



TECHNICAL SPECIFICATION MODEL 301SP TUBE FACING AND SQUARING TOOL

The Model 301SP Tube Squaring Tool is designed specifically to prepare tubes for autogenous welding. The 301SP will face (square) .125" (3.2mm) to 1.125" (28.6mm) outside diameter tubing with a wall thickness up to .125" (3.2mm). The 301SP uses an OD saddle clamping system for holding and rounding the tube. The 301SP accepts its own torque through the saddle clamping system. The standard saddle clamping system requires a straight length of tube .60" (15.2mm) long. The Short Perch saddle clamping system requires a straight length of tube .190" (4.8mm) long. Speed control is provided by a variable speed electric or pneumatic drive motor. Feed is provided by a cam actuated feed handle at right angles to the cutter head.

The Model 301SP System comes complete with:

- | | |
|---------------------------|-------|
| • Model 301SP Subassembly | 1 ea. |
| • Integral Guard | 1 ea. |
| • Electric Motor Assembly | 1 ea. |
| • Wrench Kit | 1 ea. |
| • Carrying Case | 1 ea. |
| • Operator's Manual | 1 ea. |

Design and Operating Features

- The 301SP accepts its own torque through the saddle clamping system.
- The Cutting Head accepts Squaring Tool Bits.
- The Model 301SP is lightweight and easy to handle.
- All tools needed for operation are provided with the system.

Accessories

- 110 VAC (Metabo) Motor Assembly
- 110 VAC (Milwaukee) Motor Assembly
- 220 VAC (Bosch) Motor Assembly
- 14.4 VDC Cordless Motor Assembly
- Pneumatic Motor Assembly
- Air Caddy, FRL
- Bench Stand Assembly
- Electric Foot Pedal

- Variable Speed Transformer Control (20 VAC to 140 VAC Output)

Specifications

Pipe Cutting Capacities

Basic Pipe Sizes

- 1/8" All schedules
- 1/4" All schedules
- 3/8" All schedules
- 1/2" Schedules 5 through 40
- 3/4" Schedules 5 through 40

Basic Tube Sizes

.125" (3.2mm) through 1.125" (28.6mm) with wall thickness up to .125" (3.2mm)

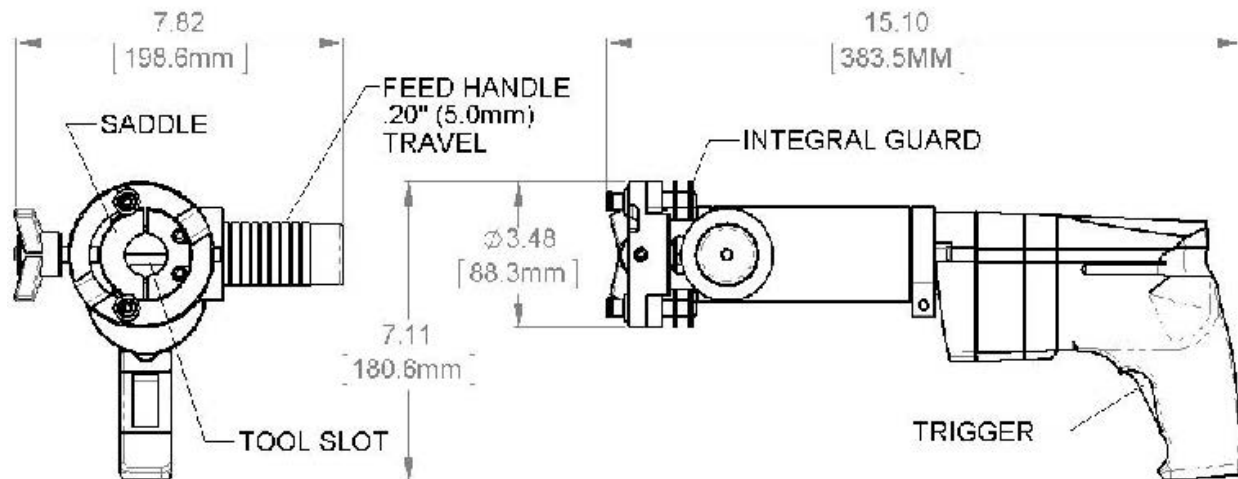
Material Cutting Capabilities

Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel alloys and aluminum without limitations except size and wall thickness as specified.

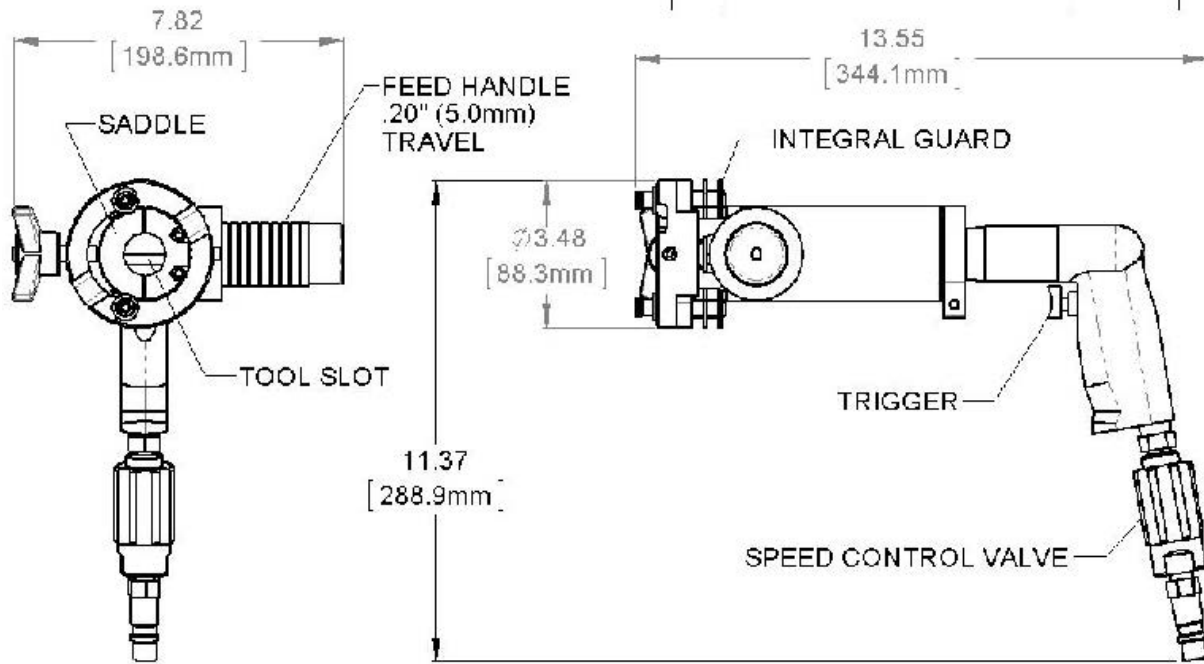
Inconel and some other high temperature alloys may require special procedures as a function of wall thickness and type of end preparation. Contact Tri Tools Engineering Department for details.

Clearance and Dimensions

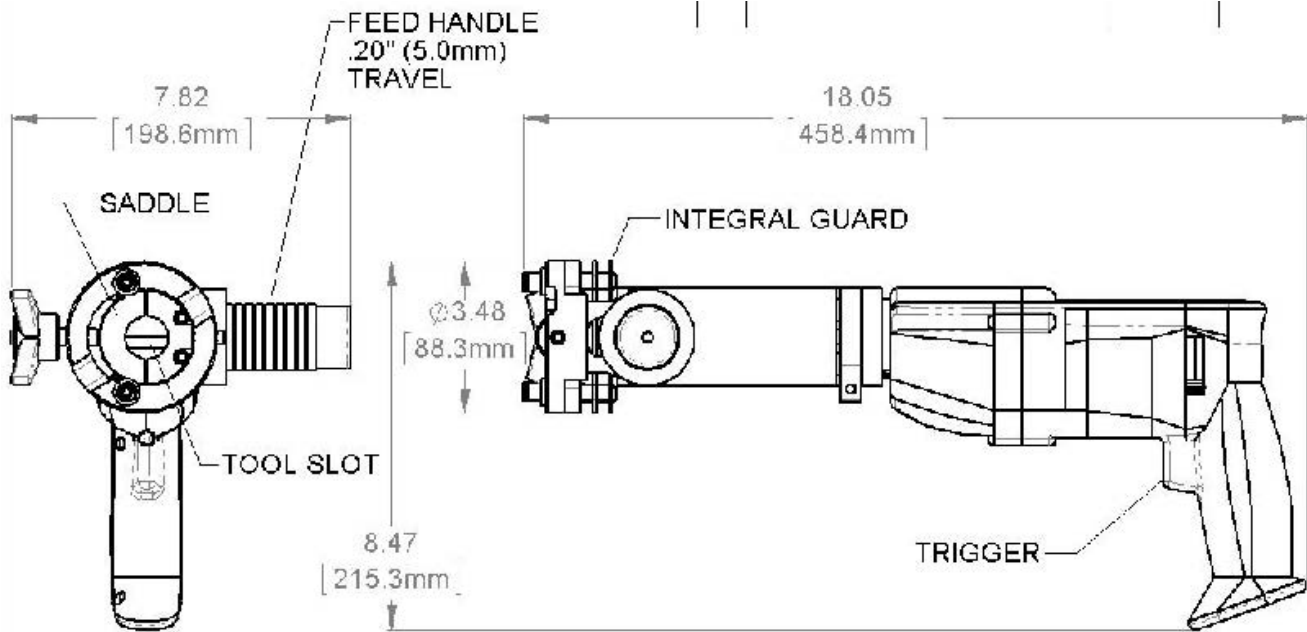
Reference Drawing No. 77-1428 (MODEL 301SP MILWAUKEE)



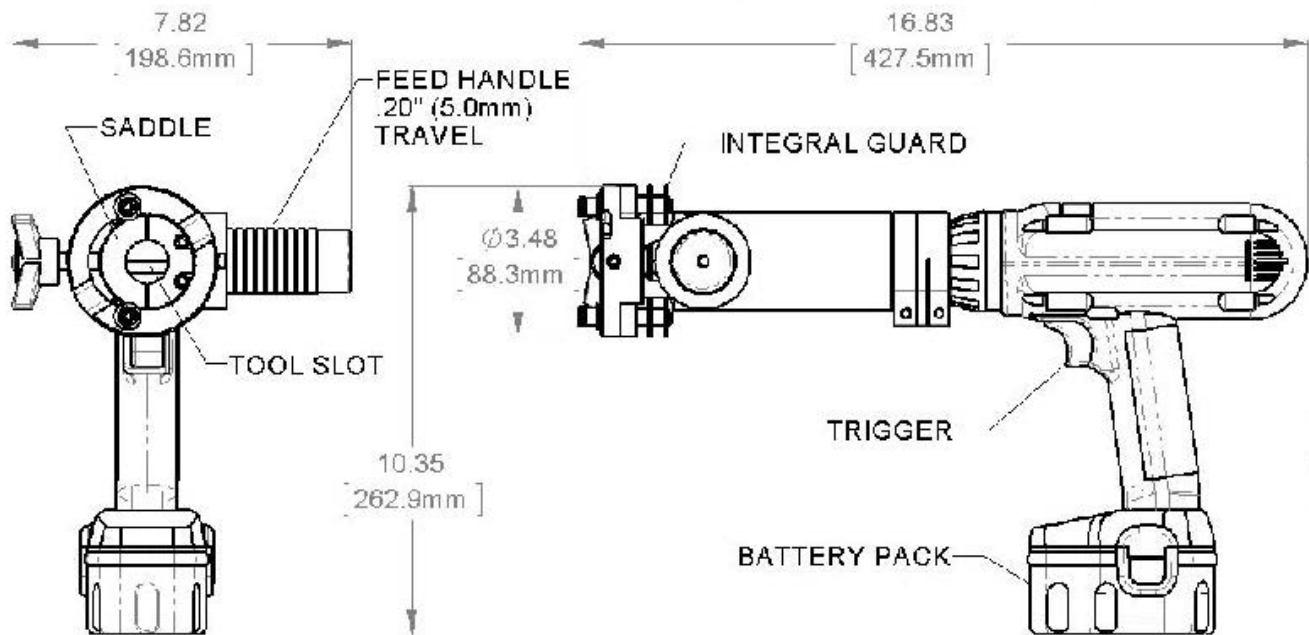
Reference Drawing No. 77-1568 (MODEL 301SP AIR)



Reference Drawing No. 77-1569 (MODEL 301SP METABO)



Reference Drawing No. 77-1570 (MODEL 301SP CORDLESS 14.4V)



Weight

8.5 lbs. (3.9 kg)

Drive Motor Options

- 110VAC 50/60 Hz 5.5 Amp Corded Motor Assembly
 - 220VAC 50/60 Hz 5.2 Amp Corded Motor Assembly
 - 14.4VDC Cordless Motor Assembly with 110VAC Charger
 - 14.4VDC Cordless Motor Assembly with 220VAC Charger
 - 22 CFM @ 90 PSI Air Motor Assembly
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Speed Control

On/Off Trigger control with Variable Speed.

Mounting

Manually actuated saddle clamping system.

Feed

Manual – A cam actuated feed handle is mounted at right angle to the cutting head and provides .200" (5.1mm) of travel.

Note To The Customer

Spare Parts and Standard Tool Bits are available from stock. Engineering design services for custom tool bits and special function modifications are available from the factory.

All Tri Tool and allied equipment products are subject to design improvements and specification changes at any time with no obligation to units already sold.

Warranty (limited): Parts and equipment are warranted against defects in material and workmanship for a period of one (1) year from date of purchase. Full details supplied on request and/or with the tools.



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