



TECHNICAL SPECIFICATION MODEL 306 TUBE SQUARING MACHINE

The Model 306 Tube Squaring Machine is a lightweight, portable machine designed for facing and squaring 1.00" (25.4 mm) to 6.63" (168.3 mm) outside diameter tubing up to .25" (6.35mm) wall thickness. The model 306 is available with an integral, variable speed 110VAC or 220VAC electric drive motor. The Model 306 features quick change Saddle Sets (no tools required) and a .001" (.025 mm) graduated feed dial. The precision inside diameter saddles hold the tubing round to accurately square and face the tubing with minimum burr. The Machine accepts its own torque through the Saddle Clamping System. The cutting head allows installation up to three tool bits for squaring, beveling or special preps.

The Model 306 Tube Squaring Machine comes complete with:

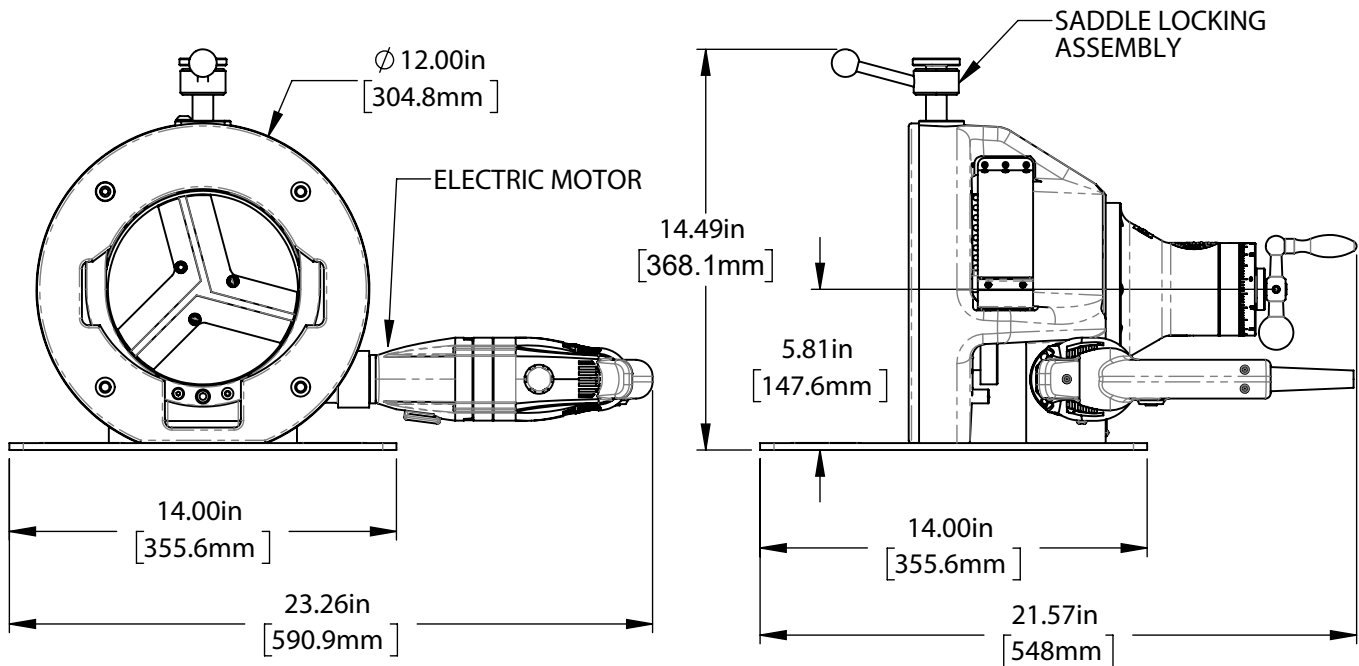
- | | |
|--------------------------|-------|
| • Model 306 Sub Assembly | 1 ea. |
| • Drive Motor Assembly | 1 ea. |
| • Wrench Kit | 1 ea. |
| • Operator's Manual | 1 ea. |

Design and Operating Features

- The Model 306 accepts its own torque through the Saddle Clamping System
- The cutting head accepts squaring bits or combinations of squaring, beveling, counterboring or facing tool bits
- Three tool slots allow counterboring, beveling and squaring operations simultaneously
- The Saddle Sets are made from aluminum
- All required wrenches for operation are supplied with the machine
- The Model 306 may be removed from the stand for use as a portable machine

Specifications

Reference Drawing No. 77-1863



Pipe Cutting Capacities

Basic Pipe Sizes

3/4" - 1 1/4" pipe

Schedules 5 through 160

1 1/2" - 2 1/2" pipe

Schedules 5 through 80

3" - 6" pipe

Schedules 5 through 40

Basic tube size

1.00" (25.4 mm) to 6.63" (168.3 mm) outside diameter with maximum wall thickness of .250" (6.350 mm).

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 in paragraph 2.
- Inconel and some other high temperature alloys may require special procedures as a function of wall thickness and type of end preparations. Contact Tri Tool's Engineering Department for details.

Drive System

Variable Speed Electric Drive Motor

Free Speed

0 – 3,000 RPM

Maximum Cutting Head Speed

77 RPM

Power Supply

Electric Drive Motor

110 VAC, 50/60 Hz, 9.6 A

220 VAC, 50/60 Hz, 5.7 A

Pneumatic Drive System

Available on request.

Mounting

Manual saddle clamping system.

Feed

Manual feed handle is mounted at rear of tool, providing 1.00" (25.4 mm) of axial feed.

Weight

70 lbs. (31.8 kg)

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.



www.tritool.com



[@tritooltechnologies](https://www.facebook.com/tritooltechnologies)



[@tritooltech](https://www.linkedin.com/company/tritooltech)



[@tritooltechnologies](https://twitter.com/tritooltechnologies)



3041 Sunrise Blvd,
Rancho Cordova,
CA 95742

+1-916-288-6100

+1-800-345-5015

Fax 916-288-6160