Maintenance

Keep the tool clean and free from chips when not in use. During repeated use, ensure chip build-up does not occur. Use a chip brush to clear chips.

All components should be clean and coated with a light film of oil prior to use. Use a clean, non-detergent oil, which is specified for air motor.

When the tool is to be stored or left out of service for 30 days or more it should be thoroughly cleaned and wiped down.

Safety Precautions

Use standard safety equipment such as hard hats, safety glasses, protective clothes, and other safety devices when appropriate.

Operate this tool only in accordance with operating instructions. Only personnel who are trained or are being trained may operate the equipment.

Do not use damaged tools. Always check your tools for damage especially if a tool has malfunctioned, been dropped or hit.

Store tools properly. Disconnect tools from the power source, remove blades/bits, and store in a safe place.

Use the right tool for the job. Contact Tri Tool Technologies to help with your application.

Notes

TRI TOOL TECHNOLOGIES

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For more information on engineered solutions, products, and trainings, visit tritool.com or contact our engineers at +1 (916) 288-6100.

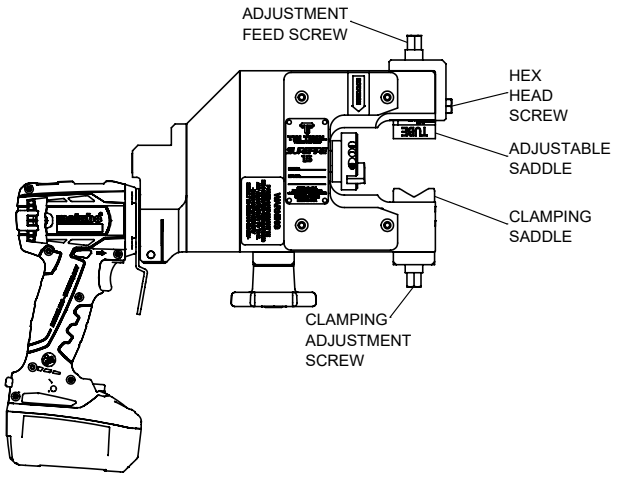
Quick Start Guide

SUREFIRE 1.5

The SUREFIRE 1.5 is a Pipe Beveler designed for facing and/or beveling pipe or tube ends in preparation for welding.

The SUREFIRE 1.5 uses Adjustable Saddle Assemblies to machine pipe and tube having an OD of .25” (6.4mm) to 2.00” (50.8mm), and comes with 1.45” and 2.00” DIA Cutting Head Kits.

The SUREFIRE 1.5 is available with either a cordless electric motor, or an air motor.



P/N 92-2086

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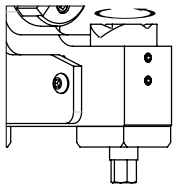
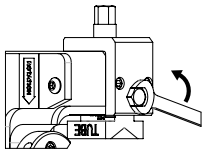
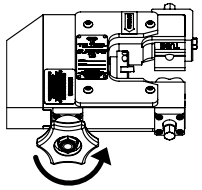
Preparing the Cut



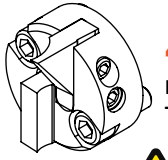
1 Orient the Clamping Saddle as shown in the Adjustable Saddles chart by loosening set screws and rotating into position.



2 Loosen Hex Head Screw to raise or lower the Adjustable Saddle using the pipe/tube size indicators.

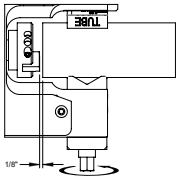


3 Retract Cutting Head completely by rotating Feed Knob counterclockwise.



4 Install the correct Tool Bit for the material to be cut (see tables for Tool Bit specs).

WARNING: To prevent injury, disconnect power from tool before changing tool bit.



5 Insert pipe into Saddle, leaving 1/8” gap, and clamp by tightening the Clamping Adjustment Screw.

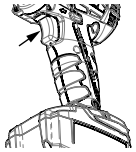
Tool Bits*

Range (ID) 2.00” DIA	Beveling	Facing
.125” (3.2mm) - .928” (23.6mm)	99-4032	99-4000
.664” (16.8mm) - 1.470” (37.3mm)	99-4034	99-4000
.900” (22.9mm) - 1.550” (39.4mm)	99-4132	99-4000
1.220” (31.1mm) - 1.875” (47.6mm)	99-4132	99-4000

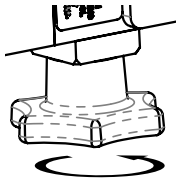
Range (ID - OD) 1.45”/2.00” DIA	Beveling	Facing
.125” (3.2mm) - 1.250” (31.8mm)	99-4032	99-4000
.800” (20.3mm) - 1.500” (38.1mm)	99-4034	99-4000
.125” (3.2mm) - 1.800” (45.7mm)	99-4132	99-4000
.800” (20.3mm) - 2.000” (50.8mm)	99-4132	99-0170

**Cobalt High Heat Tool Bits available*

Making the Cut

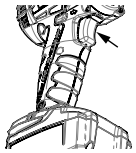


1 Depress the variable Motor Trigger according to the motor speed chart.

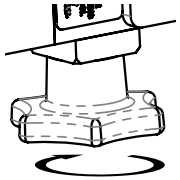


2 Rotate the Feed Knob continuously - one full turn for every six head rotations until the pipe/tube is completely machined.

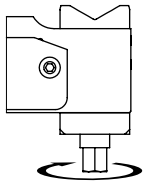
3 Discontinue Feed and allow the Cutting Head to rotate 1-3 revolutions to improve surface finish.



4 Release the Motor Trigger to stop the Cutting Head rotation.

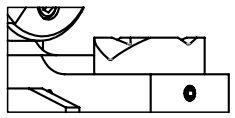
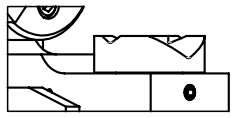


5 Rotate the Feed Knob counterclockwise to separate the Tool Bit(s) from the pipe/tube.



6 Loosen the Clamping Adjustment Screw to release the pipe/tube.

Adjustable Saddles

Range	Orientation
.250” (6.4mm) - .600” (15.2mm)	
.600” (15.2mm) - 2.000” (50.8mm)	

Cutting Head Kits *(included)*

OD Tube/Pipe	P/N
1.45” (36.8mm) DIA.	03-0037
2.00” (50.8mm) DIA.	03-0038

Motor Speeds

Nom. Pipe Size - OD	% Trigger Pull	Target RPM
NA - 0.250” (6.4mm)	100%	255
1/8” - 0.405” (10.3mm)	70%	157
1/4” - 0.540” (13.7mm)	50%	118
3/8” - 0.675” (17.2mm)	33%	94
1/2” - 0.840 (21.3mm)	??	76
3/4” - 1.050” (26.7mm)	25%	61
1” - 1.315” (33.4mm)	Minimum	48
1-1/4” - 1.660” (42.2mm)	Minimum	38
1-1/2” - 1.900” (48.3mm)	Minimum	34

Cordless Motor Speed Range: 47-220 RPM (gear 1 only)
Air Motor Speed Range: 45-375 RPM

Troubleshooting

Consult Manual 92-2078 for troubleshooting information.

Visit the Tri Tool SUREFIRE 1.5 product page for manual, demo videos and more