



E.H. WACHS

Superior Equipment. Complete Support.

SDSF

Small Diameter Split Frame

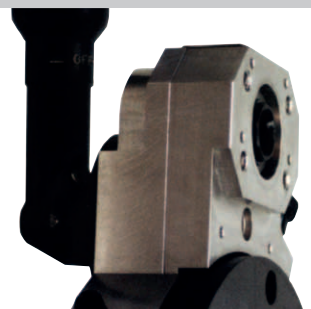
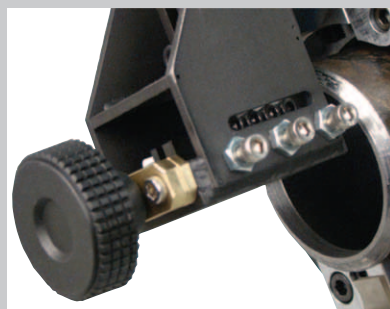
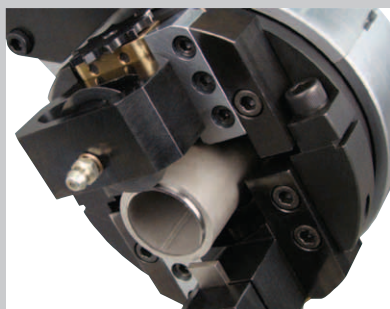
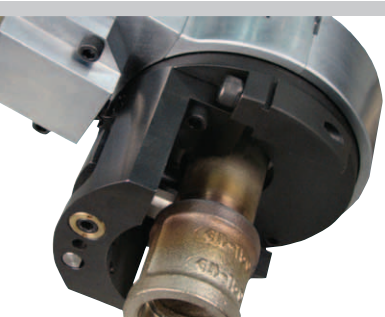
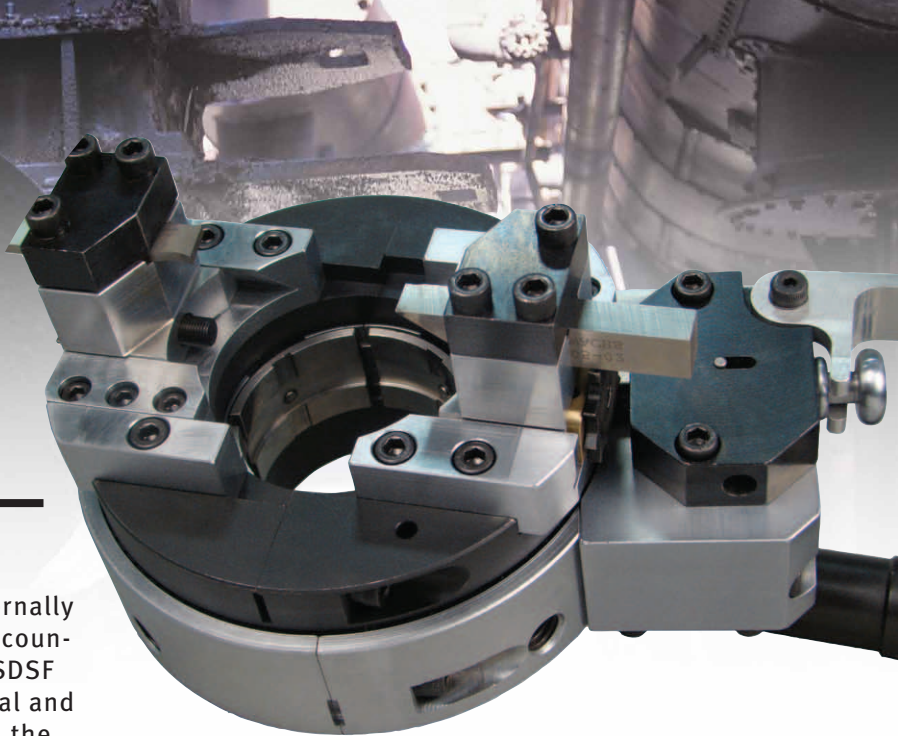
The Small Diameter Split Frame (SDSF) is an externally mounted machine tool for cutting, beveling, and counterboring pipe from 0.84" to 4.5" diameter. The SDSF is also capable of performing socket weld removal and chipless wheel cutting. Lightweight and flexible, the SDSF is optimized for low-clearance environments. It offers simple setup and operation, featuring a self-squaring clamping system for precise cutting results typically available only with fixed machine tools.

The SDSF operates on air or electric power using standard Wachs motors and adapters. A variety of tool slides and other accessories are interchangeable with all SDSF models. Best of all, the SDSF features E.H. Wachs' legendary durability, designed and built for years of reliable service.

Small Diameter Split Frame Features:

- Built to withstand greater loads than our already rugged LCSF line
- Machine quickly splits to mount around Outside Diameter of in-line pipe.
- Cuts and bevels pipe up to 7/16" wall including carbon steel and its alloys, Hastelloy™, Inconel™ and other exotic materials.
- Self-squaring pipe clamping system, using either collets or integrated, close tolerance legs with wide feet stability.
- Feed system offers low clearance operation with precise feed for controlled cutting.

- Low friction adjustable bearing system provides maximum stability and extended machine life.
- Fully enclosed bearing and drive gear system for operational safety.
- Infinite motor positioning.
- Modular tool slides.
- Lever type trip actuation for safety.
- Spring loaded axial trip for crash resistance.
- Improved radial trip geometry for crash resistance and durability.
- Improved bearing adjustment design.
- Improved durability in pinion gear bearing arrangement.
- Easier assembly and disassembly of frame halves.
- Improved sealing for chip exclusion.
- Improved collet spring design.
- Captive fasteners used for all accessories.
- Reduced fastener count for simplified inventory. Only 3 hex wrench sizes required to operate machine.
- All 2" through 4" machines can mount using collets or clamp feet.



Axial slide for socket weld removal. Wheel Cutting Module for FME cutting.

Counterbore attachment fits all models. Double drive pinion housing. Mounts securely to tool slide.

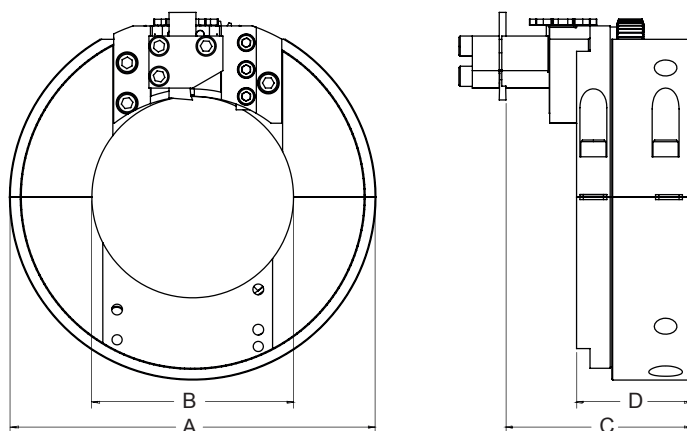
Small Diameter Split Frame (SDSF)

Specifications

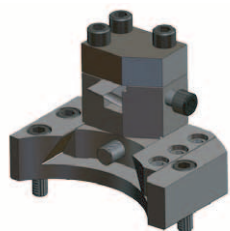
System Function:	Part off, bevel and counterbore pipe & tube; radial and axial socket weld removal; wheel cutting
System Capacity:	Machine all tube and pipe from .840" O.D. to 4.5" O.D. (21.3 - 114.3 mm) Nominal 0.5" - 4" pipe .062" to .4375" (1.6 mm - 11.1 mm) wall thickness
Cutting Tool Surface Speed:	30 Surface feet per minute , 2" 40sf/m 4"
Drive Options:	Pneumatic or electric
Air Requirements:	35 cubic feet per minute @ 90 PSI (1.0 cubic meters per minute @ 6.2 Bar)
Electrical Requirements:	110 Volt - 10 amp
Feed Method:	Star wheel
Feed Rate:	Fixed @ .0031" per trip
Construction:	Alloysteel
Tool Slide:	Radial or axial feed, cut and bevel, Counterbore, FME module
Tool Stroke:	.468" (11.9 mm)
Finish:	Hard chrome coating
Tooling:	Axial or radial socket weld removal tooling, cut/bevel tooling. High speed steel or carbide
Packaging:	Heavy duty carrying case
Standard Equipment:	Self squaring mounting system, Pinion housing, Heavy duty watertight carrying case, Operating hand tools, Operating manuals
Optional Equipment:	Electric drive, Tooling, Axial feed tool slide, Radial feed tool slide set, Bench mount, Front drive pinion housing, Counterbore attachment, FME tool slide, Aluminum collet sets, Clamp pads sets, Radial socket weld slide

Radial and axial clearance chart

Machine size	[mm]	0.039	0.039	0.039	0.039
	[inch]	1"	2"	3"	4"
Pipe Diameter	[mm]	12.7 - 25.4	31.75 - 50.8	50.8 - 76.2	76.2 - 101.6
Ranges	[inch]	1/2 - 1	1 1/4 - 2	2 - 3	3 - 4
Dimension A	[mm]	127	144.5	174.5	198.5
Machine OD	[inch]	5.000	5.688	6.871	7.812
Dimension B	[mm]	39.7	66.7	95.25	120.7
Machine ID	[inch]	1.562	2.626	3.750	4.750
Dimension C	[mm]	88.1	88.1	88.1	88.1
Parting Line	[inch]	3.468	3.468	3.468	3.468
Dimension D	[mm]	64.3	54.7	54.7	54.7
Machine Thickness	[inch]	2.530	2.155	2.155	2.155



Optional interchangeable tool slides – Modular design allows the operator to convert tool slides in second:



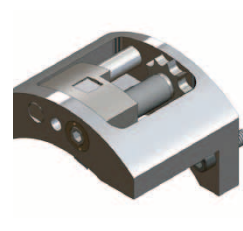
Beveling
Tool Slide



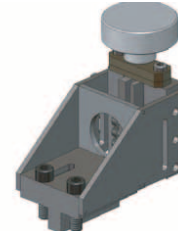
Parting
Tool Slide



Radial Socket
Weld Slide



Axial
Tool Slide



Universal Counterbore
Tool Slide



FME Module

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