



TRI TOOL INC.

TRI TOOL INTERNATIONAL INC.

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TRI TOOL INC. TECHNICAL SPECIFICATION MODEL 602TSB LOW PROFILE CLAMSHELL APRIL, 2000

MODEL 602TSB Low Profile Clamshell

Description: The 602TSB Low Profile Clamshell is a split-frame pipe lathe for severing and beveling in-line pipe and tube with a range of 1.50" (38.1mm) through 2.00" (50.8mm) O.D. with minimal radial and axial clearances. This tool requires 1.49" (37.8mm) of radial clearance over 2.00" (50.8mm) tube.

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 may be equipped with self-centering mounting pads for quick, easy mounting or may be equipped with 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 .003" (.08mm) 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 headstock for safety.
8. Modular design concepts provide quick, easy maintenance and maximum versatility in drive and tooling options.
9. Detachable right angle air motor provides maximum handling ease and low axial clearance. Torque accepting mounting bracket allows the air motor to be rotated in various positions.

Specifications:

1. Reference attached Envelope Drawing No. 77-0617
2. Cutting capacities* on 1 1/2" tube through 2" tube.
(Note: Capacity exceeds maximum wall thickness for small pipe sizes)
 - a. Severing with standard procedures 0.40" (10.2mm) wall
 - b. Severing with special procedures 0.80" (20.3mm) wall
 - c. Severing and single beveling 0.40" (10.2mm) wall
 - d. Severing and double beveling 0.40" (10.2mm) 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:

- a. Rotating parts diameter 4.98" (126.5mm)
- b. Main frame diameter 4.98" (126.5mm)
- c. Axial clearance required relative to centerline of cut:
Mounting side 4.00" (101.6mm)
Side opposite of frame 0.68" (17.3mm)
- d. Rotating parts radial clearance over pipe:
2" tube 1.49" (37.9mm)
1 3/4" tube 1.62" (41.2mm)
1 1/2" tube 1.74" (44.2mm)

4. Drive Options:

- a. Right angle air motor

Air requirements @ 90 PSI 75 CFM (35 lt/sec)
Head speed @ max. H.P. 38 RPM

5. Tool Modules:

- a. Working diameter range 0.70" - 2.00"
(17.8mm) (50.8mm)
- b. Travel per side .40"
(10.2mm)

6. Clamping:

- a. Fixed, self-centering pad sets.
All sizes within the specified size range are available upon request.
- b. Adjustable pads only, available on request.

7. Weight:

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Basic machine	10.0 lbs. (4.54 kg)
Right angle drive	12.0 lbs. (5.44 kg)
Tool module set	1.5 lbs/module (0.68 kg)
Stand for bench operation	2.3 lbs. (1.04 kg)

Optional Accessories:

- a. Counterbore Module Kit
- b. Automatic Shut Off (ASO) for remote operations (Special)
- c. Lathe Stand Kit

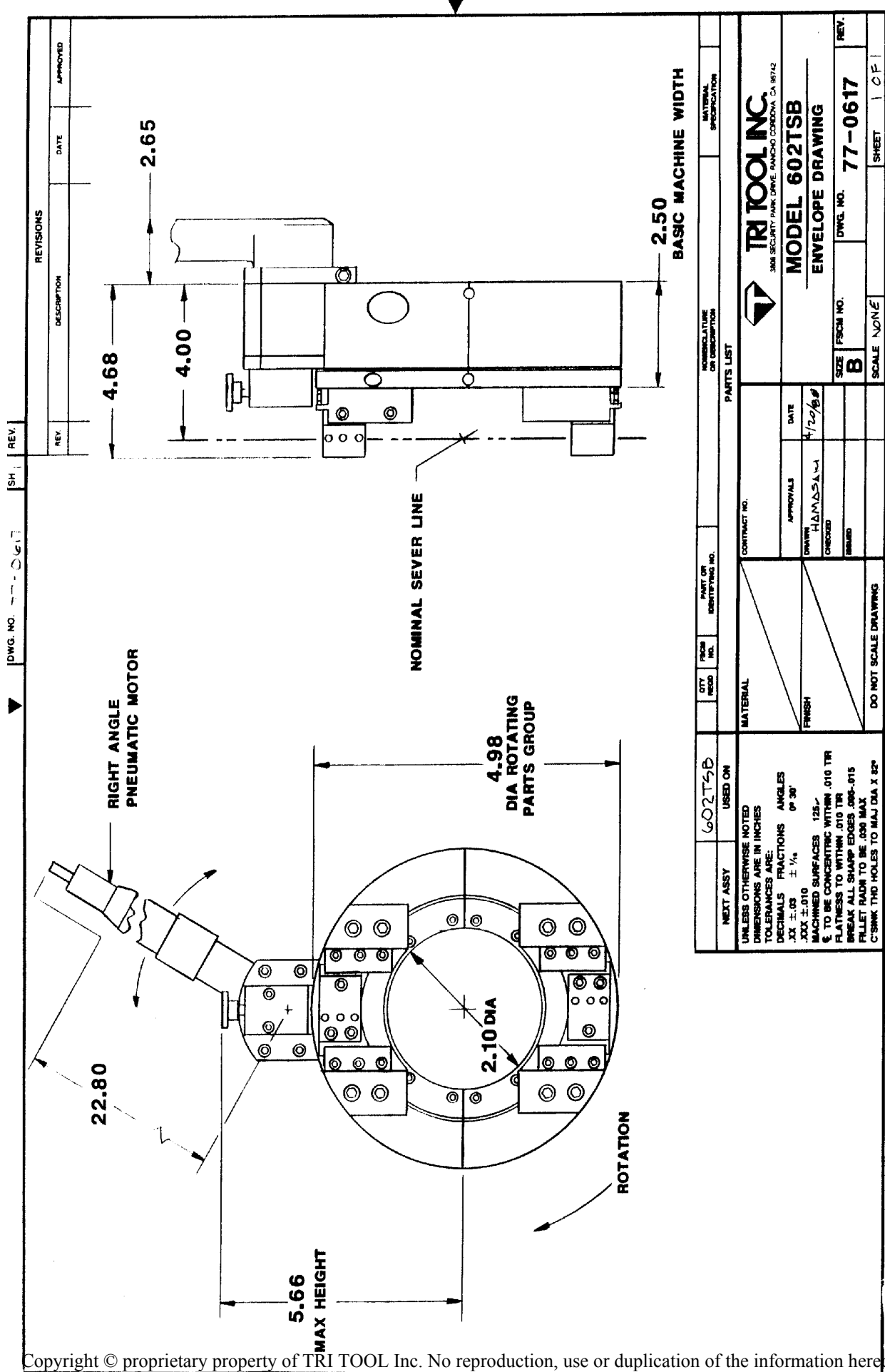
Spare parts and standard tool bits are available from stock.

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.

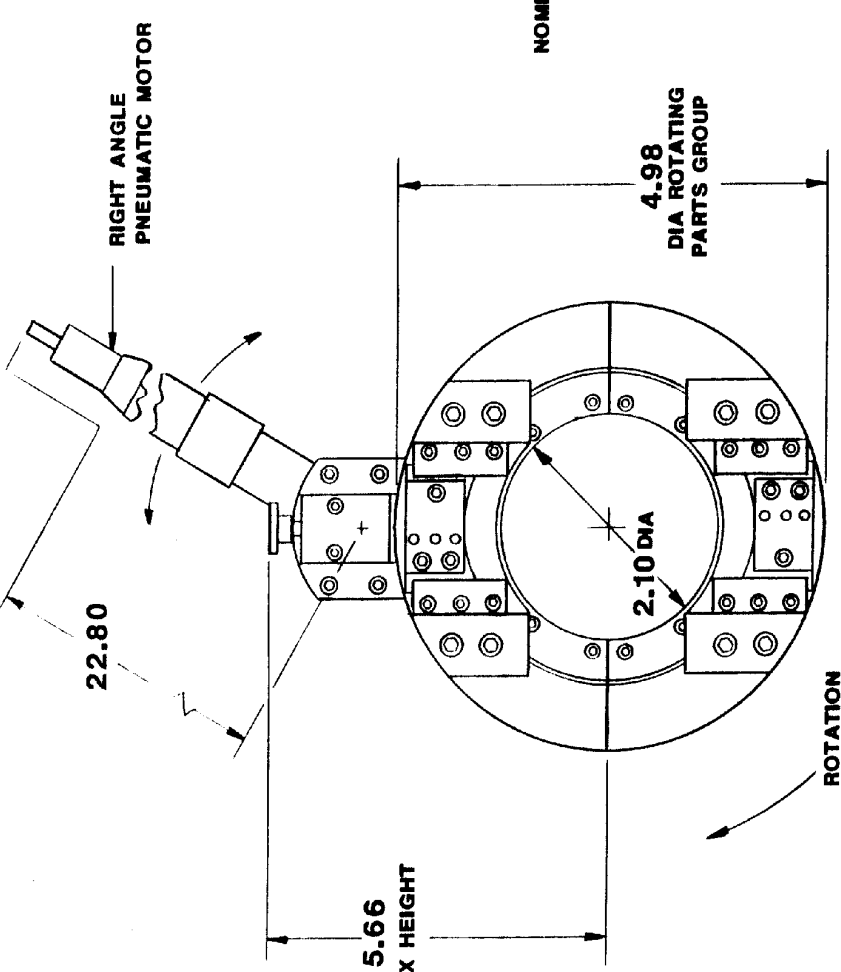
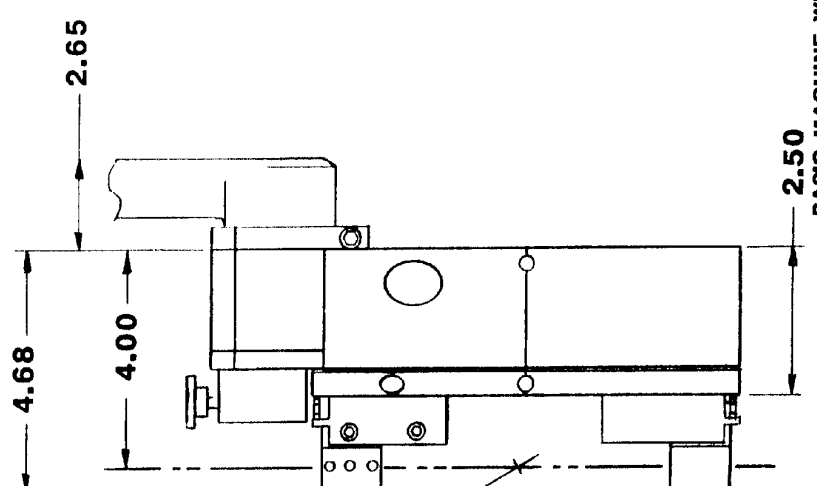
Warranty (limited), parts and/or equipment are warranted against defects in material and workmanship for a period of one year from date of purchase. Full details supplied on request and/or with tools.

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



DWG. NO. 77-0617 SH REV.

REV.	DESCRIPTION	DATE	APPROVED



QTY REQD	FRGM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION

<p>UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES TOLERANCES ARE:</p> <p>DECIMALS FRACTIONS ANGLES</p> <p>.XX ±.03 ± 1/16 ° 30'</p> <p>.XXX ±.010</p> <p>MACHINED SURFACES 125 μ</p> <p>± TO BE CONCENTRIC WITHIN .010 TR</p> <p>FLATNESS TO WITHIN .010 TR</p> <p>BREAK ALL SHARP EDGES .005-.015</p> <p>FILLET RADIUS TO BE .030 MAX</p> <p>C-SINK THD HOLES TO MAJ DIA X 42°</p>	<p>CONTRACT NO.</p> <p>DATE 4/20/88</p> <p>APPROVALS</p> <p>DRAWN HAMSAW</p> <p>CHECKED</p> <p>REMOVED</p>
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<p>602TSB USED ON</p>	<p>SCALE NONE</p>
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<p>TRITool INC.</p> <p>3008 SECURITY PARK DRIVE, RANCHO CORDONA, CA 95742</p>	<p>MODEL 602TSB</p> <p>ENVELOPE DRAWING</p>
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<p>SIZE B</p>	<p>FRGM NO.</p>	<p>DWG. NO. 77-0617</p>	<p>REV.</p>
<p>DO NOT SCALE DRAWING</p>	<p>SHEET 1</p>	<p>OF 1</p>	<p>REV.</p>