

POWERMASTER INDUSTRIAL SUPPLIES LTD

ATP SERIES - INTERNAL TUBE CUTTER

Operating manual

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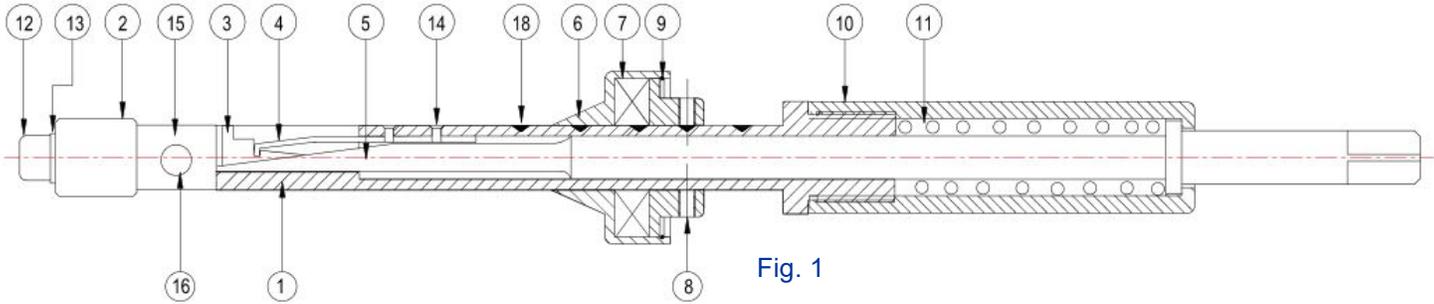


POWERMASTER PUSH TYPE INTERNAL TUBE CUTTER

- POWERMASTER ATP Series "Push Type" Internal Tube Cutter quickly cuts through the walls of ferrous, non ferrous and stainless steel tubes in condensers heat exchangers in a step to their removal from the tube sheet.
- A set of three turning pilots allows use with several tube gauges, (14-22 BWG).
- The adjustable ball bearing thrust collar suitable for reaching in to tubes of various distances.
Standard length = 4".
Reach A = 6".
Reach B = 8".
Reach C = 10".
- The Internal Tube Cutter is equipped with 3/8"sq. male drive connection.
- Quality tool steel bits available for ferrous, non-ferrous or stainless steel. Please stipulate when ordering spare bits.metals.

ATP SERIES - INTERNAL TUBE CUTTER

Parts List



Sr.	Part Name	5/8"	3/4"	7/8"	1"	1.1/4"	1.1/2"
1.	Body	621	751	871	1001	1251	1501
2.	Pilot	-	752-xx	872-xx	1002-xx	1252-xx	1502-xx
3.	Tool Bit	623	753	873	873	1253	1253
4.	Tool Bit Spring	--	754	874	874	1254	1254
5.	Mandrel	625	755	875	1005	1255	1055
6.	Collar	626	756	876	1006	1256	1506
7.	Thrust Bearing	51102	51102	51104	51104	51106	51106
8.	Thrust Nut	628	758	878	1008	1258	1508
9.	Bearing Lock	629	759	879	1009	1259	1509
10.	Spring Housing	--	7510	8710	8710	12510	12510
11.	Comp. Spring	6211	7511	8711	8711	12511	12511
12.	Cap Screw	--	7512	8712	8712	8712	8712
13.	Washer	--	7513	7513	7513	7513	7513
14.	Socket Flat Cap Screw	--	7513	7513	7513	7513	7513
15.	Body Cap	--	7514	7514	7514	7514	7514
16.	Body Cap Hole	--	--	--	--	--	--
17.	Pin punch	--	--	--	--	--	--
18.	Counter	--	--	--	--	--	--

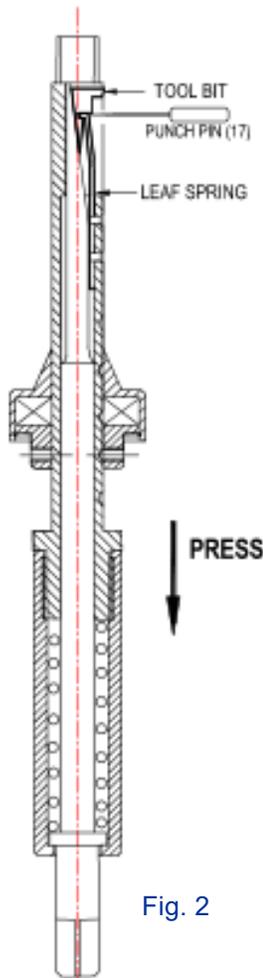
NOTE: xx = Gauge (BWG)

All parts are replaceable please call (613) 764-0572 for availability and pricing.



To Operate the ATP Series - Internal Tube Cutter

1. Select the correct Pilot (2) (guide bush) as per the tube size & its gauge.
2. Mount the pilot nose on the front side of the cutter and tighten it with the help of Cap Screw.(12).
3. Set the thrust collar at the required reach with the help of counter provided on the body & then tighten it with the grub screw.
4. Select the appropriate electric drive with appropriate Quick Change Chuck.
5. Insert the cutter into the tube, rest the thrust collar on the tube face.
6. Start the drive and gently give feed to the cutter by pushing the drive forward as it rotates.
7. The tool bit will make contact with the ID of the tube and will continue to gradually cut the tube as you continue to push the drive forward as it rotates.
8. Once cut, back out the tool which will stow the cutting bit back in its rest position for the next tube.



PROCEDURE OF REPLACING TOOL BIT: (Refer to Fig 1 & 2)

(TOOL BIT PUNCH PIN (17) required:))

Remove the Body cap (15) by inserting the pin in the given hole (16) & rotate it in an anti-clockwise direction.

Press the tool in the shown direction so that the compression spring (11) becomes compressed.

Pull the tool bit spring (4) with the help of pin punch (17).

Remove the tool bit and replace with another tool bit, leave the tool bit spring so that the edge of the tool bit spring coincide with the groove on the tool bit.

Fits the Body Cap by rotating in an clockwise direction.

Fig. 2