

TRI TOOL INC  
TECHNICAL SPECIFICATION  
300 MICROFACER™ TUBE FACING AND SQUARING TOOL  
March , 1998

300 MICROFACER™ TUBE FACING AND SQUARING TOOL

The Model 300 MICROFACER™ Tube Squaring Tool is designed specifically to prepare tubes for autogenous welding. The 300 MICROFACER™ will face (square) .125" to .750" (3.2 mm to 19.1 mm) outside diameter tubing with a wall thickness up to .125" (3.2 mm). The 300 MICROFACER™ uses an OD saddle clamping system for holding and rounding the tube. The 300 MICROFACER™ accepts its own torque through the saddle clamping system. The standard saddle clamping system requires a straight length of tube .22" (5.6 mm) long. Speed control is provided with a variable speed cordless electric drive. Feed is provided by a cam actuated feed handle at right angles to the cutter head.

The Model 300 MICROFACER™ System comes complete with:

A.	Model 300 MICROFACER™ Sub Assy.	1 ea.
B.	9.6V Cordless Motor Assy.	1 ea.
C.	Extra Battery Pack	1 ea.
D.	Battery Charger	1 ea.
E.	Wrench Kit	1 ea.
F.	Carrying Case	1 ea.
G.	Operator's Manual	1 ea.

Design and Operating Features:

1. The 300 MICROFACER™ accepts its own torque through the Saddle Clamping System.
2. The cutting head accepts Squaring Tool Bits.
3. All required wrenches for operating the 300 MICROFACER™ are supplied with the machine.
4. The Model 300 MICROFACER™ is lightweight and easy to handle.

Specifications:

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1. Material cutting capabilities:
  - a. Basic tube sizes: .125" through .750" (3.2 mm to 19.1 mm) with wall thickness up to .125" (3.2mm).
  - b. Outside diameter mounting range: .125" to .750" (3.2 mm to 19.1 mm) OD.
  - c. Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel and aluminum without limitations other than size and wall thickness as specified.
  - d. 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's Engineering Department for details.
  
2. Clearances and dimensions: (300 MICROFACER™ cordless drive)
  - a. See envelope dwg. 77-1589
  - b. Available Feed Travel .200" ( 5.1 mm )
  - c. Weight:
 

Cutting Head	1.55 lbs (.70 Kg.)
Cutting Head and Motor	5.35 lbs (2.4 Kg.)
  
3. Drive system:
  - a. A variable speed Cordless Electric Drive Motor
 

Free speed:	540 rpm
Normal working speed range:	120-380 rpm
Power requirements:	9.6 VDC, Battery Power Pack.
  
4. Mounting:
 

Manually actuated clamp.
  
5. Feed:
 

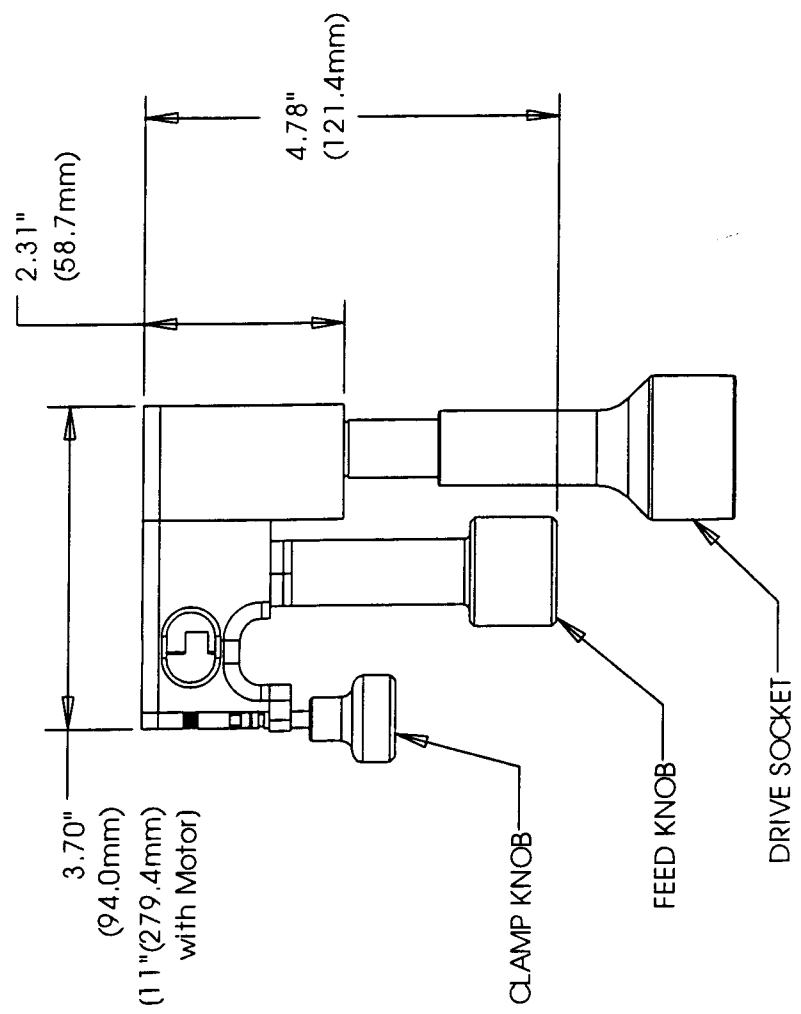
Manual - A cam actuated feed handle is mounted at right angles to the cutting head and provides .200" (5.1 mm) of travel.


Spare parts and standard Tool Bits are available from stock.

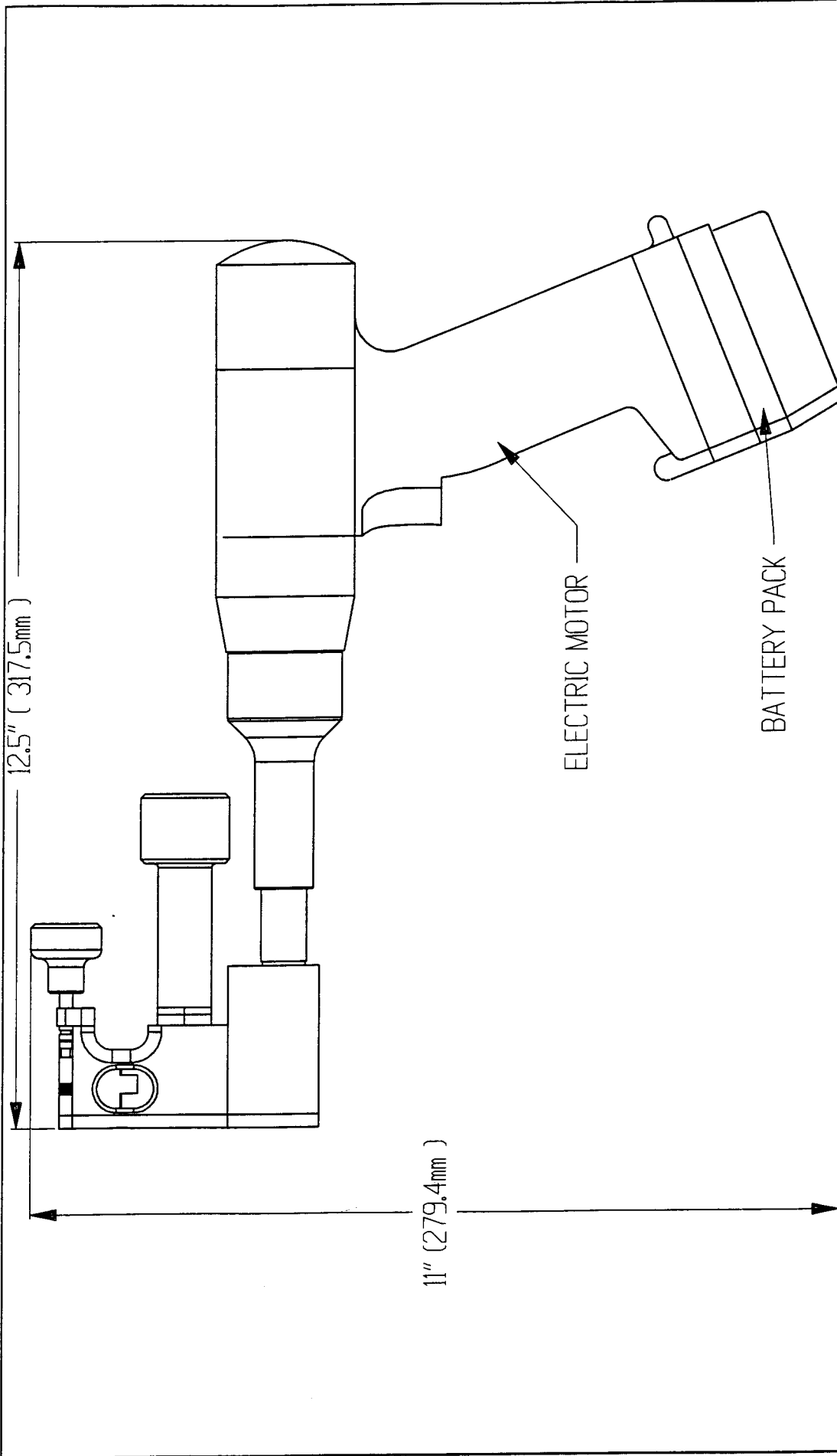
Engineering design services for custom Tool Bits and special function modifications are available from the factory.

All Tri Tool 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 defects in material and workmanship for a period of one year from the date of purchase. Full details will be supplied on request and/or with the tools.



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<b>APPROVALS</b>		<b>DATE</b>		<b>ENVELOPE DRAWING</b>	
DRAWN M POUND		10/3/97		<b>300 MICROFACER</b>	
CHECKED				SIZE SOLID WORKS DWG. NO. <b>77-1589</b> REV.	
ISSUED				SCALE <b>1 / 2</b> CAD MODE. PtoE SHEET <b>1 OF 2</b>	



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CONTRACT NO. ER8131

APPROVALS	DATE
DRAWN R MORGAN	10/3/97
CHECKED	
ISSUED	

ENVELOPE DRAWING  
 300 MICROFACERS

SIZE <b>A</b>	CAD AVAILABLE	DWG. NO. 77-1589	REV.
SCALE 1/2		SHEET 2 OF 2	