

TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL 572AC SEVERMASTER™ SYSTEM
MARCH, 1997

Model 572AC SEVERMASTER™ PORTABLE LATHE SYSTEM

The Model 572AC SEVERMASTER™ severs 1/4" (6.35mm) to 2" (50.80mm) diameter tubes and thin wall pipe within the size range. This machine enhances productivity by incorporation of an Auto-Cycle Tool Module and Quick Lock Collet Closure. The Auto-Cycle Tool Module incorporates a cam cycle tool bit feed mechanism which automatically returns the tool bit to the home position ready to start the next cut. The tool module also allows setting the start and finish cut positions to minimize the cycle time. The feed increment per revolution is adjustable to match the cutting relative to the material. A variable speed motor provides cutting speed control for tool bit life and ID burr condition. The Quick Lock mechanism actuates the collet with a single lever stroke for simple collet changes.

Tool bit options are available to minimize the burr on the mounting side or the drop-off side of the sever line and in different edge widths to match the tube wall thickness. The tool also incorporates mounting features to allow use of an SQM-1AC Tube Squaring module for optimum burr free ends.

The Model 572AC Severmaster System consists of the mainframe with Quick Lock Collet Closure, Auto Cycle Tool Module with adjustable depth of feed from .001" to .005" (.02mm to .13mm) per revolution, drive motor, wrench kit, operators manual and carrying case.

Design and Operating Features:

1. The Module 572AC accepts its own torque through the collet clamping system.
2. The collet provides accurate centering and full diameter support for minimum distortion of thin wall tubing.
3. Gear driven powerhead rotates on a precision cross roller bearing.
4. Single lever actuation of collet.
5. Gears are all enclosed for operator safety.
6. All required wrenches for operation are supplied with the machine.

Specifications

1. Pipe Cutting Capacities:
 - a. Part-off or sever:

1/8" pipe through 1 1/2" pipe schedule 5
1/4" (6.35mm) through 2" (50.80mm) diameter tubing up to .065" (1.65mm) wall.
2. Material Cutting Capabilities:
 - a. Mild steels, chrome steels (Rc 35 max), stainless steel, copper-nickel and aluminum without limitations except size and wall thickness as specified in paragraph 1.
 - 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.
3. Clearances and Dimensions:
 - a. See envelope Dwg.
4. Pneumatic Drive System:
 - a. Available on request.
5. Electric Drive:
 - a. Power requirements
115 vac, 28 to 60 hz, 5.25 amp
230 vac, 50/60 hz
6. Cutting Head Speed: (Electric)
 - a. Maximum cutting speed:

<u>Low</u>	<u>High</u>
60 rpm	120 rpm
7. Mounting
 - a. Manually actuated collet clamping system.
8. Feed:
 - a. Autofeed system adjustment from .001" to .005" (.02mm to .13mm).

9. Tool Bits:

Part Number

99-3036 Sever tool bit (leaves a burr on the tube that the machine is mounting on).

99-2959 Sever tool bit (leaves a burr on the tube that falls off after severing).

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/or equipment are warranted against defects in material and workmanship for a period of one year from date of purchase. Full details supplied on request and/or with tools.

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

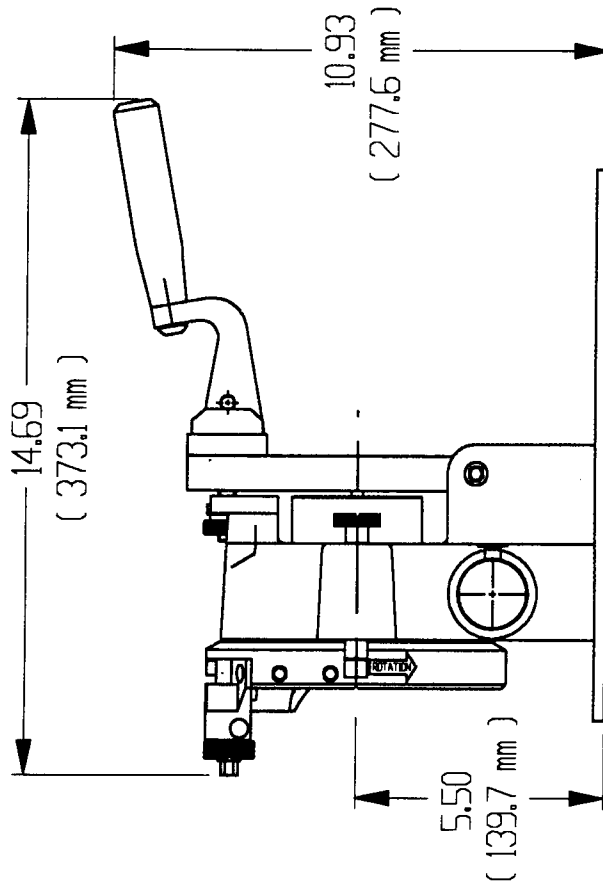
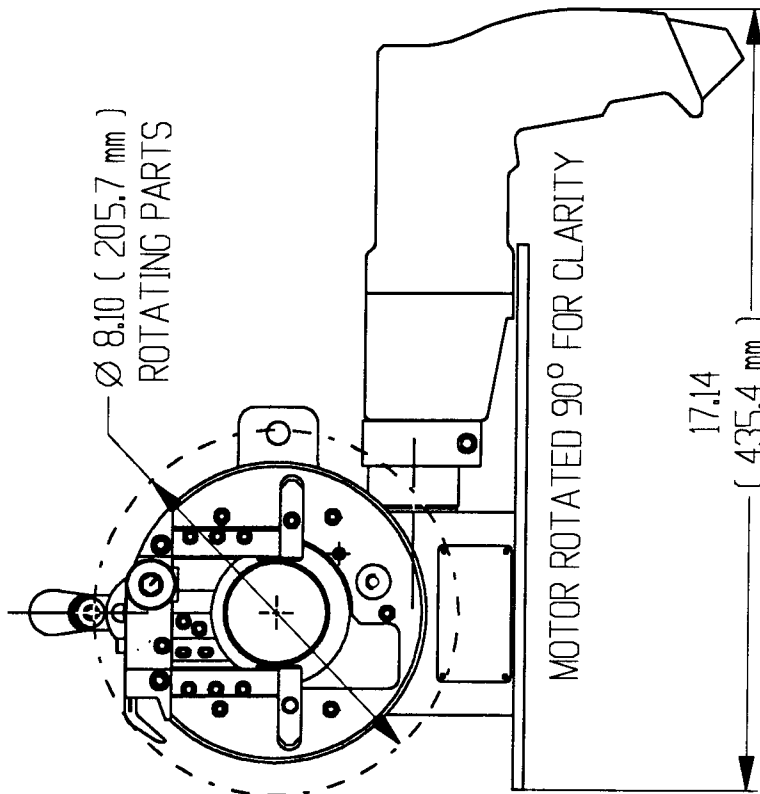
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TRI TOOL INC.



DWG. NO. 77-1516 SH 1 REV.

REVISIONS

REV.	DESCRIPTION	DATE	APPROVED

UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES		CONTRACT NO.	
TOLERANCES ARE:		NEXT ASSY	USED ON
DECIMALS ± 1/16	FRACTIONS ± 0° 30'	MATERIAL	
.XXX ± .010	ANGLES ± 0° 30'	FINISH	
MACHINED SURFACES 125 √		DO NOT SCALE DRAWING	
TO BE CONCENTRIC WITHIN .010 TIR			
FLATNESS TO WITHIN .010 TIR			
BREAK ALL SHARP EDGES .005-.015			
FILLET RADII TO BE .030 MAX			
C/SINK THD HOLES TO MAJ DIA X 8 $\frac{1}{2}$ -9 $\frac{1}{8}$			
 TRI TOOL INC. 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742		MODEL 572AC ENVELOPE DRAWING	
SIZE A CAD AVAILABLE		DWG. NO. 77-1516	
SCALE NONE		SHEET 1 OF 1	
APPROVALS DRAWN TIMBERLAKE 8/1/96 CHECKED ISSUED		DATE	