

TECHNICAL SPECIFICATION MODEL STS-4 TUBE SQUARING MACHINE

The Model STS-4 Tube Squaring Machine is a lightweight, portable machine designed for facing and squaring .25" (6.35mm) to 4.50" (114.30mm) outside diameter tubing up to .25" (6.35mm) wall thickness.

The Model STS-4 System comes complete with:

- Model STS-4 Sub-Assembly
- Drive Motor Assembly
- Wrench Kit
- Carrying Case
- Operator's Manual

Accessories

- Electric Foot Pedal
- Short Perch Saddle Sets
- Tool Bits
- Collet Adapter Kit (for use with 400 Series Collets)

Design and Operating Features

The Model STS-4 is available with in integral, dual range, variable speed 115VAC or 230VAC electric motor (corded or cordless).

The Model STS-4 features quick changing Saddle Sets (no tools required) and a .001" (.025mm) graduated feed dial.

The precision inside diameter saddles hold the tubing round to accurately square and face the tubing with minimum burr.

The Model STS-4 accepts its own torque through the Saddle Clamping System.

The Cutting Head accepts up to three (3) tool bits for a combination of squaring, beveling, counterboring, or facing operations simultaneously.

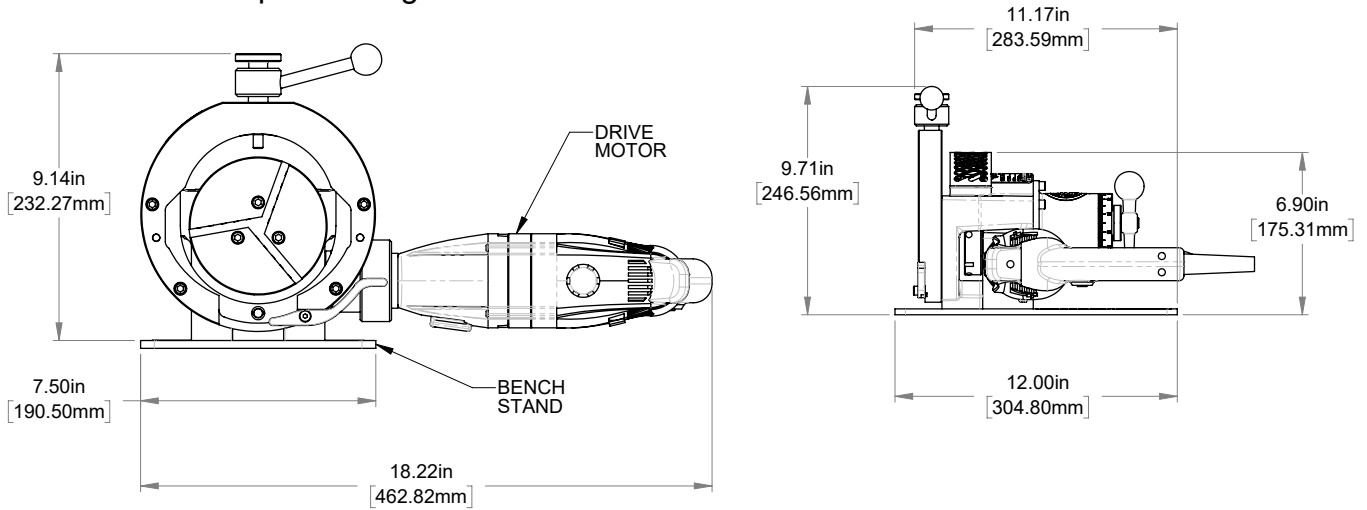
The Saddle Sets are made from stainless steel for durability and to avoid carbon contamination of high purity tubing.

All required wrenches for operation are supplied with the machine.

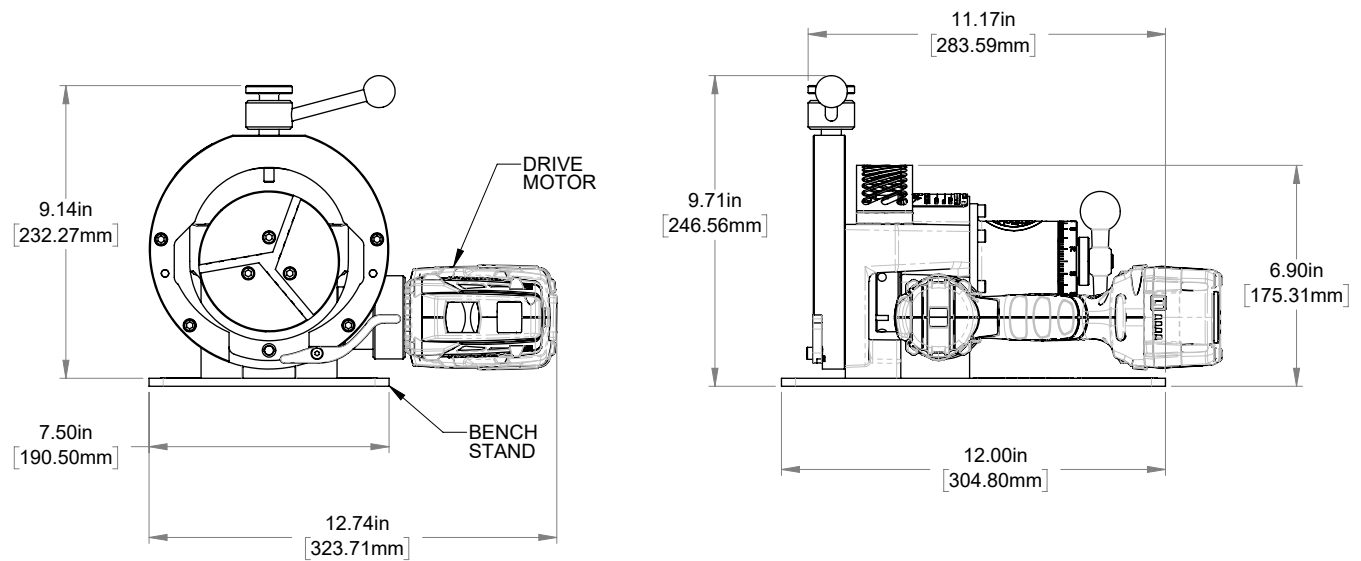
The Model STS-4 may be removed from the stand for use as a portable machine.

Specifications

Reference Envelope Drawing No. 77-1605



Reference Envelope Drawing No. 77-1872



Clearance and Dimensions

Weight:

Base Machine	12.7 lbs. (5.7 Kg)
Corded Metabo Motor	5.6 lbs. (2.5 Kg)
Cordless Metabo Motor	4.2 lbs. (1.9 Kg)
Corded Makita Motor	4.0 lbs. (1.8 Kg)

Pipe Cutting Capacities

Basic Pipe Sizes:

1/8" through 3/8" pipe	All schedules
1/2" through 1 1/4" pipe	Schedule 5 through schedule 160
1 1/2" through 2" pipe	Schedule 5 through schedule 80
1 1/2" through 4" pipe	Schedule 5 through schedule 40

Basic Tube Sizes:

.250" (6.35mm) to 4.50" (114.30mm) OD

Wall Thickness Capability:

Basic Tubing with a maximum wall thickness of .250" (6.35mm)

Material Cutting Capabilities

Mild steels, chrome steels (Rc 35 max), stainless steel, copper-nickel and aluminum without limitations other than 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 preparations. Contact the Tri Tool Technologies Engineering Department for details.

Speeds

Speed Control: Dual range, variable speed electric drive

Electric Drive Cutting Head Speeds:

Corded

Free Speed (Gear 1)	15-70 RPM
Free Speed (Gear 2)	42-200 RPM

Cordless

Free Speed (Gear 1)	0-31 RPM
Free Speed (Gear 2)	0-107 RPM

Feeds

Manual feed handle is mounted at rear of tool. It provides .560" (14.2mm) of axial feed.

Mounting

Manual saddle clamping system

Drive System

Variable Speed Electric Drive Motor (corded or cordless)

Power Requirements

Electric Drive Motor

- 115VAC 50/60 Hz 9.6 Amp Metabo Corded Motor Assembly
- 230VAC 50/60 Hz 5.7 Amp Metabo Corded Motor Assembly
- 100VAC 50/60 Hz 7.2 Amp Makita Corded Motor Assembly (Japan)
- 18VDC Metabo Brushless Cordless Motor Assembly with 115VAC Charger
- 18VDC Metabo Brushless Cordless Motor Assembly with 230VAC Charger (Type C or G)
- 18VDC Metabo Brushless Cordless Motor Assembly with 100VAC Charger (Japan)

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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