

# Fabrication

*Leggett & Platt*  
INCORPORATED

Tubular Division

*“Supplying steel tubing solutions for your diversified product lines”*

## FABRICATION SERVICES:

- Leggett & Platt Tubing offers a full service steel tubing Fabrication Dept. providing our customers with **cost effective, quality parts and on time delivery.**
- We are your one stop tube source for both straight and fabricated steel tubing.
- We can help you determine the most cost effective design and manufacturing process for your parts.
- Utilize our 35+ years of manufacturing experience, our quality system and diversified fabrication equipment.

### ● **Bending**

- CNC Rotary Draw Tube Benders
  - Makes simple to complex tubes one precise bend at a time
  - Provides high flexibility, accuracy and repeatability
  - Used for multiple radius, bend on bends and tight tolerance applications
- Twin Head Bender (Compression Bending)
  - Two bends at the same time - faster cycle time than CNC
  - For parts that can be designed for two bends at the same time
- Press Bending
  - One to four bends at a time – quickest and least expensive bending in some limited applications



### ● **Piercing & Forming**

- Pierce holes in tubing leaving clean or dimpled edges (most cost effective solution)
  - Holes in one wall or thru both walls
- Form tubes from simple to more complex shapes
  - Flatten – from partial to full flat (wall to wall)
  - Bead – upset the tube to make beads anywhere in the tube
  - Complex shapes – put unique and complex details anywhere in the tube

- Notching – notch ends to make any shape required
- Coping – ends designed to match up to any contour for improved welding or joining of parts

### ● End Forming

- Reduce or expand ends – make ends of the tube smaller or larger
- Shape ends – for example, make round tube square, oval or other shape at the ends
- Flare – roll ends of the material
- Other – there are many other types of end forming possible – let us see your application



### ● Miter Cuts

- CNC Miter Saw – servo driven technology used for more precise cuts
  - Ends can be sheared at many angles to meet customer's exact specifications

### ● Welding

- Resistance welding (faster process time) & robotic MIG welding available depending on customer specifications

## AUTOMATION:

- Leggett & Platt Tubing has invested in several fully automated tube forming cells in order to give our customers the best quality and lowest cost possible.
- We have been able to automate many of the fabrication processes that we currently have and we continue to look for opportunities to expand.
- State of the art equipment insures exacting tolerances for our customer's high performance operations.
- Flexibility enables us to run both high and low volume parts cost effectively.



### ● Automated Tube Bending Cells

- Tubes are automatically loaded by a tube bundle loader (with seam finder and auto length checking) to the CNC Bender
- A robot unloads the CNC Bender and delivers parts to the camera inspection station
- Camera measures critical dimensions – good parts are then moved to the press by the robot and bad parts are rejected automatically
- Press puts in formed details using custom tooling - part is ejected to final check process

- A pressure check fixture checks for holes in the weld – good parts are moved to the shipping container and non-conforming parts are automatically rejected

### **Automated End Forming Cell**

- Tubes are automatically oriented to the robot loader
- The robot loader puts the tube in the forming station
- The finished part is ejected to the final conveyor

### **Automated Piercing and Forming Cell**

- Tubes are automatically removed from the container and oriented to the robot (with seam finder and auto length checking)
- The robot picks up the tube and places it in the custom dies to form or pierce
- The finished part is removed with the robot to the final pack line

### **Robotic Weld Cell**

- MIG welding with a Motoman Arc 2 Welder

### **Custom Designed Fabrication Cells**

- We can custom design an automated fabrication cell to meet specific customer requirements - Leggett & Platt is a FORTUNE 500 company willing to invest in new equipment, automation and technology



## **Manufacturing Support Services:**

- Leggett & Platt Tubing offers additional value added manufacturing support services to meet our customers' evolving needs.
- We can come into your facility to collaborate on manufacturing solutions and opportunities.

### **Quality Checks**

- We can check any critical dimension as defined by the customer
  - Custom designed Poke Yoke devices, gauges and check fixtures
  - Electronic measuring and inspection with cameras and sensors
  - Pressure check fixtures
- We have an accredited in-house Quality Lab
  - ISO 9001:2000 Registered
  - ISO/IEC 17025 Accredited Lab



## Engineering & Design Expertise

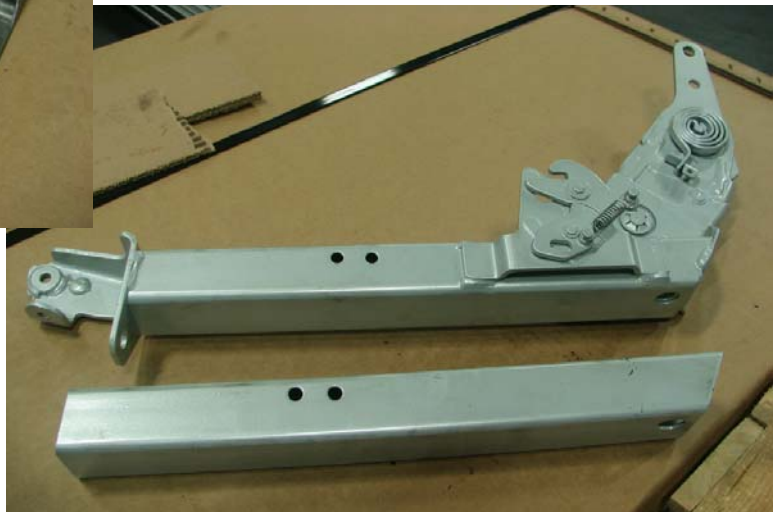
- Let our experienced engineering staff assist with your product design and launch efforts
  - We design for best cost, quality and manufacturability
  - With can assist you with problem solving
- We use industry experts to custom build tooling to your part specifications at competitive pricing

## Cost Savings Opportunities

- Cost leveraging available when straight tube is produced in the same facility as the fabricated part
- We have low manufacturing overhead costs
- Open up floor space in your facility by outsourcing your fabrication jobs to us – let your parts come to you JIT for your final operation and reduce your work-in-process
- Continuous improvement techniques including Six Sigma, 6S and Lean Manufacturing are used throughout the company to improve quality and reduce costs



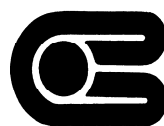
- We can assemble our tubing and other component parts to make simple assemblies



**Contact us for more information on how Leggett & Platt Tubing can meet your steel tubing fabrication needs.**



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