by means of quick change dovetail slide-type anvils. The stippled surfaces of the jaws are parallel, and grip the work at two points. The action of the jaws then shrinks (or stretches) the material between these two points. For removing wrinkles from the flanges of a channel section, extended jaws are available. Jaw assemblies for special shrinking/stretching applications are available or can be designed and manufactured upon request.

The stippled working surfaces of the jaws grip the work piece and impart a finish to the material surface. A standard No. 2 stippled jaw surface is used for a wide variety of applications. There are three finer grades of jaw stipple available: Nos. 1, 0, and 00. For work with harder alloy metals, a more coarse No. 3 stippled jaw surface may be appropriate. When stippling on the jaws is worn smooth, they can be reground and restippled in any grade for a nominal charge.

## THE TCE-ERCO LINE OF MACHINE TOOLS

The TCE-ERCO line of specialized and general purpose machine tools for the metalworking industry also includes:

- Power operated shrinkers and stretchers.
- Automatic portable and floor mounted punch-riveters.
- Forming and flanging machines.
- Work positioning spotlights.

MADE IN THE U.S.A.



EXPORTED WORLDWIDE