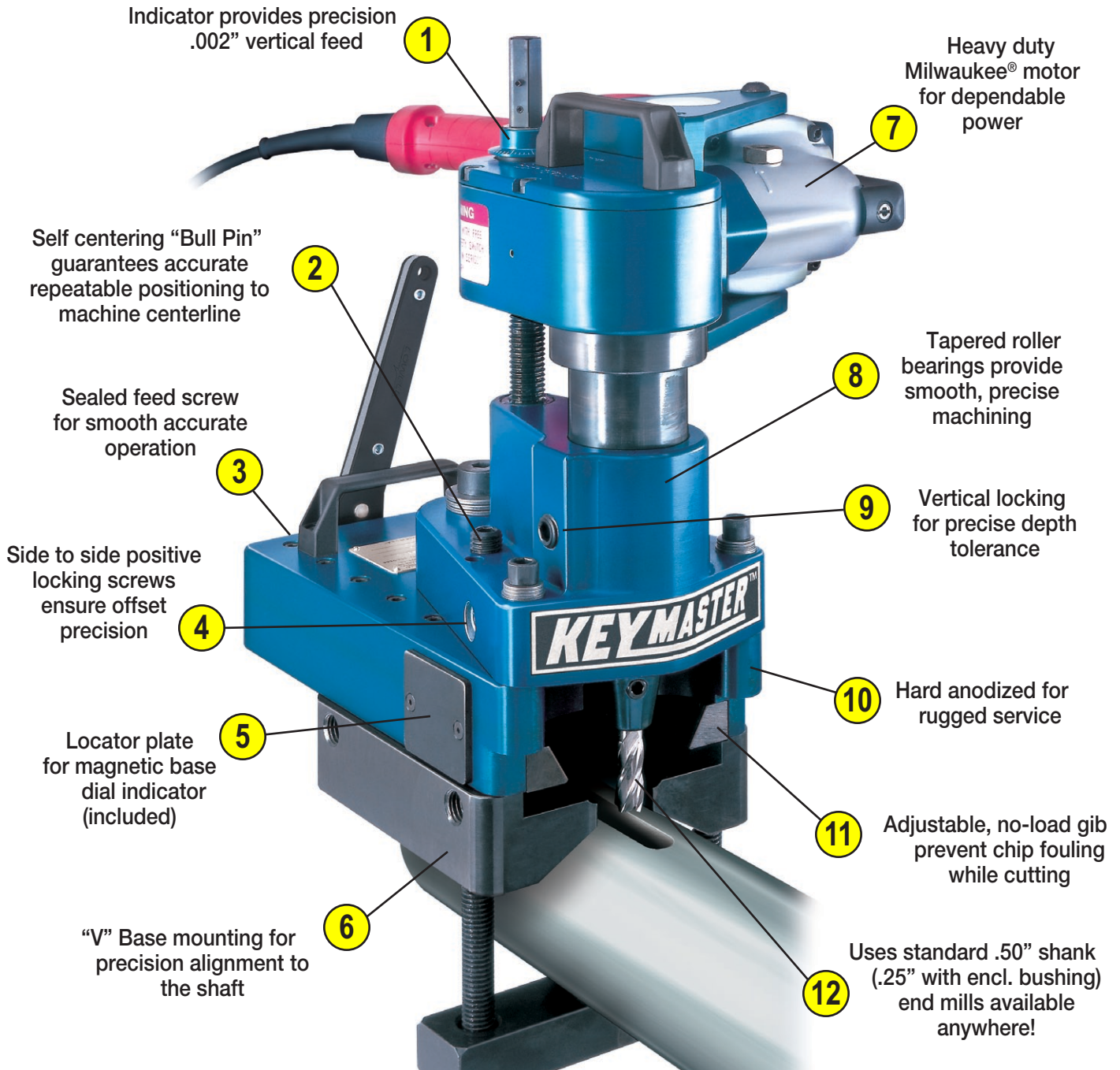


# Dependable In-Place Keyway Cutting

## Model 404 and 424 Portable Keyway Machines

### KEYMASTER®

This comprehensive keyway system is designed to quickly and easily machine precision keyways on 1.5" to 4.5" shafts (Model 404) or 1.5" to 24" shafts (Model 424).



# TRI TOOL INC.

## Specifications

### Equipment Description

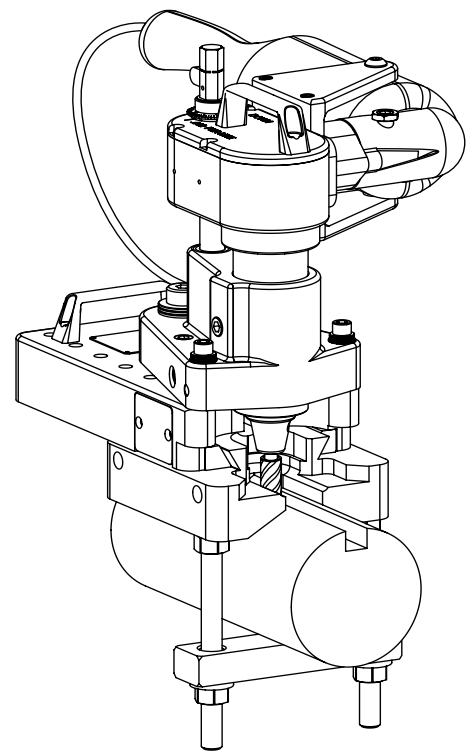
The KEYMASTER® Keyway Cutting Machine is designed to mill .25" (6.35mm) to 1.25" (31.75mm) wide by up to 6" (152.4mm) long keyway slots. The cutter may be used to install new keyways, re-cut keyways after being weld repaired, or install second keyways to bypass a damaged keyway. The tool uses a "V" block system to auto-align and center the tool to the shaft. For shaft sizes up to 4.5" (114.3mm), the tool mounts with a fixed bottom clamping bar. For larger shaft sizes, a system of spacers and chain clamps are used (optional for the Model 404). The tool incorporates a graduated precision depth of cut system and a mechanism to pivot the cutter off center to allow milling the sides of a keyway with a light finish cut for optimum width precision and surface finish, without having to reposition the machine on the shaft. With this system the keyway width is not dependent on the mill cutter dimensions (i.e. a .375" (9.53mm) mill cutter can be used to cut up to a .75" (19.1mm) wide key slot). A magnetic base precision dial indicator is included for adjustments and to verify the mounting accuracy. Axial feed is provided by a manual ratchet system. The Model 404/424 uses standard .5" (12.7mm) shank mill cutters, sizes from .5" (12.7mm) to 1" (25.4mm) diameters in .125" (3.18mm) increments, and a reducer collet (included with Model 424) allows use of .25" shank (6.35mm) end mills. The Model 404 KEYMASTER® can be expanded to work on shaft or pipe from 1.5" (38.1mm) to 24" (609.6mm) diameter with the addition of a range extension kit.

### Specifications

Min. Clamping Length:	1.5" (38.1mm) pipe length required
(404) Shaft Dia. Range:	1.5" (38.1mm) to 4.5" (114.3mm) dia.
(424) Shaft Dia. Range:	1.5" (38.1mm) to 24" (609.6mm) dia.
Motor Power:	1HP, 115VAC, 10.2 Amps
Optional Power	Pneumatic or 230VAC, 50/60 Hz
Speed Control:	Variable speed (6 speed thumb wheel)
Handling Weight:	61 lbs. (27.67 Kg)
Drive System:	Gear driven final drive
Keyway Length Travel:	6" (152.4mm)
Cut Depth Travel:	2" (50.8mm)

### Additional Features

- Model 424 - Packaged as a complete system with end mills, wrenches, dial indicator, mounting bar (1.5" - 4"), mounting chains (4"-12") and extensions for 12" to 24" dia. shafts.
- Perfect for motor shafts, pump shafts, etc. in paper mills, process industries, construction equipment, power plants, refineries, military and shipbuilding, and machine shops.
- Sealed Acme threads for long lasting, precision machine life.
- A common ratcheting wrench is used to control the keyway length feed and depth of cut adjustments.
- Variable speed thumb wheel allows setting motor RPM to six exact speeds throughout 0 to 560 RPM range.
- Top and bottom handles for easy carrying and positioning.
- Quick and easy gib adjustment compensates for wear.
- Rapid and secure plate mounting for 1.5" to 4.5"
- 12" to 24" mounting system (included with Model 424 - optional on Model 404) can be attached in two different positions for maximum flexibility and mounting options.
- Magnetic base dial indicator (included with Model 424) permits the machine to check alignment to the shaft and measure offset.
- Standard end mills mount with single mounting screw.
- Bores holes and mills inspection slots in jacketed piping.



Save time and money with dependable Tri Tool® machining equipment!



## TRI TOOL INC.

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