Single Point vs. Dual Point Coilers
Single Point vs. Dual Point Coilers

Since the introduction of the first automatic spring coiler, there has been an unending debate as to which type of coiler a single point (generally used in North America) and a dual point (generally used in Europe) is better for making springs.

- Single Coiling Point Machine
Single Point vs. Dual Point Coilers

- Dual Point Coiling Machine

FROM THE POINT OF STRESSES FOR FORMING AND RESIDUAL STRESSES POST FORMING

THERE IS NO DIFFERENCE
The Metallurgy:

Stress

Forming Occurs Plastic Deformation

AS COILED
The Metallurgy:

Strain

After Stress Relieving

Residual Stresses

After Forming

AFTER STRESS RELIEF
The Metallurgy:

BCT under stress from residual stresses $\delta$
After Coiling, Before Stress Relieving

BCT under stress from residual stresses $\delta$
After Stress Relieving
FROM THE POINT OF STRESSES FOR FORMING AND RESIDUAL STRESSES POST FORMING

THERE IS NO DIFFERENCE

What makes them DIFFERENT:

- The Amount of Initial Tension
- Control of Forming
- Set-Up methods
- Tooling
- Problem Avoidance
Reminders

Wednesday, October 3

Exhibit Hall Open: 10:00AM – 5:00PM

NESMA Networking Event: 5:30 – 8:30PM offsite