



TRI TOOL INC.

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TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL 304 TUBE SQUARING MACHINE
APRIL 6, 2011

Model 304 Tube Squaring Machine

The Model 304 Tube Squaring Machine is a lightweight, portable machine designed for facing and squaring .25" (6.35 mm) to 4.50" (114.30 mm) outside diameter tubing up to .25" (6.35 mm) wall thickness.

The Model 304 System comes complete with:

- | | |
|--------------------------|-------|
| ▪ Model 304 Sub Assembly | 1 ea. |
| ▪ Drive Motor Assembly | 1 ea. |
| ▪ Wrench Kit | 1 ea. |
| ▪ Carrying Case | 1 ea. |
| ▪ Operator's manual | 1 ea. |

Design and Operating Features

1. The Model 304 is available with an integral, dual range, variable speed 110VAC or 220VAC electric drive motor or a pneumatic drive motor.
2. The Model 304 features quick changing Saddle Sets (no tools required) and a .001" (.025 mm) graduated feed dial.
3. The precision inside diameter saddles hold the tubing round to accurately square and face the tubing with minimum burr.
4. The Model 304 accepts its torque through the Saddle Clamping System.
5. The cutting head accepts up to three (3) tool bits for a combination of squaring, beveling, counterboring or facing operations simultaneously.
6. The Saddle Sets are made from stainless steel for durability and to avoid carbon contamination of high purity tubing.
7. All required wrenches for operation are supplied with the machine.
8. The Model 304 may be removed from the stand for use as a portable machine.

Specifications

9. Reference Envelope Drawing No.: 77-1605
10. Weight (machine with electric motor)
 - A. 18.25lbs (8.28 kg)
11. Clearance and Dimensions (See envelope Drawing No. 77-1605)
12. Cutting Capacities
 - A. Basic Pipe Sizes
 - i. 1/8" through 3/8" pipe
 - a. All schedules
 - ii. 1/2" through 1 1/4" pipe
 - a. Schedule 5 through schedule 160
 - iii. 1 1/2" through 2" pipe
 - a. Schedule 5 through schedule 80
 - iv. 1 1/2" through 4" pipe
 - a. Schedule 5 through schedule 40
 - B. Basic Tube Sizes
 - i. .250" (6.35 mm) to 4.50" (114.30 mm) OD
 - C. Wall Thickness Capacity
 - i. Basic Tubing with a maximum wall thickness of .250" (6.35 mm)
13. Material Cutting Capabilities
 - A. Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel and aluminum without limitations other than size and wall thickness as specified.
 - B. Inconel and some other high-temperature alloys may require special procedures as a function of wall thickness and type of end preparation. Contact TRI TOOL's Engineering Department for details.

14. Speeds

A. Speed Control

- i. Electric Drive
 - a. Dual range, variable speed.
- ii. Pneumatic Drive
 - a. On/Off trigger and twist type air flow control valve.

B. Electric Drive Motor Free Speed

- i. 900 RPM (Low)
- ii. 2800 RPM (High)

C. Cutting Head Speeds

- i. 75 RPM Max.

D. Functional Speed Range

- i. 0 to 70 RPM

15. Feeds

- A. Manual feed handle is mounted at rear of tool, providing .560" (14.2mm) of axial feed.

16. Mounting

- A. Manual saddle clamping system.

17. Drive System

- A. Variable Speed Electric Drive Motor.
- B. Variable Speed Pneumatic Drive Motor.

18. Power Requirements

- A. Electric Drive Motor
 - i. 115 VAC \pm 10%, 50/60 Hz, 9.6 Amp.
 - ii. 220 VAC \pm 10%, 50/60 Hz, 2.5 Amp.

- B. Pneumatic Drive Motor
 - i. 55 cfm at 90 psi (26 lt/sec at 621 kPa)

Accessories (Optional)

1. Electric Foot Pedal
2. Short Perch Saddle Sets
3. Tool Bits
4. Air Caddy, FRL
5. Collet Adapter Kit (for use with 400 Series Collets)

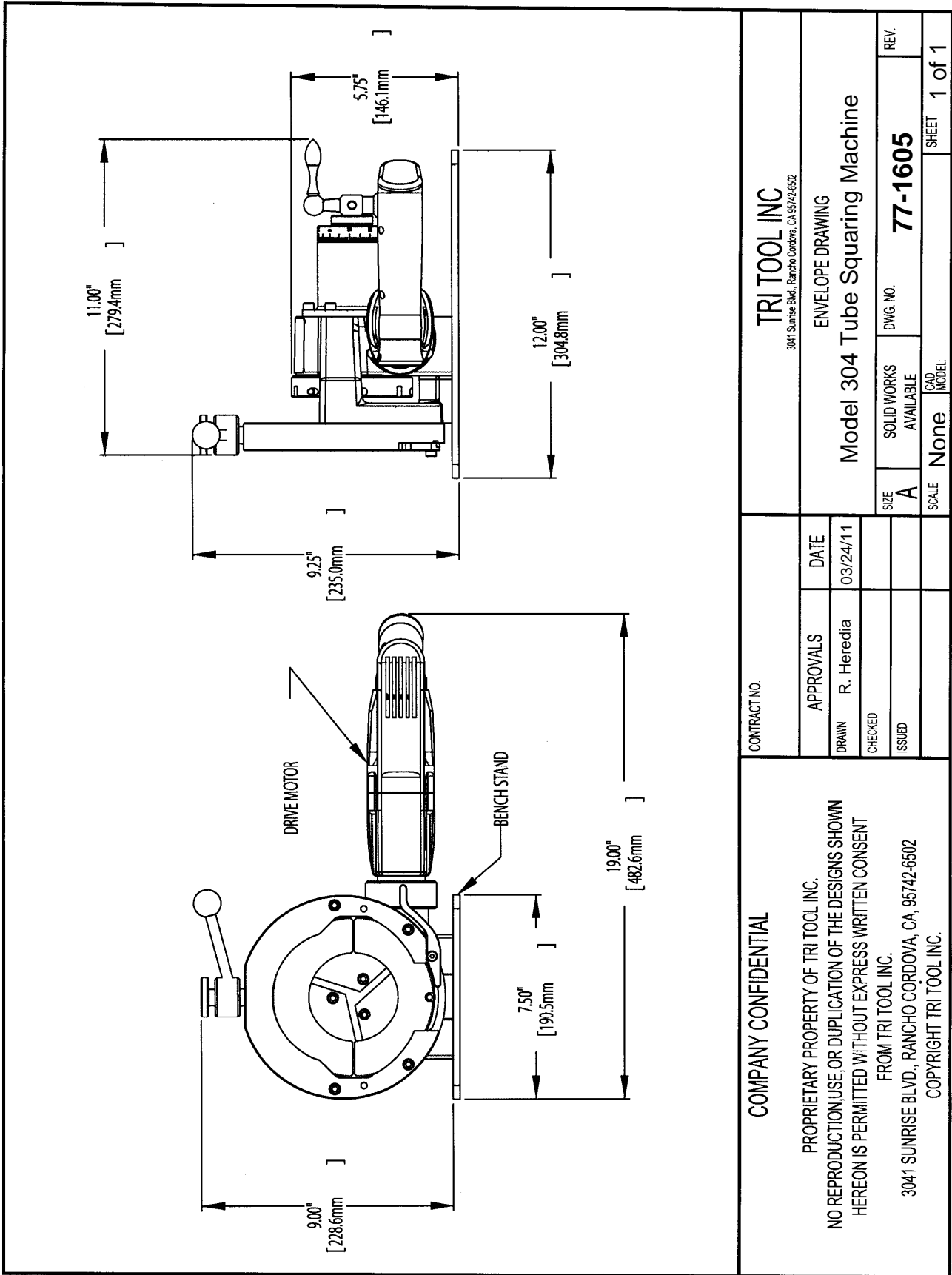
Note To The Customer

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 Inc. 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.

Filter, regulator and lubricator are required to protect the warranty on air powered tools.



<p>TRI TOOL INC 3041 Sunrise Blvd., Rancho Cordova, CA 95742-6502</p>		<p>ENVELOPE DRAWING</p>		<p>Model 304 Tube Squaring Machine</p>	<p>REV</p>
		<p>CONTRACT NO.</p>	<p>DATE</p>		
<p>APPROVALS</p>	<p>R. Heredia</p>	<p>03/24/11</p>	<p>A</p>	<p>77-1605</p>	<p>1 of 1</p>
<p>CHECKED</p>			<p>None</p>	<p>CAD MODEL</p>	<p>SHEET</p>
<p>ISSUED</p>			<p>SCALE</p>	<p>None</p>	<p>1 of 1</p>

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