

TECHNICAL SPECIFICATION MODEL 602TSB LOW PROFILE CLAMSHELL

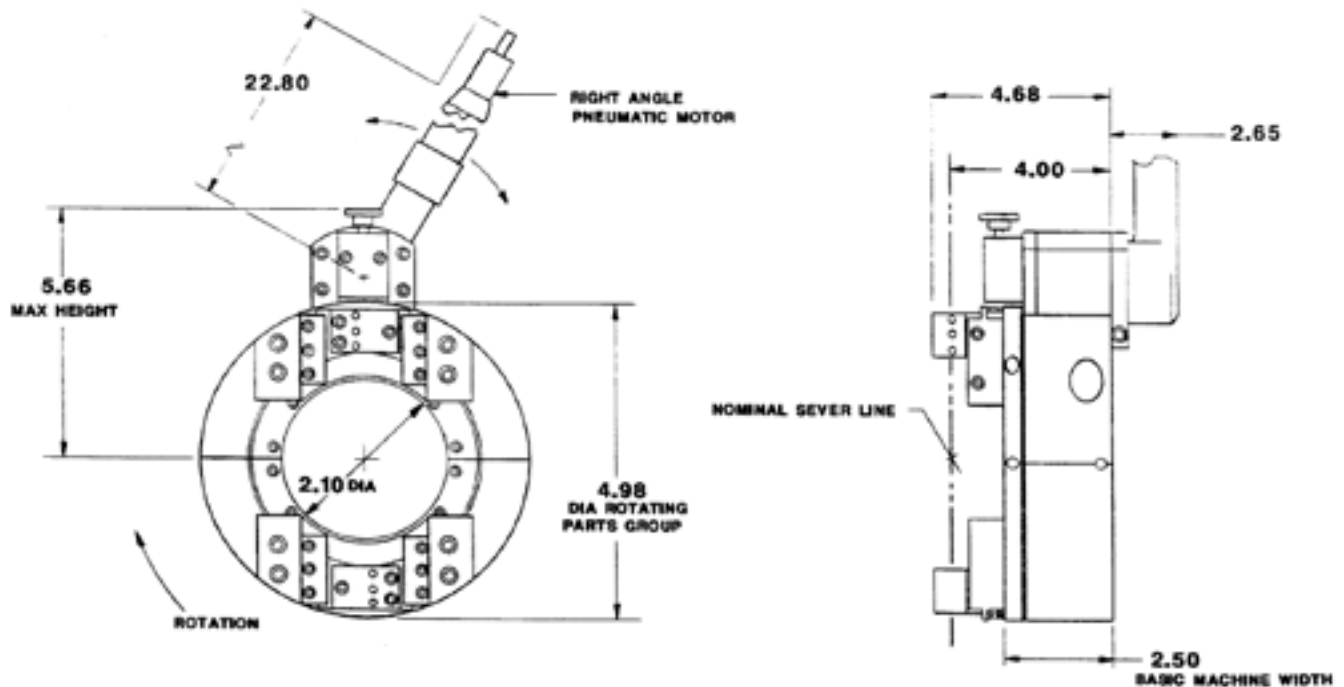
The 602TSB Low Profile Clamshell is a split-frame pipe lathe for severing and beveling in-line pipe and tube with a range of 1.50" (38.1mm) through 2.00" (50.8mm) O.D. with minimal radial and axial clearances. This tool requires 1.49" (37.8mm) of radial clearance over 2.00" (50.8mm) tube.

Design and Operating Features

- Easily adjustable precision bearing surfaces preload and stabilize the rotating head to provide long life, low maintenance, stability and precision.
- The Clamshell splits into two halves for mounting on closed loop systems. All parts are secured to the two halves to avoid loss of parts and provide maximum ease of handling.
- The machine may be equipped with self-centering mounting pads for quick, easy mounting or may be equipped with adjustable mounting pads for out-of-round pipe conditions.
- Dual tool modules with auto-feed sprockets and adjustable slide ways provide maximum maintainability, life and operator safety with minimum operator training.
- The auto-feed star sprockets provide .003" (.08mm) of radial feed per revolution for a controlled depth of cut.
- Drive gears and bearing surfaces are covered for operator safety and sealed to prevent cutting chip damage.
- Operator controls are away from the rotating headstock for safety.
- Modular design concepts provide quick, easy maintenance and maximum versatility in drive and tooling options.
- Detachable right angle air motor provides maximum handling ease and low axial clearance. Torque accepting mounting bracket allows the air motor to be rotated in various positions.

Specifications

Reference Envelope Drawing No. 77-0617



Weight

Basic machine	10.0 lbs. (4.54 kg)
Right angle drive	12.0 lbs. (5.44 kg)
Tool module set	1.5 lbs/module (0.68 kg)
Stand for bench operation	2.3 lbs. (1.04 kg)

Clearance and Dimensions

Rotating parts diameter	4.98" (126.5mm)
Main frame diameter	4.98" (126.5mm)
Axial clearance required to centerline of cut:	
Mounting side	4.00" (101.6mm)
Side opposite of frame	0.68" (17.3mm)
Rotating parts radial clearance over pipe:	
2" tube	1.49" (37.9mm)
1 3/4" tube	1.62" (41.2mm)
1 1/2" tube	1.74" (44.2mm)

Pipe Cutting Capacities

Cutting capacities on 1 1/2" tube through 2" tube

(Note: Capacity exceeds maximum wall thickness for small pipe sizes)

- | | |
|-------------------------------------|---------------------|
| • Severing with standard procedures | 0.40" (10.2mm) wall |
| • Severing with special procedures | 0.80" (20.3mm) wall |
| • Severing and single beveling | 0.40" (10.2mm) wall |
| • Severing and double beveling | 0.40" (10.2mm) wall |
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Material Cutting Capabilities

Materials include, but are not limited to carbon steel, low alloy steel, chrome steel (20% max), chrome/moly alloys (Rc 32 max), austenitic stainless steel, Inconel, copper, aluminum, and copper nickel alloys.

Drive Options

Right angle air motor

Air requirements @ 90 PSI

75 CFM (35 lt/sec)

Head speed @ max. H.P.

38 RPM

Tool Modules

Working diameter range

0.70" - 2.00" (17.8mm - 50.8mm)

Travel per side

0.40" (10.2mm)

Clamping

Fixed, self-centering pad sets. All sizes within the specified size range are available upon request.

Adjustable pads only, available on request.

Accessories

- Counterbore Module Kit
 - Automatic Shut Off (ASO) for remote operations (Special)
 - Lathe Stand Kit
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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 Technologies 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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