



# TRI TOOL INC.

## TRI TOOL INTERNATIONAL INC.

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TRI TOOL INC.  
TECHNICAL SPECIFICATION  
MODEL 648RBL LOW PROFILE CLAMSHELL  
MARCH, 1997

### MODEL 648RBL Low Profile Clamshell

Description: The 648RBL Low Profile Clamshell is a split-frame pipe lathe for severing and/or beveling in-line pipe with a range of 42" through 48" nominal diameter with minimal radial and axial clearances.

### Design and Operating Features

1. Easily adjustable precision 90° -Vee bearings preload and stabilize the rotating head to provide long life, low maintenance, stability and precision.
2. The clamshell splits into four quarters for mounting on closed looped systems. All parts are secured to these four quarters to avoid loss of parts and provide maximum ease of handling.
3. The clamshell is equipped with jackscrews and adjustable mounting pads for out-of-round pipe conditions.
4. Dual tool modules with auto-feed sprockets and adjustable slide ways provide maximum maintainability, life and operator safety with minimum operator training.
5. The auto-feed star sprockets provide .004" ( .10mm ) of radial feed per revolution for a controlled depth of cut.
6. Drive gears and bearing surfaces are covered for operator safety and sealed to prevent cutting chip damage.
7. Operator controls are away from the rotating head for operator safety.
8. Modular design concepts provide quick, easy maintenance and maximum versatility in drive and tooling options.
9. The clamshell has 90° -Vee bearings that are field adjustable back to zero tolerance.

## Specifications

1. Reference Envelope Drawing No. 77-1430.
2. Cutting capacities\* 42" through 48" pipe: with ext. tool modules:
  - a. Severing with standard procedures . 2.50" ( 63.5mm ) wall
  - b. Severing and single beveling 1.25" ( 31.8mm ) wall
  - c. Severing and double beveling 1.25" ( 31.8mm ) wall
  - d. Severing and beveling w/ special procedures 2.00" ( 50.8mm ) wall

\* 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.
3. Clearances: ( see Envelope drawing )
4. Drive Options:
  - a. Single or dual right angle air motors:  
Single air requirements @ 90 PSI ( 6.3 kg/cm2 ) 95 CFM ( 45 lt/sec )
  - b. Single or dual inline hydraulic motors  
( requires separate hydraulic power supply. Ref: 765RVC technical specifications )
5. Tool Modules:
  - a. Working diameter range 42" - 48 " pipe
  - b. Feed rate .004" ( .10mm )/rev
6. Mounting:

4 fully adjustable mounting pads with additional mounting jackscrews for 42" , 44" , 46" , and 48" pipe.
7. Approximate weights:

Basic machine w/ 2 drive housings	900 lbs. (408.2kg )
Standard Tool Modules	23 lbs ( 10.4kg ) /module.
Hydraulic Motors	34 lbs. (15.4 kg ) ea.
Air Motors	25 lbs ( 11.3 kg ) ea.

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.

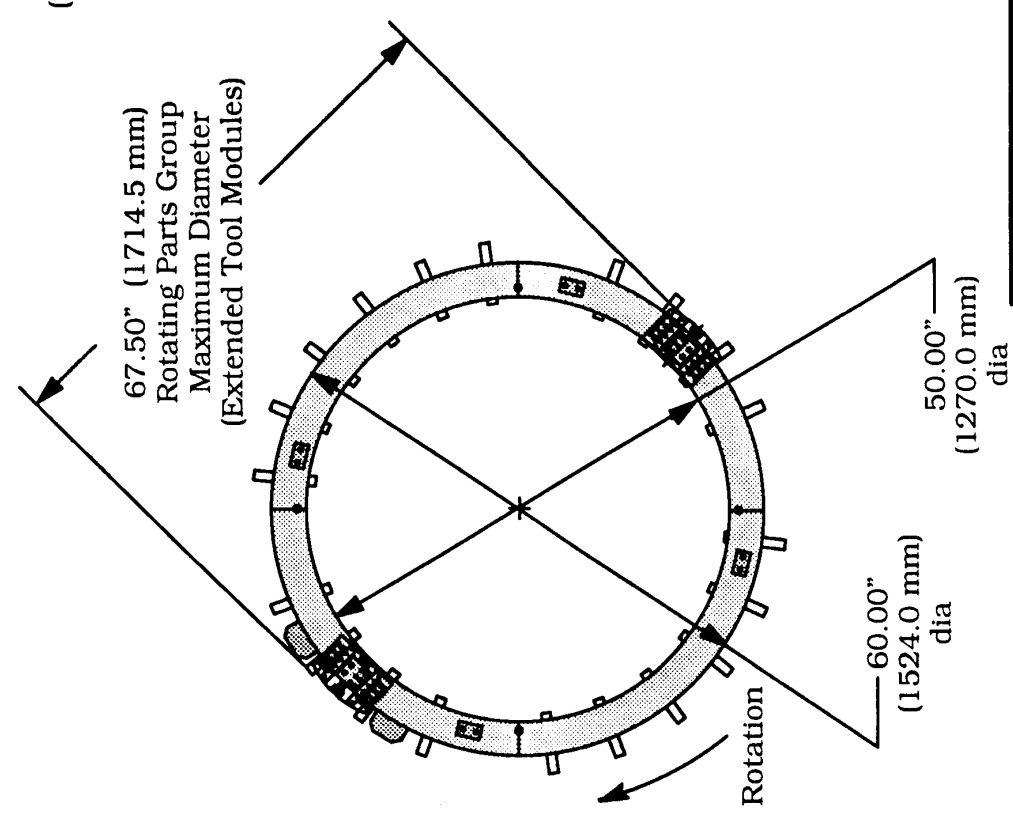
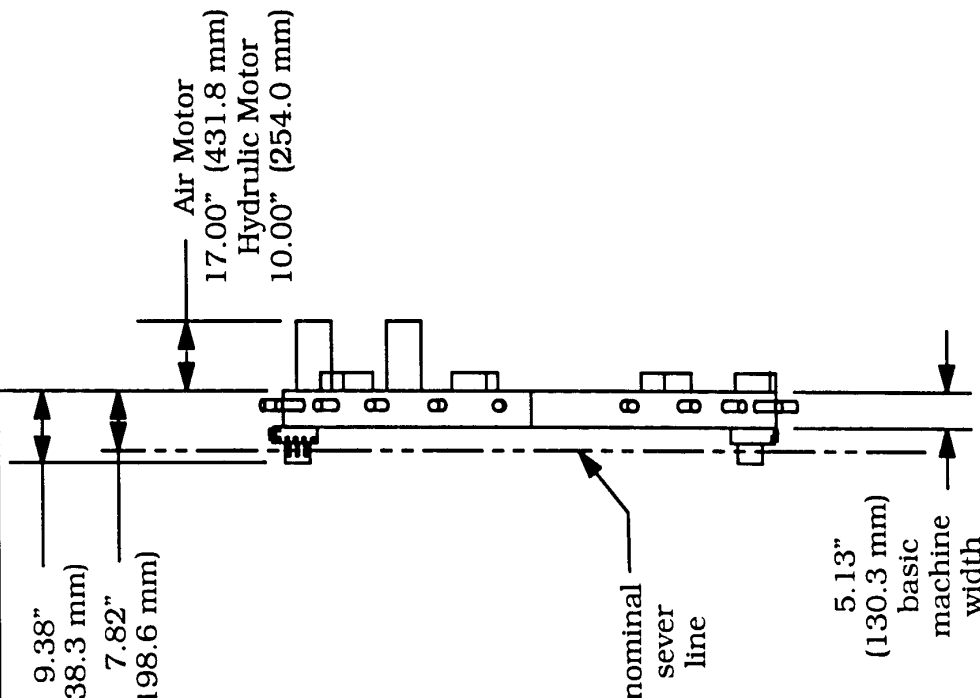
Filter, regulator, lubricator required to protect warranty on air powered tools.



DWG. NO. 77-1430

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REV.



<b>TRITOO Inc.</b> 3806 SECURITY PARK DRIVE RANCHO CORDOVA CA 95742-6990	
Envelope Drawing Model 648RBL, Clamshell	
CONTRACT NO.	DATE
APPROVALS	4/26/95
DRAWN PFAFMAN	
CHECKED	
ISSUED	
SIZE A	DWG. NO. 77-1430
FSCM NO.	REV
SCALE None	SHEET 1 of 1
<b>DO NOT SCALE DRAWING</b>	

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