Updated 1/22/2026

TECHNICAL SPECIFICATION
MODEL 202TS TUBE SHEET CUTTER

The Model 202TS Tube Sheet Cutter is an ID mount machine tool for facing and chamfering the ends of tubing and tube sheet bores in preparation for welding and finish squaring.

The Model 202TS System comes complete with:

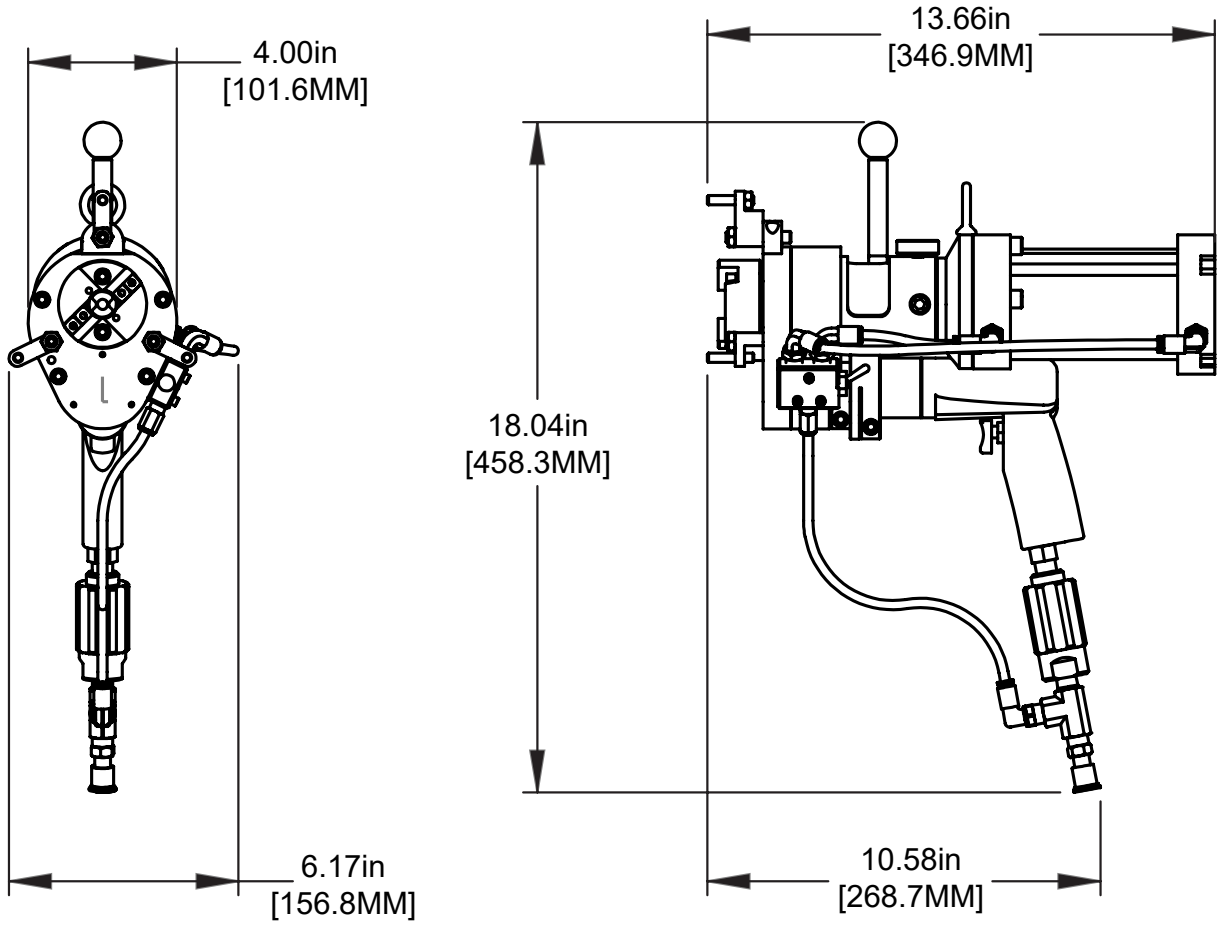
- Model 202TS Sub-Assembly
- Head Kit, 2” DIA
- Air Motor Assembly
- Mandrel Assembly
- Wrench Kit
- Carrying Case
- Operator’s Manual

Design and Operating Features

- The lathe accepts its torque through the mandrel.
- The expanding mandrel provides fast, accurate self-centering and alignment.
- All wrenches needed for operation are provided with the system.
- The lathe, at less than 17 lbs. (7.7 kg), is lightweight and is easily handled by one operator.
- Pneumatic clamping system.
- Mandrel shaft seal to keep coolant out of the gears.
- Heat-treated mandrel mounting blocks for maximum life and secure mounting.
- Adjustable stops to set mounting and/or cut depth.
- Hoist ring for attachment to an overhead balancer.

Specifications

Reference Envelope Drawing No. 77-1528



Clearance and Dimensions

Weight	16.5 lbs. (7.5 kg)

Pipe Cutting Capacities

Basic Tube Sizes

A maximum OD of 2.00” (50.8mm) and a minimum ID of .77” (19.6mm) may be faced with the Model 202TS.

Wall Thickness Capacity

Wall thickness of all standard tube sizes (.187” [4.8mm] maximum) in the range listed. Contact Tri Tool Technologies for heavier wall procedures.

Counterboring Operations

The tool will chamfer tubing with an ID range of 1.00” (25.4mm) to 2.00” (50.8mm) with the standard mandrel of .77” (19.6mm) to 2.00” (50.8mm) with the optional small mandrel.

Optional Small Mandrel

Mounting range of .50” (12.7mm) ID to .78” (19.8mm) ID.

Material Cutting Capabilities

Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel alloys and aluminum without limitations except size and wall thickness as specified.

Inconel and some other high temperature alloys may require special procedures as a function of wall thickness and type of end preparation. Contact Tri Tool Technologies for more information.

Cutting Head Speeds

Maximum Cutting Head Speed	275 RPM
Cutting Head Speed at Maximum H.P.	138 RPM
Functional Speed Range	35-200 RPM
RPM at 300 Surfrace Inches per Minute	2.00” (50.8mm)/48 RPM .50” (12.7mm)/191 RPM

Drive System

Final Drive	Gear Driven
Pneumatic Motor	
Free Speed	400 RPM
Max. H.P. Speed	200 RPM

Power Requirements

Pneumatic Motor requires 30 cfm (14 L/s) air supply at 90 PSI (621 kPa) for maximum horsepower delivery.

NOTE: Air Supply must have a filter/regulator/lubricator (FRL) system to protect the warranty on the Air Motor.

Speed Control

On/off safety lever valve and twist-type air flow control valve.

Feed

Manual: a lever arm actuated feed mounted at rear of the 202TS provides .560” (14.2mm) of travel.

Mounting

Pneumatically-actuated draw rod expands mandrel ramp blocks.

Note To The Customer

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 Technologies 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 equipment are warranted against defects in material and workmanship for a period of one (1) year from date of purchase. Full details supplied on request and/or with the tools.

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