



TRI TOOL INC.

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TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL 306 TUBE SQUARING MACHINE
OCTOBER 29, 2008

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" (6.35 mm) 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 System 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

1. The Model 306 accepts its own torque through the Saddle Clamping System.
2. The cutting head accepts squaring bits or combinations of squaring, beveling, counterboring or facing tool bits.
3. Three tool slots allow counterboring, beveling and squaring operations simultaneously.

4. The Saddle Sets are made from aluminum.
5. All required wrenches for operation are supplied with the machine.
6. The Model 306 may be removed from the stand for use as a portable machine.

Specifications

1. Clearance and Dimensions reference Envelope Drawing No. 77-1700.
2. Pipe Cutting Capacities
 - A. Basic Pipe Sizes
 - i. 3/4" through 1 1/4" pipe
 - a. Schedules 5 through 160
 - ii. 1 1/2" through 2 1/2" pipe
 - a. Schedules 5 through 80
 - iii. 3" through 6" pipe
 - a. Schedules 5 through 40
 - B. Tubing
 - i. 1.00" (25.4 mm) to 6.63" (168.3 mm) outside diameter with maximum wall thickness of .250" (6.350 mm).
3. Material Cutting Capabilities
 - A. 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.
 - B. 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.

- 4. Drive System
 - A. Variable Speed Electric Drive Motor
 - i. Free Speed
 - a. 0 – 1,750 RPM
 - B. Cutting Head Speed
 - i. Maximum Cutting Head Speed
 - a. 40 RPM
- 5. Power Supply
 - A. Electric Drive Motor
 - i. 115 VAC, 20/60 Hz, 11 Amp.
 - ii. 230 VAC, 50/60 Hz
 - B. Pneumatic Drive System
 - i. Available on request.
- 6. Speed Control
 - A. Variable speed electric drive motor.
- 7. Mounting
 - A. Manual saddle clamping system.
- 8. Feed
 - A. Manual feed handle is mounted at rear of tool, providing 1.00" (25.4 mm) of axial feed.
- 9. Weight
 - A. 70 lbs. (31.8 kg)

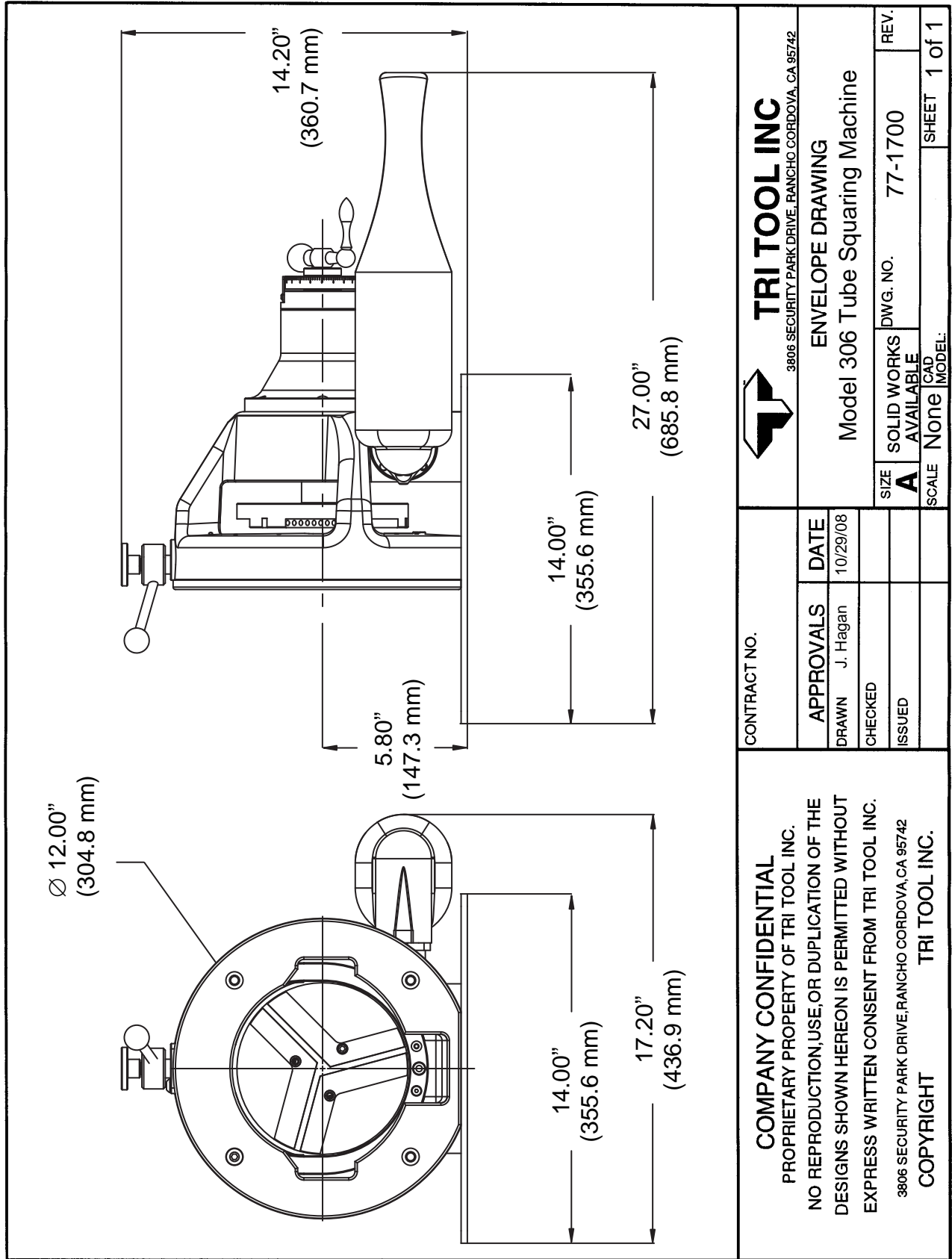
Note To The Customer

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.

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



<p>TRI TOOL INC 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</p>		<p>ENVELOPE DRAWING</p>		<p>SIZE A</p>	<p>SOLID WORKS DWG. NO. 77-1700</p>	<p>REV.</p>
		<p>Model 306 Tube Squaring Machine</p>		<p>SCALE None</p>	<p>CAD MODEL</p>	<p>SHEET 1 of 1</p>
<p>CONTRACT NO.</p>		<p>APPROVALS</p>	<p>DATE</p>			
		<p>DRAWN J. Hagan</p>	<p>10/29/08</p>			
		<p>CHECKED</p>				
		<p>ISSUED</p>				
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