



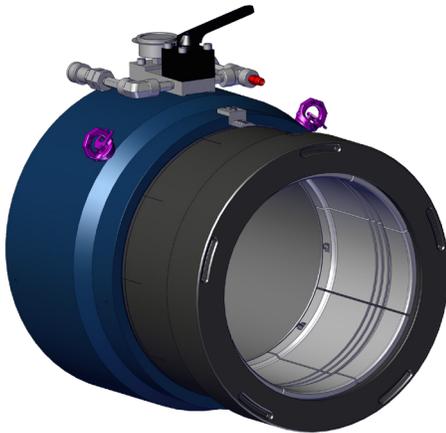
## RTF™ Radial Tubular Forming Tool

Volant RTF™ tools are designed for both crimping and swaging operations. These tools use a hydraulically 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 tool's simple architecture makes it 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.

The RTF-13.38XS model is configured with an alternate piston, end flange, and flange nut in order to increase the axial stroke and pressure capacity as required to crimp and swage larger tubular sizes.

**RTF-13.38XS**  
Tool configured for  
13.63 in. crimping



**RTF-13.38**  
Tool configured for  
13.63 in. swaging



Base Tool Characteristics		RTF-13.38	RTF-13.38XS
Housing OD	in. (mm)	20.9 (530.9)	20.9 (530.9)
Overall Length <sup>1,2</sup>	in. (mm)	19–22 (482.6–558.8)	19–22 (482.6–558.8)
Base Tool Weight	lb. (kg)	553 (251)	553 (251)
Diametrical Stroke	in. (mm)	0.414 (10.5)	0.535 (13.5)
Maximum Radial Force <sup>3</sup>	kip (kN)	1,700 (7,562)	2,500 (11,121)
Piston Bore Diameter	in. (mm)	13.8 (350.5)	13.8 (350.5)
Maximum Pressure Capacity	psi (MPa)	5,000 (34.4)	7,500 (51.7)
Base Tool P/N		82089	106247



### Crimping: Collet Size Specific Characteristics<sup>4</sup>

Nominal Collet Size <sup>5</sup>		Collet Style	Collet P/N	Bell P/N	Bell Adaptor P/N	Approximate Dressed Tool Weight	
in.	mm					lb.	kg
13.63 <sup>6</sup>	346.2	Crimp	105642	105408	N/A	875	397
13.38	339.9	Crimp	82037	82038 / 105408	N/A	867	393
9.88	250.9	Crimp	82078	81230	81231	852	386
9.63	244.6	Crimp	80062	81230	81231	838	380
8.63	219.2	Crimp	80186	81230	81231	833	378
7.63	193.8	Crimp	80070	81230	81231	904	410
7.0	177.8	Crimp	80063	81230	81231	876	397

1. Overall Length is shown for base tool equipped with the most common bell, P/N 81230.
2. Actual formed length depends on adequate stroke and load capacity.
3. For details on radial force requirements for crimping or swaging contact Volant customer support at +1 780.784.7098.
4. Common collet sizes shown. For any other collet sizes, profiles, or pipe diameters contact Volant customer support at +1 780.784.7098.
5. Components can be developed for configurations not shown.
6. To crimp with 13.63 in. collet size a higher pressure capacity RTF, the RTF-13.38XS, is required. Contact Volant sales for more information at +1 780.784.7099.

### Swaging: Custom Applications

For swaging applications, contact Volant customer support at +1 780.784.7098 to determine the best custom configuration of the RTF tool for your needs.

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