Updated 9/19/2024

TECHNICAL SPECIFICATION
MODEL SUREFIRE 4 FACING/BEVELING SYSTEM

Pipe facer/beveler featuring Surefire quick change mounting pads for clean, square weld preps on 2” to 4” SCH 5/10 pipe. The through hardened mandrel, solid milled body with a heavy-duty gear set, and tapered roller bearings ensure rigidity and reliability. The machine is lightweight, and has adjustable torque keys that prevent cutting vibrations producing smoother cuts.

The Model Surefire 4 System comes complete with:

- Model Surefire 4 Sub-Assembly
- Surefire Mount Pad Set (for one pipe size and schedule)
- Electric Motor Assembly
- Mandrel Assembly
- Wrench Kit
- Carrying Case
- Operator’s Manual

Special Features

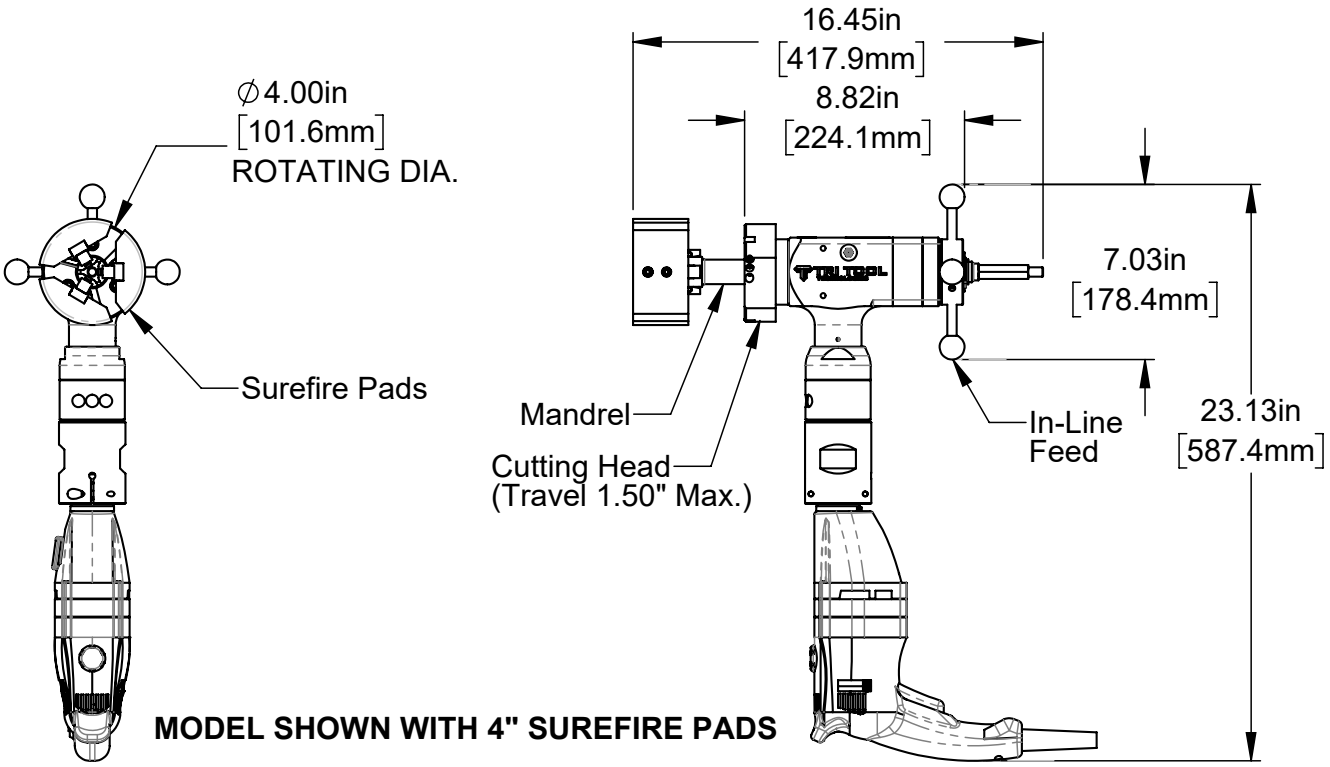
- Surefire Pads for equal distribution contact along inner wall of pipe
- Mandrel shaft heat treated to Rc 50 for optimum strength and hardness minimum wear
- Heavy-duty tapered mandrel and spindle bearings
- Mandrel shaft seal to keep coolant out of the gears
- Heat-treated mandrel mounting blocks for maximum life and secure mounting
- Heavy duty gear reduction for optimum performance

Design and Operating Features

- The lathe accepts its own 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 is lightweight, at 25 lbs. (11.3 kg)
- Easily handled by one operator
- All tools needed for operation are provided with the system

Specifications

Reference Envelope Drawing No. 77-1865



MODEL SHOWN WITH 4" SUREFIRE PADS

Clearance and Dimensions

Weight	25.0 lbs. (11.3 kg)

Pipe Cutting Capacities

Basic Pipe Sizes (Schedules 5S & 10S to all sizes)*

2” pipe	2 1/2” pipe
3” pipe	4” pipe

*Custom Surefire pad sizes available on request

Wall Thickness Capacity (Limitations)

Wall thickness of schedules listed, .120” (3 mm) maximum, in the range listed can be machined without limitations.

Duty Cycle

The Surefire 4 with an electric motor (P/N 58-0147 or equivalent) duty cycle on high-cutting load applications (see above), is limited to 50% ‘On’ time with a maximum of five (5) minutes continuous ‘On’ time.

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

Low Range	0-14 RPM
High Range	0-42 RPM

Drive System

Final Drive	Gear Driven (6:1 gear reduction)

Power Requirements

Electric Drive Motor	110 VAC, 50/60 Hz, 9.6 A
	220 VAC, 50/60 Hz, 5.7 A

Speed Control

On/off trigger with variable speed.

Feed

Manual-Feed Handle is inline at the back of the machine. Feed rate is .100” (2.5mm) per revolution of the feed handle.

Maximum available feed travel is 1.50” (38.1 mm)

Mounting

Manually-actuated draw rod expands mandrel ramps and jaw 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.

www.tritool.com

@tritooltechnologies

@tritooltech

@tritooltechnologies

SCAN OR CLICK

3041 Sunrise Blvd

Rancho Cordova, CA 95742

+916-288-6100

+1-800-345-5015

Fax 916-288-6160