

TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL SQM-2AC SQUARING MODULE KIT
APRIL, 1997

MODEL SQM-2AC SQUARING MODULE KIT

The Model SQM-2AC Squaring Module mounts on the Model 576AC SEVERMASTER™. The mount incorporates a pivot post to allow the SQM-2AC to be "parked" over the cutting face during a sever operation.. After a sever is complete, the SQM-2AC may be pivoted into position for performing a burr free end squaring operation. A manual feed allows the operator to control the depth of cut of the end squaring operation. The SQM-2AC covers the full range of the Model 576AC SEVERMASTER™.

Design and Operating Features

1. The SQM-2AC Squaring Module can be mounted directly to the headstock of the Model 576AC SEVERMASTER™.
2. Manual axial feed.
3. No loose pieces.
4. No reset of the Model 576AC after severing and/or beveling pipe.

Specifications

1. Reference Envelope Drawing No. 77-1549
2. Basic tube or pipe size: 2.00" (50.8mm) through 6.63" (168.4mm) O.D.
.156" (4.0mm) wall max.
3. Clearances:
 - a. Rotating parts diameter: Rotating diameter of Model 576AC
 - b. Length: 5.02" (127.5mm) from the face of Model 576AC
4. Axial Feed Length: .63" (16.0mm)
5. Axial Feed Rate: .025" (.64mm)/rev. at full speed

Copyright© propriety property of TRI TOOL inc. No reproduction, use or duplication of the information hereon is permitted without the express written consent of TRI TOOL Inc.

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.

COMPANY CONFIDENTIAL

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.

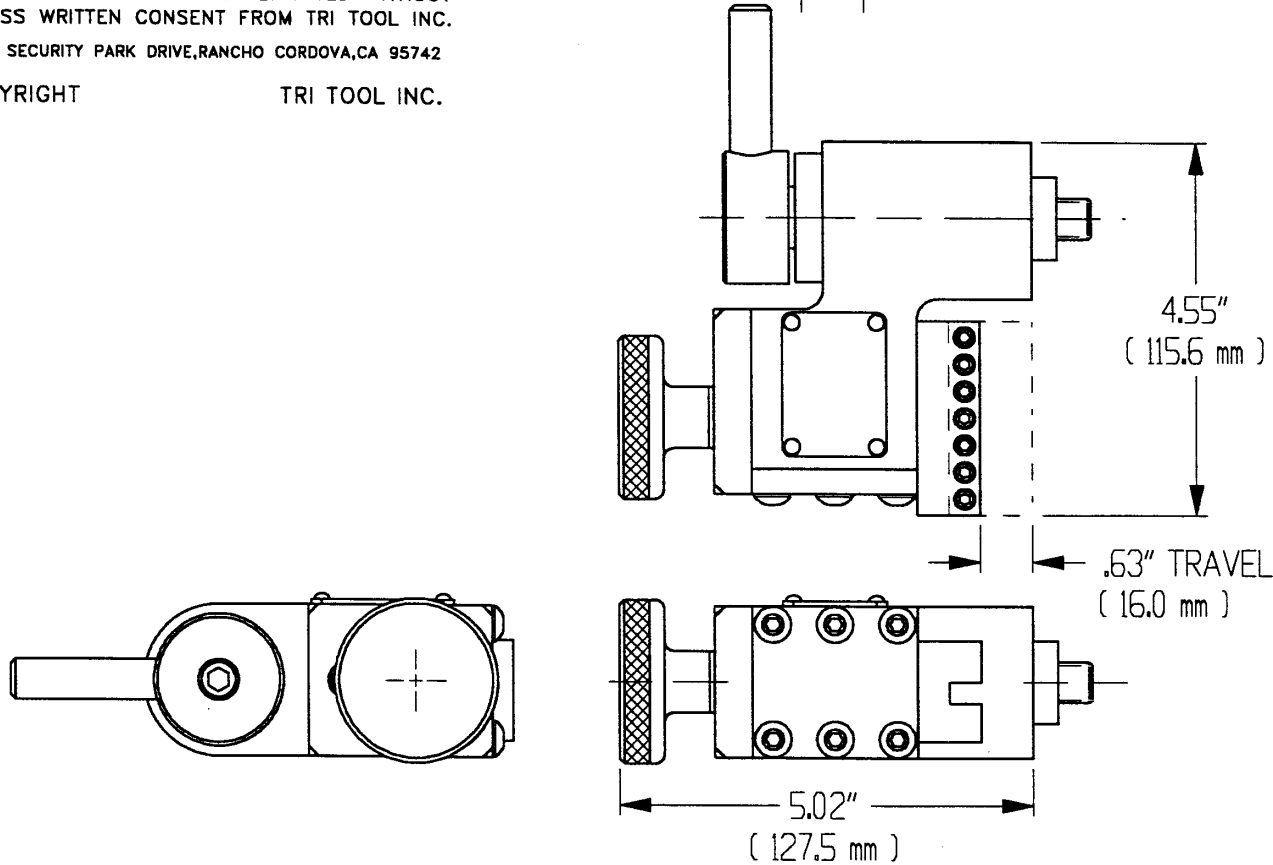
3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742

COPYRIGHT

TRI TOOL INC.

REVISIONS


REV.	DESCRIPTION	DATE	APPROVED



DWG. NO. 77-1549
 SH 1
 REV.

UNLESS OTHERWISE NOTED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 DECIMALS FRACTIONS ANGLES
 .XX±.03 ±1/16 ± 0° 30'
 .XXX±.010
 MACHINED SURFACES 125√
 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 82°-90°

CONTRACT NO.	
NEXT ASSY	USED ON
MATERIAL	APPROVALS
FINISH	DATE
DO NOT SCALE DRAWING	DRAWN TIMBERLAKE 4/21/97
	CHECKED
	ISSUED

 <p>TRI TOOL INC. 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</p>		ENVELOPE DRAWING	
		MODEL SQM-2AC, SQUARING MODULE	
SIZE A	CAD AVAILABLE	DWG. NO. P 77-1549	REV.
SCALE NONE	SHEET 1 OF 2		

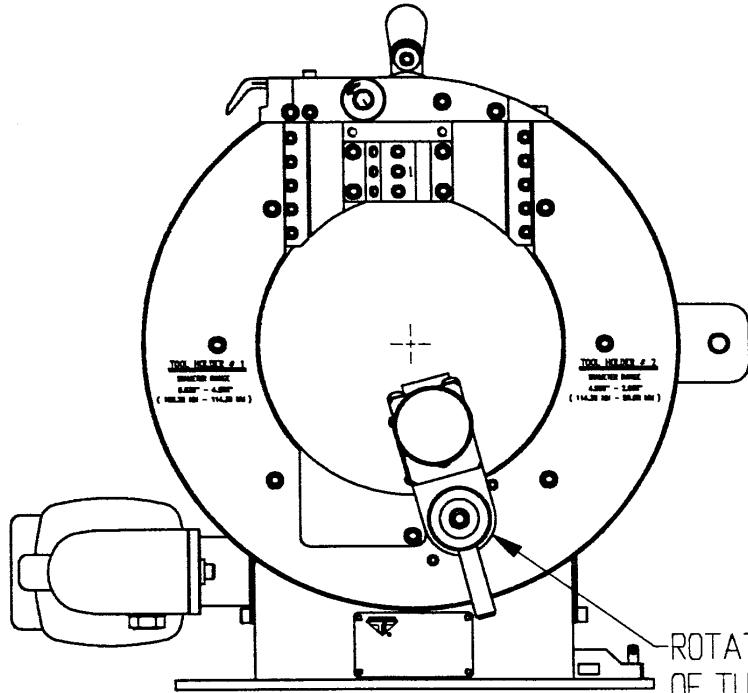
COMPANY CONFIDENTIAL

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.

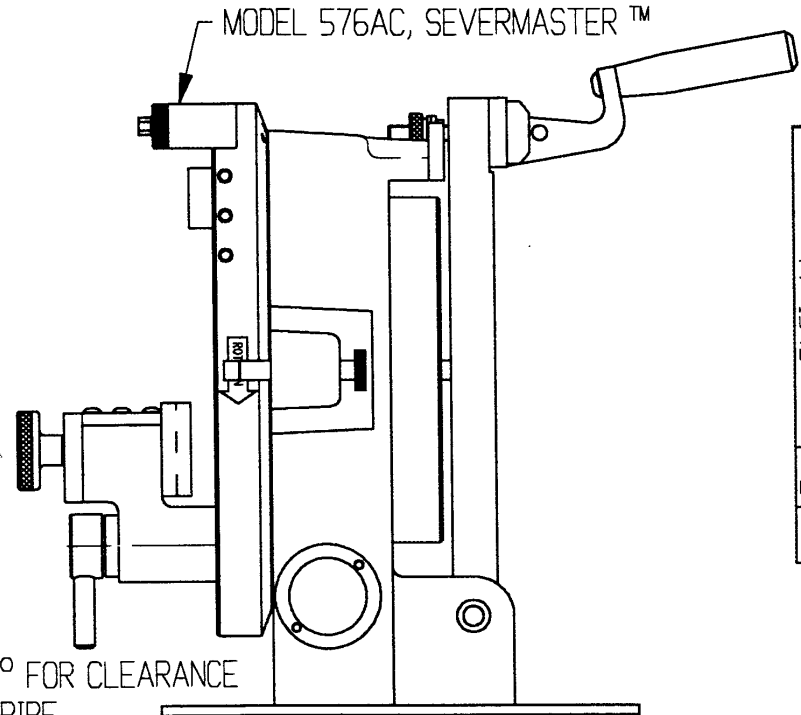
3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742

COPYRIGHT

TRI TOOL INC.



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED




DWG. NO. 77-1549
 SH 2 REV.

UNLESS OTHERWISE NOTED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 DECIMALS FRACTIONS ANGLES
 .XX±.03 ±1/16 ± 0° 30'
 .XXX±.010
 MACHINED SURFACES 125 ✓
 [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 82°-90°

NEXT ASSY	USED ON
MATERIAL	APPROVALS
FINISH	DATE
DO NOT SCALE DRAWING	ISSUED

CONTRACT NO.	
APPROVALS	DATE
DRAWN TIMBERLAKE	4/21/97
CHECKED	
ISSUED	



TRI TOOL INC.
 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742

ENVELOPE DRAWING
 MODEL SQM-2AC, SQUARING MODULE

SIZE A	CAD AVAILABLE	DWG. NO. P 77-1549	REV.
SCALE NONE	P771549A.DWG	SHEET 2 OF 2	