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TECHNICAL SPECIFICATION MODEL 572AC SEVERMASTER™

The Model 572AC SEVERMASTER™ severs .25" (6.4mm) to 2" (50.8mm) diameter tubes and thin wall pipe within the size range. This machine enhances productivity by incorporation of an Auto-Cycle Tool Module and Quick Lock Collet Closure. The Auto-Cycle Tool Module incorporates a cam cycle tool bit feed mechanism which automatically returns the tool bit to the home position ready to start the next cut. The tool module also allows setting the start and finish cut positions to minimize the cycle time. The feed increment per revolution is adjustable to match the cutting relative to the material. A variable speed motor provides cutting speed control for tool bit life and ID burr condition. The Quick Lock mechanism actuates the collet with a single lever stroke for simple collet changes.

Tool bit options are available to minimize the burr on the mounting side or the drop-off side of the sever line and in different edge widths to match the tube wall thickness. The tool also incorporates mounting features to allow use of an SQM-1AC Tube Squaring module for optimum burr-free ends.

The Model 572AC SEVERMASTER™ comes complete with:

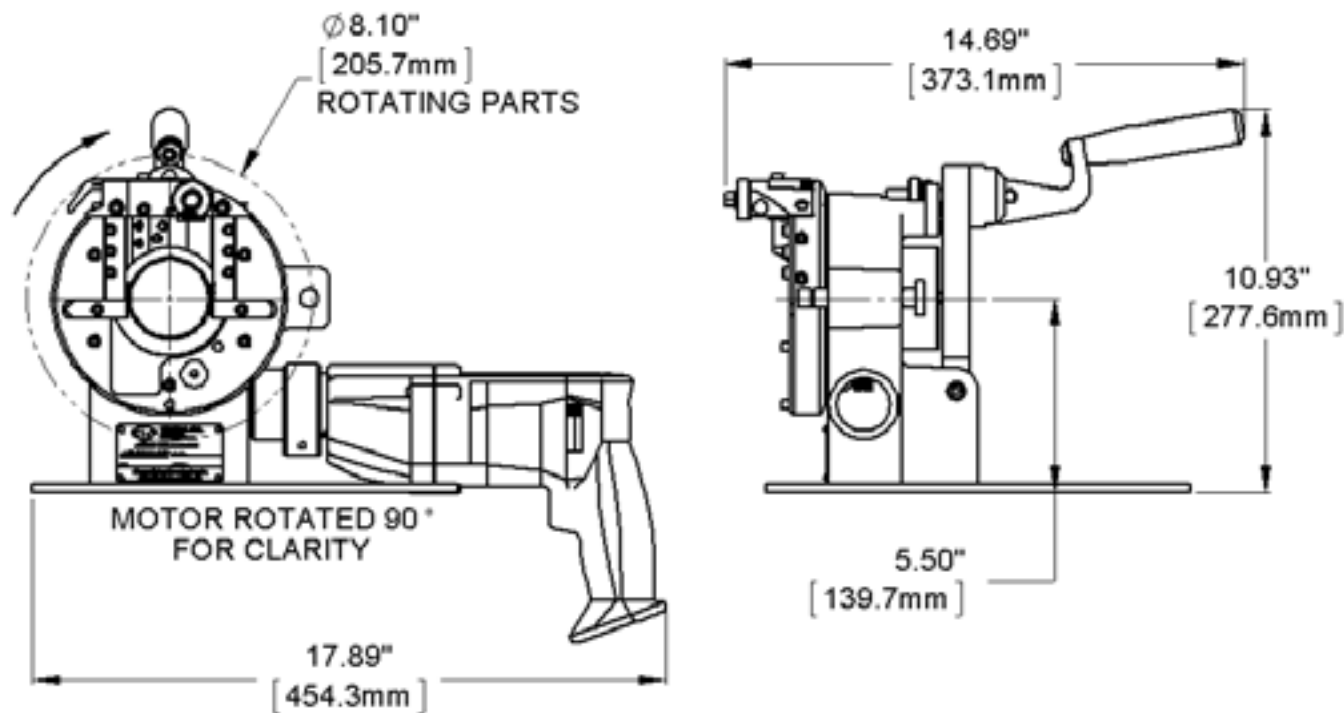
- Model 572AC Subassembly
- Electric Motor Assembly
- Bench Stand
- Severing Bit
- Carrying Case
- Wrench Kit
- Operator's Manual

Design and Operating Features

- The 572AC accepts its own torque through the collet clamping system.
- The collet provides accurate centering and full diameter support for minimum distortion of thin wall tubing.
- Gear driven powerhead rotates on a precision cross roller bearing.
- Single lever actuation of collet
- Gears are all enclosed for operator safety.
- All tools needed for operation are provided with the system.

Specifications

Reference Envelope Drawing No. 77-1516



Weight

Machine Assembly	29.0 lbs. (13.1 kg)
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Clearance and Dimensions (Base Machine)

Maximum rotating head diameter	8.10" (205.7mm)
Length over motor (Electric)	17.89" (454.3mm)
Length parallel to axis of pipe (Electric)	14.69" (373.1mm)

Pipe Cutting Capacities

Basic Pipe Sizes

1/8" through 3/8"	All Schedules
1/2" and 3/4"	Schedules 5 through 40
1" through 1 1/2"	Schedules 5 & 10

Basic Tube Sizes

.25" (6.4mm) through 2.00" (50.8mm) with wall thickness up to .125" (3.2mm)

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

Electric motor:

Low 60 RPM

High 120 RPM

Feed

Autofeed system adjustment from .001" (.02mm) to .005" (.13mm) per revolution.

Mounting

Manually actuated collet clamping system.

Tool Bits

99-3036 Sever tool bit (leaves a burr on the tube that the machine is mounting on).

99-2959 Sever tool bit (leaves a burr on the tube that falls off after severing).

Accessories

- Tube Squaring Module (SQM-1AC)
- Pneumatic Drive System: Available on request

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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