



# TRI TOOL INC.

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## TRI TOOL INC. TECHNICAL SPECIFICATION MODEL 602SBCM LOW PROFILE CLAMSHELL MARCH 2006

### Model 602SBCM Low Profile Clamshell

The 602SBCM Low Profile Clamshell is a split-frame pipe lathe for severing and beveling in-line pipe with a range of 1" through 2" pipe with minimal radial and axial clearances.

### Design and Operating Features

1. Easily adjustable precision bearing surfaces preload and stabilize the rotating head to provide long life, low maintenance, stability and precision.
2. 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.
3. The machine is equipped with self-centering collets.
4. Dual dovetail tool modules with auto-feed sprockets and adjustable gib provide maximum maintainability, life and operator safety with minimum operator training.
5. The auto-feed star sprockets provide .003" (.08 mm) of radial feed per revolution for a controlled depth of cut.
6. Drive worm, worm gears and bearing surfaces are covered for operator safety.
7. Operator controls are away from the rotating headstock for safety.
8. Modular design concepts provide quick, easy maintenance and maximum versatility in drive and tooling options.
9. Detachable Bayonet type motor provides maximum handling ease and low axial clearance. A flex drive shaft is also available to bring the motor away from the tool.
10. All parts are plated for clean room or glove bag use. Tool contains no lead, brass, or copper.

Specifications

1. Reference Envelope Drawing No.: 77-1672

2. Cutting capacities\* on 1" through 2" pipe

\*Capacity exceeds maximum wall thickness for small pipe sizes.

- A. Severing with standard procedures .250" wall (6.35 mm)
- B. Severing with special procedures .358" wall (9.09 mm)
- C. Severing and single beveling .250" wall 6.35 mm)
- D. Severing and double beveling .250" wall (6.35 mm)

3. Material Cutting Capabilities

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

4. Clearance and Dimensions

- A. Rotating parts diameter 4.610" (117.1 mm)
- B. Main frame diameter 4.40" (111.8 mm)
- C. Axial clearance required relative to centerline of cut
  - i. Mounting side 2.24" (56.9 mm)
  - ii. Side opposite of frame .25" (6.35 mm)
- D. Radial clearance over pipe
  - i. 1" pipe 1.65" (41.9 mm)
  - ii. 2" pipe 1.12" (28.4 mm)

5. Drive Options

- A. Bayonet type air motor
  - i. Air requirements @ 90 PSI 32 CFM
  - ii. Horsepower 0.7 HP
  - iii. Head max. speed 18 RPM

6. Clamping
  - A. Fixed, self-centering collet sets.
    - i. All sizes within the specified size range are available upon request.
7. Weight
  - A. Basic Machine
    - i. 6.0 lbs. (2.67 kg)
  - B. Motor
    - i. 5.35 lbs. (1.68 kg)

#### Accessories (Optional)

1. Socket Weld Removal Tool Module Kit
2. Auto-Disengage Tripper Module Kit

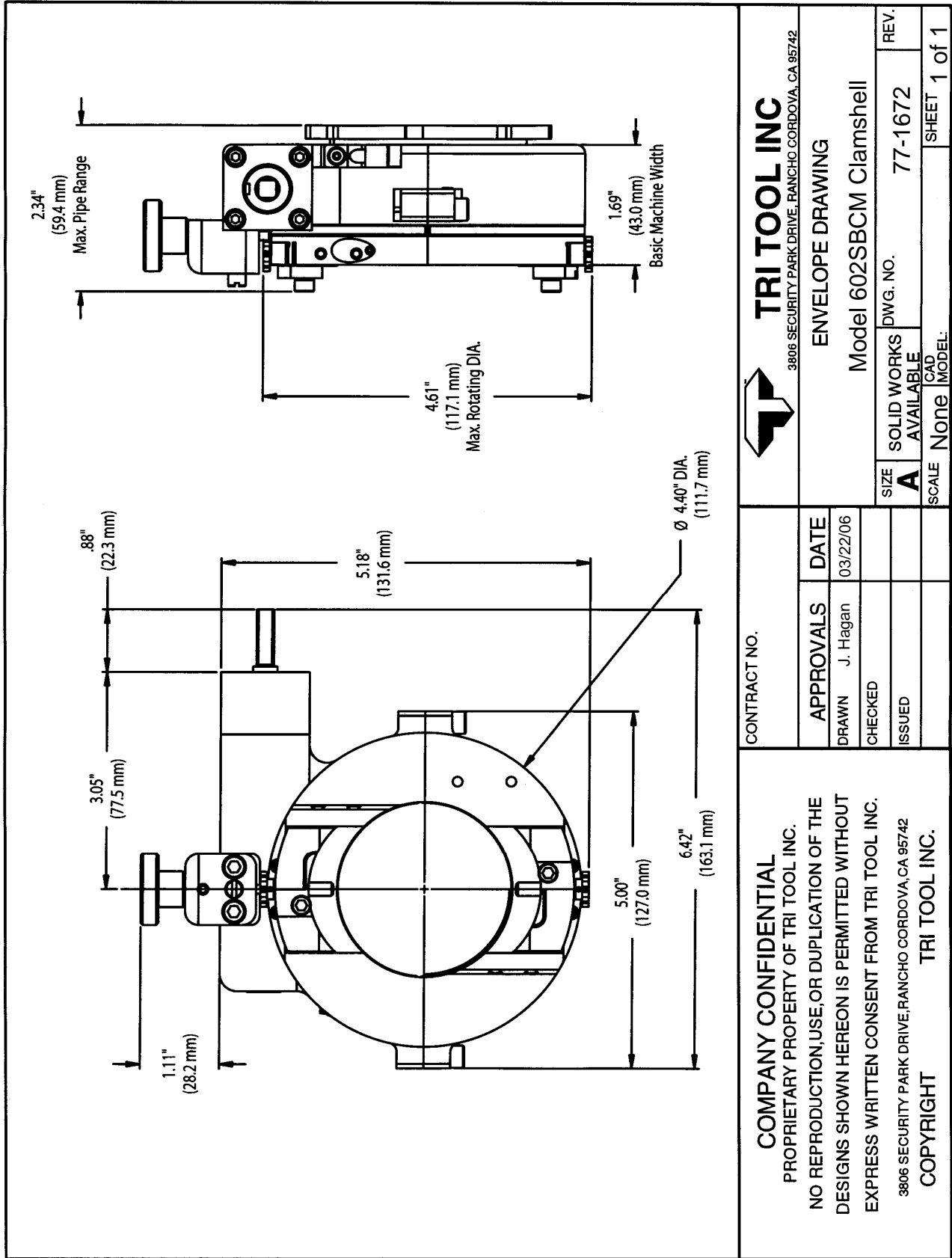
#### Note To The Customer

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 Inc. 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><b>TRI TOOL INC</b>                  3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</p>		<p>ENVELOPE DRAWING</p>		<p>Model 602SBCM Clamshell</p>			
		<p>CONTRACT NO.</p>	<p>APPROVALS</p>	<p>DATE</p>	<p>SIZE</p>	<p>DWG. NO.</p>	<p>REV.</p>
<p><b>COMPANY CONFIDENTIAL</b>                  PROPRIETARY PROPERTY OF TRI TOOL INC.                  NO REPRODUCTION, USE, OR DUPLICATION OF THE                  DESIGNS SHOWN HEREON IS PERMITTED WITHOUT                  EXPRESS WRITTEN CONSENT FROM TRI TOOL INC.                  3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742                  COPYRIGHT TRI TOOL INC.</p>		<p>DRAWN J. Hagan</p>	<p>CHECKED</p>	<p>ISSUED</p>	<p><b>A</b></p>	<p>77-1672</p>	<p>SHEET 1 of 1</p>
		<p>SCALE</p>	<p>CAD</p>	<p>None</p>	<p>MODEL:</p>	<p>None</p>	<p>None</p>
		<p>None</p>	<p>None</p>	<p>None</p>	<p>None</p>	<p>None</p>	<p>None</p>