

TRAV-L-CUTTER Pipe Cutter



Horizontal & vertical cutting



Fast & accurate cutting & beveling



Add mounting chain sections to fit larger diameters

Cold Cutting, Compact Design, Easy Set-Up

The Wachs Trav-L-Cutter is a portable milling machine capable of cold cutting and beveling simultaneously on all machinable pipe materials, pipe schedules and pipe sizes from OD 6in - 72in (152.4-1829 mm).

Mounted by its own tensioning chain, the Trav-L-Cutter drives itself around the pipe as it machines. For larger diameter pipe or vessels, simply add more drive chain sections. For greater accuracy specify the Trav-L-Cutter Guide Track. Available with pneumatic (Model E) and hydraulic (Model HE) drive.



TRAV-L-CUTTER Overview

Portable Milling Machines

- Safe cold cutting
- Simultaneous cutting and beveling
- Compact design, easy set-up
- Horizontal and vertical cutting
- Wide dimension range

Fast & Accurate

Wachs high-performance cutters remove 3/16in (4.8 mm) of metal while cutting, leaving the pipe end with a smooth, machined finish. The chain feed system maintains continuous out-of-round compensation while providing constant drive under all conditions for accurate cuts. By using an optional guide track and special guide track wheels, higher accuracy can be maintained. This cutting method facilitates section removal in the field where new sections, precut by the same method, can be easily dropped into place.

Operates Anywhere

The Trav-L-Cutter operates on horizontal or vertical pipe, in the field or the shop.

Machines Most Materials

Materials such as carbon steel, ductile iron, cast iron and most alloys in all pipe sizes from 6in to 72in (152.4-1829 mm) can be cold cut and beveled simultaneously.

Corrosion Resistance

Hydraulic models offer the inherent advantages of a completely sealed and self-lubricating closed loop system. The Model HE is particularly suited to field machining operations under the type of hostile conditions often found on offshore drilling rigs, pipelines and other construction work.

Both the HE and E models feature corrosion resistant components including stainless steel, hi-spec bearings and anti-corrosive finishes.



Model HE Hydraulic



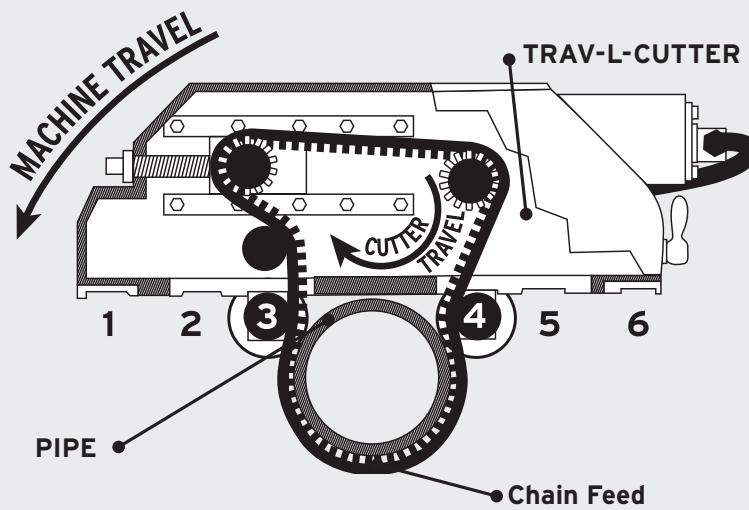
Trav-L-Cutter shown in steel storage case



Model HE Hydraulic Trav-L-Cutter suitable for full immersion



First generation Trav-L-Cutter photo circa 1952



TRAV-L-CUTTER Specifications

SPECIFICATIONS	
Machining capacity	6in - 72in (152-1829 mm)
Cutter drive	Pneumatic: 2.9 kW (4 hp) governed air motor coupled with worm gearbox. Hydraulic: As above, with hydraulic motor.
Cutter speed	Pneumatic: Adjustable from 35-55 rpm for use on work-hardened alloys. Hydraulic: Adjustable from 0-60 rpm.
Feed	<ul style="list-style-type: none"> Pneumatic: 0.56 kW (¾ hp) air motor coupled through overload clutch, gearbox and chain reduction to final machine drive sprocket. Hydraulic: 2.9 kW (4 hp) hydraulic motor.
Feed method	Positive, nonslip chain drive
Air requirements	2.8 m³/min (100 cfm at 90 psi)
Hydraulic requirements	55 l/min (15 gal/min at 1500 psi)
Work speed	<ul style="list-style-type: none"> Provides cutting time of 1inch/min of pipe diameter. 10in (254 mm) = 10 minutes. Over ½in (12.7 mm) wall as well as most alloys require reduced feed rate.
Clearance	Radial: 10in - 12in (254-305 mm) Axial: 20in (508 mm)
Controls	Cutter on-off, feed on-off, with interlock to prevent machine feed unless cutter is turning, adjustable feed control. Flow control valves (Model HE only). Separate controls provide adjustable spindle speed and cutter speed. Forward/reverse valve governs machine travel direction.
Weight	Operating: 97.5 kg (215 lb) Shipping: 189.6 kg (418 lb)
Finish	Corrosion resistant powder coat
Dimensions (LxWxH)	24 x 20 x 10.75in (61 x 51 x 28 cm)

Standard Equipment

- Air line lubricator (air only)
- Filter (air only)
- Speed control
- Operating manual and isometric parts list
- Operating tools
- Connecting pins
- Basic mounting chain for 6in - 48in (152-1219 mm) diameter pipe
- Steel storage case
- 6ft whip hose without oiler (air only)

Optional Equipment

- Additional chain sections
- Additional cutter blades
- Guide track and wheels to fit all pipe sizes up to 48in (1219 mm) for vertical cutting multiple pass cutting or high accuracy cutting
- Long cutter spindle for use with grooving cutters

ITEM	MODEL	DRIVETYPE	PIPE OD	CODE	PART #
Trav-L-Cutter	E	Pneumatic	6-72* (152-1829*)	902 000 010	02-000-01
Trav-L-Cutter	HE	Hydraulic	6-72* (152-1829*)	902 000 020	02-000-02

* Standard equipment includes a basic mounting chain for OD 6in - 48in (152-1219 mm) only.
Chain assembly for OD 54- 72in (1371- 1829 mm) sold separately.



Model E Pneumatic



Trav-L-Cutter is in use worldwide



Heavy duty steel storage case hinges open for easy access



Trav-L-Cutter being used for submarine decommissioning

TRAV-L-CUTTER Tooling

Slitting Saw Blades

ITEM	SAW BLADE Ø	SAW BLADE THICKNESS	FOR PIPE MATERIALS	WALL THICKNESS MAX.	CODE	PART #
Slitting Blade HSS	6in (152.4 mm)	3/16in (4.8 mm)	Steel	1in (25.4 mm)	902 601 000	02-601-00
Slitting Blade HSS*	7in (177.8 mm)			1.5in (38.1 mm)	902 602 000	02-602-00
Slitting Blade HSS**	7in (177.8 mm)	9/32in (7.1 mm)		2.125in (54.0 mm)	902 603 000	02-603-00
Slitting Blade HSS	8in (203.2 mm)	3/16in (4.8 mm)		Ductile, cast iron	1in (25.4 mm)	902 604 000
Slitting Blade Carbide tipped	6in (152.4 mm)		1.5in (38.1 mm)		902 605 000	02-605-00
	7in (177.8 mm)		2.125in (54.0 mm)		902 606 000	02-606-00
	8in (203.2 mm)				902 607 000	02-607-00



Slitting blade



Slitting blade



Bevel cutter

Bevel Cutters

VERSION	BEVEL CUTTER Ø	BEVEL CUTTER THICKNESS	BEVEL ANGLE	WALL THICKNESS MAX.	CODE	PART #
Left hand (inside)	5in (127.0 mm)	.5in (12.70 mm)	30°	.75in (19.05 mm)	902 608 540	02-608-LH
Right hand (outside)					902 608 740	02-608-RH
Left hand (inside)	5in (127.0 mm)	.5in (12.70 mm)	37.5°	.625in (15.88 mm)	902 609 540	02-609-LH
Right hand (outside)					902 609 740	02-609-RH
Left hand (inside)	6in (152.4 mm)	.75in (19.05 mm)	30°	1in (25.40 mm)	902 610 540	02-610-LH
Right hand (outside)					902 610 740	02-610-RH
Left hand (inside)	6in (152.4 mm)	.75in (19.05 mm)	37.5°	.875in (22.23 mm)	902 611 540	02-611-LH
Right hand (outside)					902 611 740	02-611-RH

Saw Blade & Bevel Cutter Combination Options

Example: Cutting and beveling up to .75in (19.05 mm) wall thickness

BLADE	BLADE Ø	BLADE THICKNESS	BEVEL ANGLE °	WALL THICKNESS MAX.	CODE	PART #
HSS Slitting Blade	6in (152.4 mm)	.1875in (4.8 mm)	-	1in (25.4 mm)	902 601 000	02-601-00
Bevel cutter Left hand (inside)	5in (127.0 mm)	.5in (12.70 mm)	30	.75in (19.05 mm)	902 608 540	02-608-LH
Bevel cutter Right hand (outside)	5in (127.0 mm)	.5in (12.70 mm)	30	.75in (19.05 mm)	902 608 740	02-609-RH



Bevel cutter

Example: Cutting and beveling up to 1in (25.4 mm) wall thickness

BLADE	BLADE Ø	BLADE THICKNESS	BEVEL ANGLE °	WALL THICKNESS MAX.	CODE	PART #
Slitting Blade HSS**	7in (177.8 mm)	.28in (7.1 mm)	-	1.5in (38.1 mm)	902 603 000	02-603-00
Bevel cutter Left hand (inside)	6in (152.4 mm)	.75in (19.05 mm)	30	1in (25.4 mm)	902 610 540	02-610-LH
Bevel cutter Right hand (outside)	6in (152.4 mm)	.75in (19.05 mm)	30	1in (25.4 mm)	902 610 740	02-610-RH
Spacer Kit 3/16, 11/16, 3/4	-	-	-	-	902 500 030	02-500-03



Bevel cutter & slitting saw combination

* For parting only.

** For use with 6in bevel cutter.

*** Hi-grain carbide is a micrograin carbide with higher strength for tough materials.

TRAV-L-CUTTER Accessories

Clamping Chains

ITEM	PIPE OD	CHAIN LENGTH	CODE	PART #
Clamping chain	– per linear inch –		call	call
Chain assembly	6-48in (152.4-1219.2 mm)	173in (4394 mm)	902 450 480	02-450-48
Chain assembly	54-72in (1371.6-1828.8 mm)	67in (1702 mm)	902 450 720	02-450-72
Connecting pin			902 158 000	02-158-00

Guide Tracks

Guide tracks require purchase of guide track wheel (Set of two).

DESCRIPTION	CODE	PART #	DESCRIPTION	CODE	PART #
6in (108.3 mm) Track	902 428 060	02-428-06	26in (660.4 mm) Track	902 428 260	02-428-26
8in (219.1 mm) Track	902 428 080	02-428-08	28in (711.2 mm) Track	902 428 280	02-428-28
10in (273.1 mm) Track	902 428 100	02-428-10	30in (762.0 mm) Track	902 428 300	02-428-30
12in (323.9 mm) Track	902 428 120	02-428-12	32in (812.8 mm) Track	902 428 320	02-428-32
14in (355.6 mm) Track	902 428 140	02-428-14	34in (863.6 mm) Track	902 428 340	02-428-34
16in (406.4 mm) Track	902 428 160	02-428-16	36in (914.4 mm) Track	902 428 360	02-428-36
18in (457.2 mm) Track	902 428 180	02-428-18	38in (965.2 mm) Track	902 428 380	02-428-38
20in (508.0 mm) Track	902 428 200	02-428-20	40in (1016.0 mm) Track	902 428 400	02-428-40
22in (558.8 mm) Track	902 428 220	02-428-22	42in (1066.8 mm) Track	902 428 420	02-428-42
24in (609.6 mm) Track	902 428 240	02-428-24	48in (1219.2 mm) Track	902 428 480	02-428-48

Set of 2 guide track wheels	902 429 000	02-429-00
Guide track bolt (2 required per guide track)	902 209 000	02-209-00

Miscellaneous Accessories & Spare Parts

ITEM	CODE	PART #
Hydraulic hose set 13.9 m (45 ft 5/8in). Includes 4 sets M/F quick disconnects. For use with Trav-L-Cutter Model HE	902 408 000	02-408-00
Hydraulic female disconnect	909 025 000	09-025-00
Hydraulic male disconnect	909 026 000	09-026-00
Dust cover, plug-cap	909 027 000	09-027-00
Set of 2 guide track wheels	902 429 000	02-429-00
Long cutter spindle*	902 073 020	02-073-02
Spare parts kit**	902 500 010	02-500-01
Spare parts kit with air motor (includes both air motors)**	902 500 020	02-500-02
Spare parts kit for 902 000 040 (atmospheric)**	902 500 040	02-500-04
Chain connecting pin	902 158 000	02-158-00
Steel wedges.	902 175 000	02-175-00
Trav-L-Cutter manual. Electronic version via e-mail available free upon request.	902 626 010	02-MAN-01

* If purchased in place of standard spindle: add \$125.00 to machine price.

** Kit BOM's subject to change based on current production configuration.

Hydraulic Power Units

For available Hydraulic Power Unit options, see page 76.

Cutting Lubrication KSS-TOP

Cutting lubrication "KSS-TOP", see page 53.



Chain assembly & pins



Guide track



Gasoline Driven
HPU Hydraulic Power Unit



KSS Top