

TECHNICAL SPECIFICATION MODEL PFM 614 PIPEMASTER™ SYSTEM

The Model PFM 614 PIPEMASTER™ is a portable OD mount machine tool for beveling and facing 6" through 14" pipe. The tool is configured with a dual hydraulic drive motor powering a set of helical gears attached to the main spindle. An auto-feed hydraulic cylinder with rapid and slow feed control, provides accurate cutting head control. One hydraulically actuated OD clamping head assembly with mounting pads covers the whole range of the tool.

The Model PFM 614 PIPEMASTER™ System comes complete with:

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| • Model PFM 614 Sub-Assembly | 1 ea. |
| • ID Tracking Tool Modules Assembly | 3 ea. |
| • Mounting Pads | 5 ea. |
| • Hydraulically Powered OD Clamping Head | 1 ea. |
| • Lathe Lifting Frame Assembly | 1 ea. |
| • Drive Motor Assembly | 2 ea. |
| • Wrench Kit | 1 ea. |
| • Operator's Manual | 1 ea. |

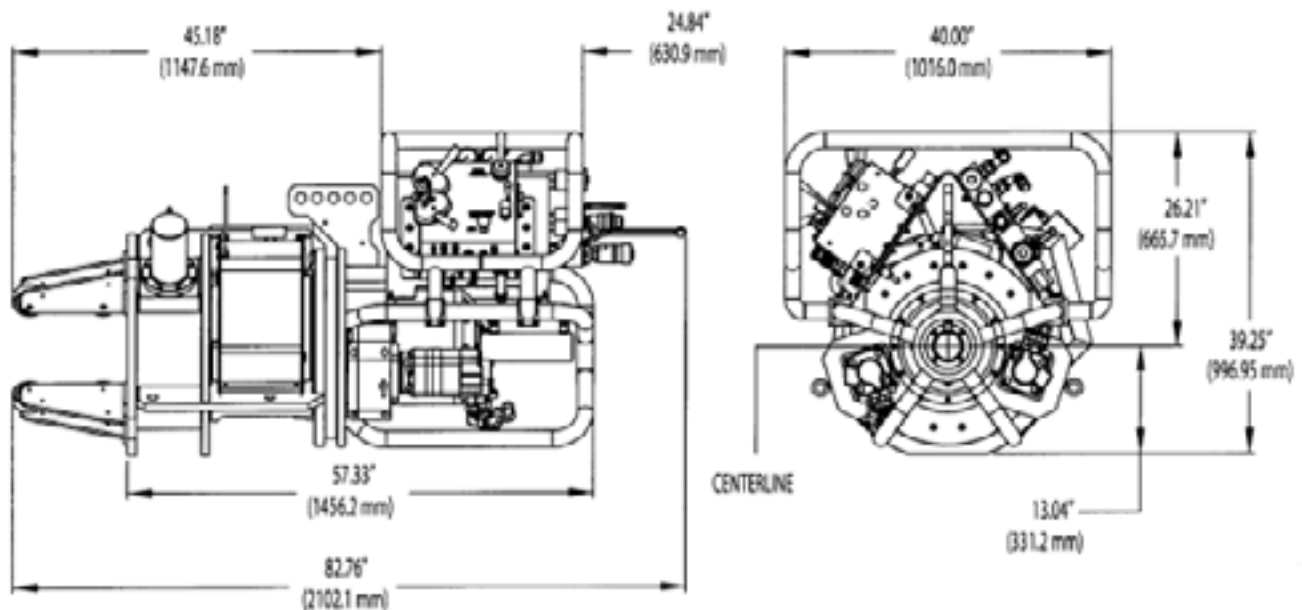
Design and Operating Features

- The tool accepts its own torque through the OD clamping head.
- The OD clamping head provides, fast and accurate clamping of the pipe.
- All wrenches needed for operation are provided with the system.
- The lathe is provided with lifting frame.
- The OD clamping head provides a maximum of 50,000 lbs. of clamping force at 2000 PSI.
- The OD clamping head covers the full mounting range of the tool.
- The power train uses a precision helical cut gear system, for a more precise weld preparation.
- The lathe has an infinitely adjustable feed valve for accurate and smooth cutting.
- Five and a half inches (5 1/2") of feed travel allows easier and more forgiving axial positioning.
- The extra feed travel allows the tool to handle heavier pipe wall thickness.
- Three (3) ID Tracking Tool Modules allows distributing the cutting loads to more tool bits to handle greater wall thickness.
- Three (3) torque acceptance bars insure greater torque handling and a balanced load for accurate facing.

- The hydraulic drive system delivers smooth operation.
- A switched chip guard is supplied for the safety of the operator.
- An interlocking safety mechanism is also supplied to avoid unclamping the OD clamping head while the headstock is rotating.

Specifications

Reference Envelope Drawing No. 77-1701



Weight

2650 lbs. (1202 kg)

Clearance and Dimensions

Maximum Rotating Head DIA	17.375" (441.3 mm)
Length, approximate (parallel to axis of pipe)	82.76" (2102.1 mm)
Available Feed Travel	5.50" (139.7 mm)
Standard Minimum Straight Mounting Length	11" (280 mm)

Pipe Cutting Capacities

Basic Pipe Sizes

6" through 14" pipe with wall thickness as specified below.

Basic Tube Sizes

6.63" (168.4 mm) OD tubing with a maximum OD of 14.00" (355.6 mm).

A minimum ID of 4.89" (124.2 mm) may be beveled with the standard system.

Wall Thickness Capacity (Limitations)

Wall thickness of all standard pipe schedules [2.48" (63.0 mm) max.] in the range listed.

Tubing or pipe with greater wall thickness may be handled provided the ID is equal to or greater than 4.89" (124.2 mm) and the OD is equal to or less than 14.00" (355.6 mm).

Contact Tri Tool Technologies for heavier wall procedures.

Material Cutting Capabilities

Mild steels, chrome steels (Rc 30 max), with no limitations as specified.

Stainless steel, copper-nickel alloys, Inconel, and some other high temperature alloys may require special procedures as a function of wall thickness and type of end preparations.

Contact Tri Tool Technologies' Engineering Department for details.

Cutting Head Speeds

Hydraulic Drive (maximum, approximate)	152 RPM
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Drive System

Dual Hydraulic Drive

Requires separate hydraulic power supply. (Ref: TRI TOOL Inc. HPU 75-60/5)

Power Requirements

60 GPM and 2000 PSI

5 GPM at 2000 PSI

Feed

Hydraulic powered cylinder with fast feed control in both directions and fine adjustment feed for cutting.

Mounting

Hydraulic cylinder actuates mounting head clamping blocks.

Accessories

- Electric 60 GPM Power Unit
- Diesel 60 GPM Power Unit
- 4" Pipe Kit (Includes Tooling Plate, Tool Modules and Mounting Feet)

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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