



TRI TOOL INC.

TRI TOOL INTERNATIONAL INC.

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TRI TOOL INC. TECHNICAL SPECIFICATION V22 TUBE CUTTER KIT JUNE,2000

MODEL V22 TUBE CUTTER KIT

The Model V22 Tube Cutter Kit is a series of different size tube cutter heads with a common drive unit, each head is designed to sever one size of in-line tube. Individual tube size machines are available in the range from 3/16" through 1" for use in areas where access and space around the tube is limited.

The Model V22 Tube Cutter Kit comes complete with:

- A. 8 Cutter Head sizes
- B. 8 Squaring Fork Assemblies
- C. One Pneumatic drive Motor
- D. One 18" Flex Drive Assembly
- E. A Spare Parts Kit and Tool Kit
- F. Custom Case

Design and Operating Features:

1. Compact size allows access into areas that have limited clearance problems.
2. Horseshoe type head design allows for easy installation and removal from the tube.
3. Machine is self-centering for quick and easy mounting.
4. Manually actuated squaring forks latch the cutter head to the tube to hold the head square to the tube.
5. Each tool is equipped with an autofeed mechanism for ease of operation.
6. Chipless cutting wheel (metal displacement cutter) provides extremely long life.
7. A removable pin allows the cutting wheel to be changed when necessary.
8. A pneumatic drive system for use in hazardous areas is standard
9. The drive system has a quick disconnect system for quick and easy changes from one size machine to another.

10. Centerline marking for accurate positioning of cut.
11. Cutter heads may be operated with motor connected directly, or through an 18" flex drive.

Specifications

1. Reference Envelope Drawing No. 77-1635
2. Material and Cutting capacities:

Materials include, but are not limited to: carbon steel, low alloy steel, chrome steel, chrome / molly alloys (Rc 32 max.), stainless steel, titanium, inconel, copper, aluminum and copper nickel alloys. Listed below are examples of some materials and wall thicknesses.

<u>Model No.</u>	<u>Tube Size (Dia.)</u>	<u>Aluminum</u>	<u>Stainless Steel</u>	<u>Titanium</u>
550 – 03	.188" (4.76mm)	.065" (1.7mm)	.065" (1.7mm)	.065" (1.7mm)
550 – 04	.25" (6.35mm)	.065" (1.7mm)	.065" (1.7mm)	.065" (1.7mm)
550 – 05	.312" (7.94mm)	.065" (1.7mm)	.065" (1.7mm)	.065" (1.7mm)
550 – 06	.375" (9.53mm)	.065" (1.7mm)	.065" (1.7mm)	.065" (1.7mm)
550 – 08	.50" (12.7mm)	.095" (2.4mm)	.100" (2.54mm)	.100" (2.54mm)
550 – 10	.625" (15.9mm)	.125" (3.2mm)	.100" (2.54mm)	.100" (2.54mm)
550 – 12	.75" (19.1mm)	.095" (2.4mm)	.100" (2.54mm)	.100" (2.54mm)
550 – 16	1.00" (25.4mm)	.095" (1.7mm)	.100" (2.54mm)	.100" (2.54mm)

3. Clearances: (see envelope drawing).
4. Approximate weights:

<u>Model No.</u>	<u>(lbs.)</u>
550 – 03	.75 lb (.34 kg)
550 – 04	.75 lb (.34 kg)
550 – 05	.75 lb (.34 kg)
550 – 06	.75 lb (.34 kg)
550 – 08	2.25 lb (1.02 kg)
550 – 10	2.47 lb (1.12 kg)
550 – 12	2.65 lb (1.20 kg)
550 – 16	3.16 lb (1.43 kg)

5. Special Purpose Accessories:
 - a. Manual drive Systems (special order only)
 - b. Electric Drive Systems (special order only)

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/or equipment are warranted against defect in material and workmanship for a period of one year from the date of purchase. Full details supplied on request and/or with tools.

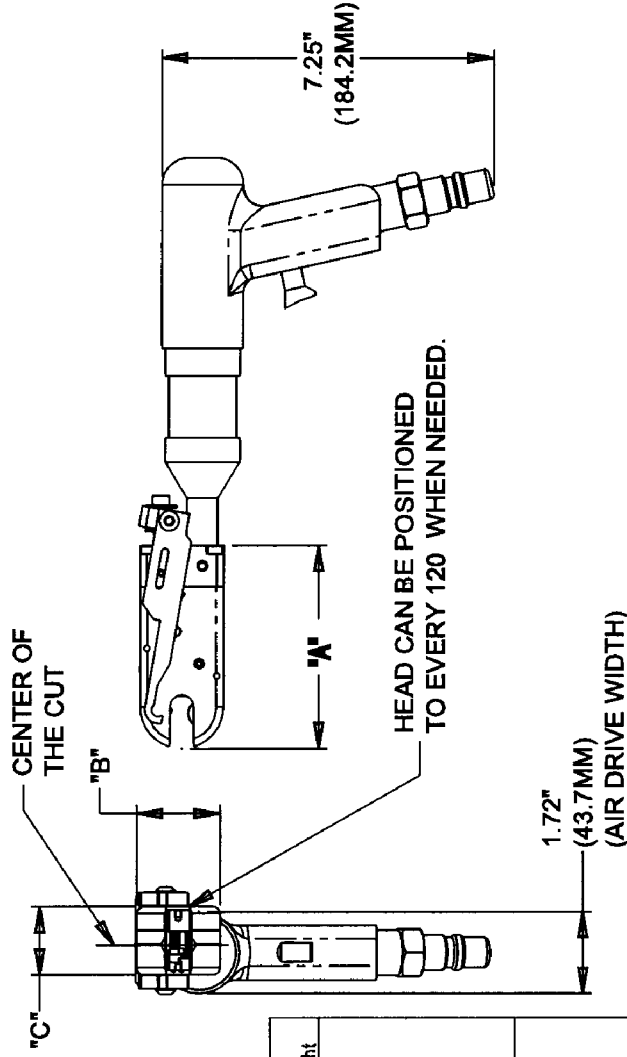
Filter, regulator, lubricator required to protect warranty on air powered tools.

REVISIONS

REV.	DESCRIPTION	DATE	APPROVED

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 PROPRIETY PROPERTY OF TRI TOOL INC
 NO REPRODUCTION, USE, OR DUPLICATION OF THE
 DESIGNS SHOWN HEREON IS PERMITTED WITHOUT
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 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742
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DWG No. 77-1635 SHT 1 REV



Model No.	P/N	Tube Size	A	B	C	Weight
550-03	01-1062	3/16" (4.8mm)	3.67" (93.2mm)	1.50" (38.1mm)	1.25" (31.8mm)	.75 lb (34kg)
550-04	01-1063	1/4" (6.4mm)	3.67" (93.2mm)	1.50" (38.1mm)	1.25" (31.8mm)	.75 lb (34kg)
550-05	01-1064	5/16" (7.9mm)	3.67" (93.2mm)	1.50" (38.1mm)	1.25" (31.8mm)	.75 lb (34kg)
550-06	01-1009	3/8" (9.5mm)	3.67" (93.2mm)	1.50" (38.1mm)	1.25" (31.8mm)	.75 lb (34kg)
550-08	01-1065	1/2" (12.7mm)	4.36" (110.7mm)	2.25" (57.2mm)	1.53" (38.9mm)	2.25 lb (1.02kg)
550-10	01-1066	5/8" (15.9mm)	4.53" (115.1mm)	2.38" (60.5mm)	1.53" (38.9mm)	2.47 lb (1.12kg)
550-12	01-1067	3/4" (19.1mm)	4.63" (117.6mm)	2.50" (63.5mm)	1.53" (38.9mm)	2.65 lb (1.20kg)
550-16	01-1068	1" (25.4mm)	5.02" (127.5mm)	2.75" (69.9mm)	1.53" (38.9mm)	3.16 lb (1.43kg)

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MODEL V22 TUBE CUTTER KIT ENVELOPE DRAWING

SIZE **A** SOLIDWORKS DWG. NO. **77-1635** REV.

SCALE **1/1** CAD MODEL: **77-1635.SLDPRT** SHEET **1 OF 1**

CONTRACT NO.

APPROVALS

DRAWN: 6-15-00

CHECKED

ISSUED

DO NOT SCALE DRAWING

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 RADIUS TO BE .030 MAX

C.SINK THD HOLES TO MAJ DIA X.82 .90