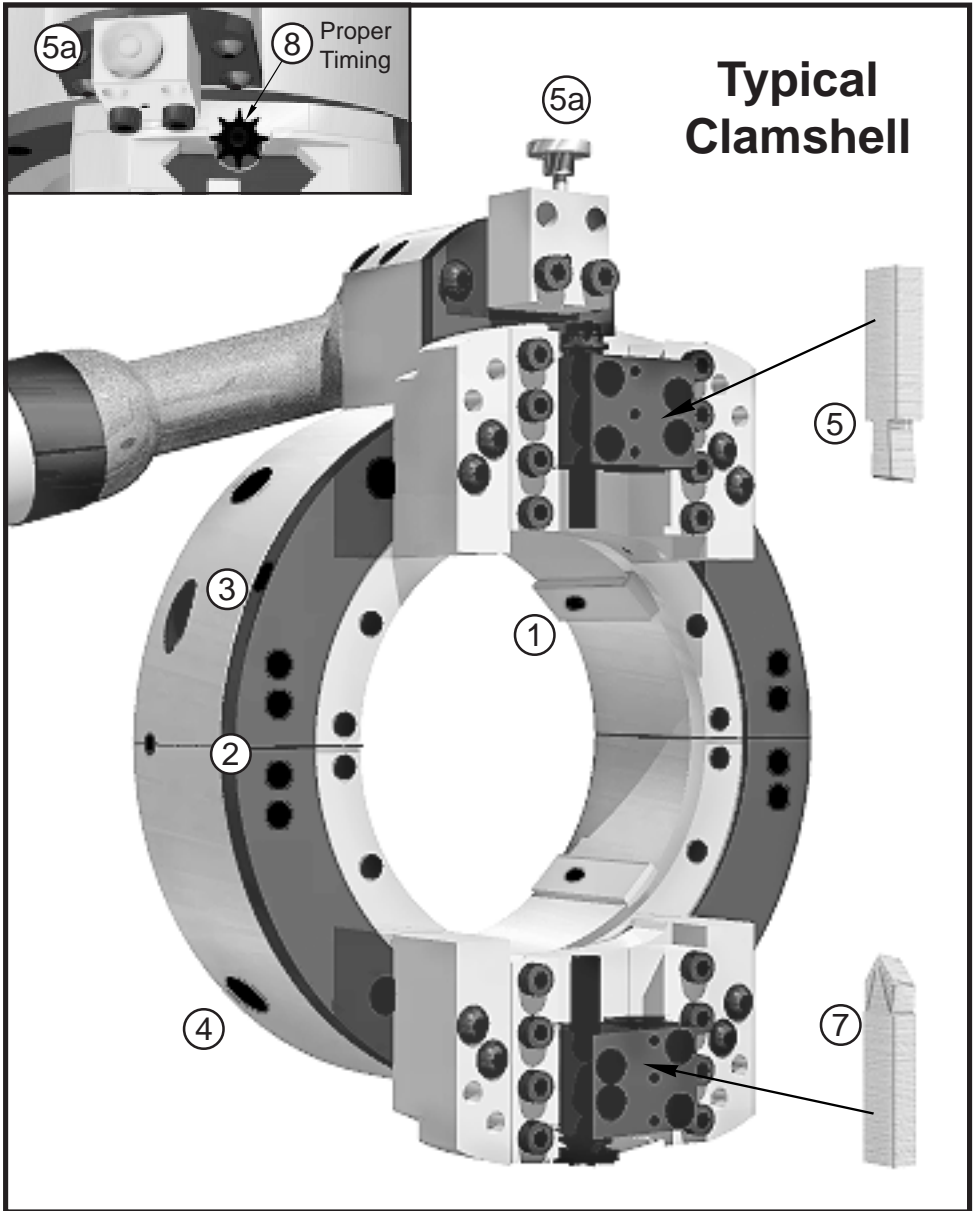


# QUICK REFERENCE CARD-

## Set-Up and Operation of TRI TOOL™ 600 SB Series Clamshells

Note: This is intended only as a step by step reminder and does not remove the responsibility from the user of being completely familiar with the safety, operation, and maintenance information printed in the Operator's Manual, provided with this machine.



1. Determine the pipe size to be cut and select the proper locator pads for mounting (1).  
*(If cutting open end pipe, skip to step #4)*
2. For an in-line cut, ensure that frames are aligned at split lines and loosen four captive screws that hold the frame and gear together (3).
3. Be sure that locator pads are fully retracted into the frame before positioning clamshell.
4. Mount clamshell on pipe and tighten captive frame and gear screws (3).
5. Tighten locator pads to the pipe (1).  
Note: Wiggle the machine while tightening bolts to ensure machine is square on pipe OD.
6. Install sever bit into tool module (5) and lightly tighten two of four set screws. Ensure that tool module is in the outermost position and raise trip pin knob (illustration #5a) to the outermost position to disengage. Note: For machines over 12" size, see Operator's Manual.
7. Rotate machine with a 1/2" drive ratchet at motor mount to find the high spot on the pipe. At that point, lower sever bit with sprocket (8) and special starwheel wrench.
8. Install bevel bit (7) into the opposite tool module and lightly tighten two of four set screws. Rotate machine frame to the same high spot. With starwheel wrench, lower bevel bit until it touches pipe and back off two turns.
9. With starwheel wrench, turn star wheel counterclockwise to remove free play and to "time" the sprocket teeth before startup (see illustration 8 in inset picture). Be sure to perform this operation on both tool modules.
10. Tighten down all tool bit holding set screws.
11. Install drive motor into pinion housing and secure with shoulder bolt supplied. Note: Some motor movement, after shoulder bolts are fully tightened, is intentional.
12. Connect power supply (pneumatic and air caddy, electric, or hydraulic). Put on safety glasses and secure loose clothing.
13. Engage tripper pin (5a). Slowly rotate under power for one full revolution to ensure clearance and proper star wheel "timing."
14. Go to full rotating speed. As the machine commences to cut, apply approved coolant /lubricant from a spray bottle.



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