

Tube Removal Tools

Cutter Feed Assist

Airetool Cutter Feed Assist (CF)

Increase your productivity with the Airetool Cutter Feed Assist. The Cutter Feed Assist is designed to work in conjunction with Airetool PIC push-type tube cutters to reduce operator fatigue and increase productivity.

- For use with 5/8" through 1" (15.8 - 25.4mm) PIC tube cutters
- Powered by Cleco® DPV-135 variable speed drills to match the best cutting speed to the tube material
- Provides constant pressure which increases durability of tool bits
- Independent cutter bit feed trigger for operator safety
- Positive-feed stop controls tube cutting depth
- Compact design allows the Cutter Feed Assist easier access to confined areas.



PIC Tube Cutter sold separately. See page 55.

Two Models Available:

Part Number	Order Number	RPM
CF-150/500	5523443	150-500
CF-400/1200	5523444	400-1200

HOW TO ORDER:

See selection chart below*. Select the Airetool Cutter Feed Assist that corresponds to tube sizes and tube material.

Tube Material	Tube O.D.			
	5/8" (16mm)	3/4" (19mm)	7/8" (22mm)	1" (25mm)
Aluminum	CF-400/1200	CF-400/1200	CF-400/1200	CF-400/1200
Brass	CF-400/1200	CF-400/1200	CF-400/1200	CF-400/1200
Copper	CF-400/1200	CF-400/1200	CF-400/1200	CF-400/1200
Carbon Steel	CF-400/1200	CF-400/1200	CF-400/1200	CF-400/1200
Stainless	CF-150/500	CF-150/500	CF-150/500	CF-150/500
Titanium	CF-150/500	CF-150/500	CF-150/500	CF-150/500

* Refer to the Machinery's Handbook for actual recommended tube cutting speeds for specific materials.



Airetool PIC Internal Tube Cutters

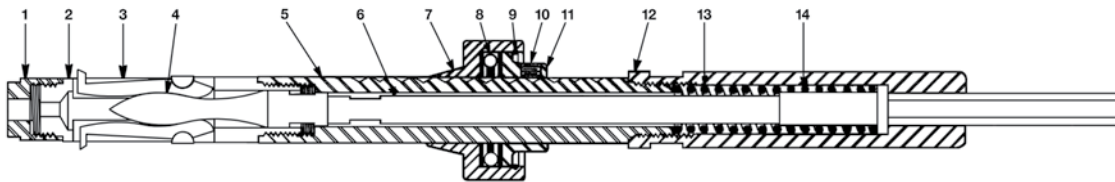
The "PIC" internal tube cutters are an economical solution to low volume tube cutting of various tube materials. Optimum tube cutting performance and tooling life are obtained when the Airetool CF Series cutter feed assist is used to match the cutting speed to the tube material.

Available for tube sizes
5/8" - 1-1/4" OD (15.8 - 31.8mm)

- Two-piece construction allows for quick and easy tool bit replacement.
- Cutter bits are now available with TiN coating, increasing the cutter bit life.
- Airetool PIC tube cutters are sold with a complete set of pilots and two spare tool bit sets
- Larger sizes and longer reaches available upon request.

Tube O.D.		PIC Tube Cutter Reach*			Pilots (incl.)
(in.)	mm	Standard	"A"	"C"	(gauge)
1/2	12.70	PIC 500 (5519733)	PIC 500 A	PIC 500 C	18 - 20
5/8	15.88	PIC 625 (5515553)	PIC 625 A (5515557)	PIC 625 C (5515559)	16 - 20
3/4	19.05	PIC 750 (5515560)	PIC 750 A (5515540)	PIC 750 C (5515514)	14 - 20
7/8	22.22	PIC 875 (5515562)	PIC 875 A (5515564PT)	PIC 875 C (5515566PT)	15 - 20
1	25.4	PIC 1000 (5515567)	PIC 1000 A (5515568)	PIC 1000 C (5515554)	12 - 20
1-1/8	28.57	PIC 1125 (5515820)	PIC 1125 A	PIC 1125 C	14, 16, 18
1-1/4	31.75	PIC 1250 (5518134PT)	PIC 1250 A	PIC 1250 C	14, 16, 18

* Standard Reach = 1-11/16 to 4-7/16" (43 to 110mm)
 "A" Reach = 4-11/16 to 7-7/16" (119 to 189mm)
 "C" Reach = 8-3/16 to 10-15/16" (208 to 278mm)



Item Number	Description	5/8" (16mm) 16-20GA	3/4" (19mm) 14-20GA	7/8" (22mm) 16-20GA	1" (25mm) 12-20GA
		Part No. (Order No.)	Part No. (Order No.)	Part No. (Order No.)	Part No. (Order No.)
	Complete PIC Cutter*	PIC-625 (5515553)	PIC-750 (5515560)	PIC-875 (5515562)	PIC-1000 (5515567)
1	Pilot	TTC 6 (2675000)	TTC-6-14 (2668900)	TTC-6-15 (2676400)	TTC-36-12 (2672500)
1	Pilot	TTC-46-18 (2675100)	TTC-6-15 (2669000)	TTC-56-16 (2990534)	TTC-36-13 (2672600)
1	Pilot	TTC-46-19 (2675200)	TTC-6-16 (2669100)	TTC-56-17 (2990535)	TTC-36-14 (2672700)
1	Pilot	TTC-46-20 (2675300)	TTC-6-17 (2669200)	TTC-56-18 (2676500)	TTC-36-15 (2672800)
1	Pilot	TTC 46 22 (2974902)	TTC-6-18 (2669300)	TTC-56-19 (2676600)	TTC-36-16 (2672900)
1	Pilot	TTC 46 23 (2976001)	TTC-6-19 (2669400)	TTC-56-20 (2676700)	TTC-36-17 (2673000)
1	Pilot	TTC 46 24 (2976002)	TTC-6-20 (2669500)		TTC-36-18 (2673100)
1	Pilot				TTC-36-19 (2673200)
1	Pilot				TTC-36-20 (2673300)
2	Body Tip	IC-41 (2979725)	IC-1 (2979306)	IC-51 (2979726)	IC-31 (2979419)
3	Tool Bit* (Non-ferrous)	TTC-43 (5338869)	TTC-3 (5338865)	TTC-53 (5338871)	TTC-33 (5338867)
3	Tool Bit* (Ferrous)	TTC-43-S (5338870)	TTC-3-S (5338866)	TTC-53-S (5338872)	TTC-33-S (5338868)
3	Tool Bit* (Stainless)	TTC-43-SS (5518303)	TTC-3-SS (5517614)	TTC-53-S (5517757)	TTC-33-SS (5516337)
4	Mandrel Tip	IC-44-T (2979724)	IC-4-T (2979308)	IC-34-T (2979409)	IC-34-T (2979409)
5	Body Extension	IC-41X (2979688)	IC-1X (2979672)	IC-51X (2979692)	IC-31X (2979680)
6	Mandrel Extension	IC-4X (2979676)	IC-4X (2979676)	IC-34X (2979684)	IC-34X (2979684)
7	Thrust Body	TTC-47 (2675400)	TTC-7 (2669600)	TTC-57 (2676800)	TTC-37 (2673300)
8	Bearing	TTC-9 (2670000)	TTC-9 (2670000)	TTC-39 (2673800)	TTC-39 (2673800)
9	Thrust Spring	TTC-10 (2670100)	TTC-10 (2670100)	TTC-40 (2673900)	TTC-40 (2673900)
10	Set Screw	10-32X1/4 (8000800)	10-32X1/4 (8000800)	10-32X1/4 (8000800)	10-32X1/4 (8000800)
11	Thrust Nut	TTC-48 (2675700)	TTC-8 (2669900)	TTC-58 (2677100)	TTC-38 (2673700)
12	Spring Housing	PIC-21 (2979752)	PIC-21 (2979752)	PIC-21 (2979752)	PIC-21 (2979752)
13	Spring	PTC-5 (2574180)	PTC-5 (2574180)	PTC-5 (2574180)	PTC-5 (2574180)
14	Driver	PIC-4 (2979751)	PIC-4 (2979751)	PIC-4 (2979751)	PIC-4 (2979751)

*Standard length listed

Tube Removal Tools

Air Driven Tube Cutter (TIC)

Complete tube cutting system for various tube materials. Five models available in speeds from 100 to 625 rpm for various steel and non-ferrous tube applications.

- Powerful, 4.5 Horsepower motor with D-handle
- Governed motor for consistent cutting speeds
- Positive lever-operated feed of cutter bit
- One mandrel drive adapter works with all sizes of cutters (TTC-30, ordering number 2671400)



Electric Tube Cutter (EIC)

Where compressed air supply is unavailable, the EIC tube internal tube cutter will perform satisfactorily for low volume tube cutting jobs. The variable speed motor can be used to cut various steel and non-ferrous tube materials.

- Powerful, 120VAC, 7 amp reversible motor
- Trigger speed control: 0 - 600 RPM
- Triple gear reduction provides abundant torque output
- One mandrel drive adapter works with all sizes of cutters (ETC-30, ordering number 3073240)



RPM	Tube Material	Cutter Complete			
		5/8" O.D.	3/4" O.D.	7/8" O.D.	1" O.D.
Pneumatic Models					
625	Non-ferrous	TIC-625-625 (5515586)	TIC625-750 (5515590)	TIC-625-875 (5515594)	TIC-625-1000 (5515598)
335	Non-ferrous/Ferrous	TIC-350-625 (5515602)	TIC-350-750 (5515606)	TIC-350-875 (5515610)	TIC-350-1000 (5515614)
265	Ferrous-Stainless	TIC-265-625 (5515618)	TIC-265-750 (5515622)	TIC-265-875 (5515626)	TIC-265-1000 (5515630)
200	Ferrous-Stainless	TIC-200-625 (5518909)	TIC-200-750 (5518459)	TIC-200-875 (5522345)	TIC-200-1000 (5519460)
100	Stainless & Titanium	TIC-100-625 (5519526)	TIC-100-750 (5517806)	TIC-100-875 (5522125)	TIC-100-1000 (5518512)
40	Titanium & Inconel	TIC-40-625 (5521860)	TIC-40-750 (5518184)	TIC-40-875	TIC-40-1000
Electric Models					
EIC 100/600 RPM	See Above	EIC 100/600 625 (5515772)	EIC 100/600 750 (5515635)	EIC 100/600 875 (5523035)	EIC 100/600 1000 (5518583PT)

Cutter Bodies Complete for TIC & EIC Models

Several design improvements have been incorporated for maintenance and increased service life

- Shorter and stronger cutter body improves durability and increases bit life
- Cutter body is threaded into body extension for easier bit replacement
- Standard mandrel driver fits all sizes of Airetool tube cutters
- Adjustable reach "IC" cutter bodies:
 - Standard reach 1-11/16" to 4-7/16" (42 - 112mm) shown above
 - "A" reach = 4-11/16" to 7-7/16" (112 - 188mm)
 - "C" reach = 8-3/16" to 10-15/16" (207 - 277mm)
- Larger sizes and longer lengths available upon request.

Description	Tube O.D.			
	5/8" O.D.	3/4" O.D.	7/8" O.D.	1" O.D.
Tube Cutter body Sub-assemblies for TIC & EIC models				
Cutter Body Complete	IC-625 (5515574)	IC-750 (5515577)	IC-875 (5515581)	IC-1000 (5515571)
Tool Bit* (Non-ferrous)	TTC-43 (5338869)	TTC-3 (5338865)	TTC-53 (5338871)	TTC-33 (5338867)
Tool Bit* (Ferrous)	TTC-43-S (5338870)	TTC-3-S (5338866)	TTC-53-S (5338872)	TTC-33-S (5338868)
Tool Bit* (Stainless)	TTC-43-SS (5518303)	TTC-3-SS (5517614)	TTC-53-SS (5517757)	TTC-33-SS (5516337)

* Tool Bit part numbers above consist of 2 bits each.
 Tube Cutter Bodies consists of all parts necessary to convert models TIC & EIC to different tube size.

Specify desired reach:
 Standard Reach 4-7/16" (112.7mm) shown
 "A" Reach 7-7/16" (188.9mm)
 "C" Reach 10-15/16" (277.8mm)



RCM One Revolution Tube Cutters

For cutting tubes beyond the tube sheet in heat exchangers, condensers, and boilers. RCM series tube cutters are also an excellent tool for puncturing defective tubes prior to tube plugging. This reduces the risk of pressure buildup in plugged tubes.

- Designed for hand use by employing a ratchet or hand wrench for manual operation
- Available in standard reaches of 6" (152mm) and 10" (254mm)
- Longer reaches are available in 10" increments upon request



Tube O.D.		BWG	Tube I.D.	Tool Reach		Cutting Bit
in.	mm			6" (152.4mm)	10" (254.0mm)	
1/2	12.70	18-19	.400"-.420" 10.2-10.7mm	RCM-105 (5522994)	RCM-105-10 (5523116)	RC-500-2 (2993368)
1/2	12.70	20	.430"-.450" 11.0-11.3mm	RCM-110 (5522929)	RCM-110-10	RC-500-2 (2993368)
5/8	15.88	14	.450"-.470" 11.4-11.9mm	RCM-115 (5522995)	RCM-115-10 (5523118)	RC-625-2 (2993372)
5/8	15.88	15-16	.472"-.510" 12-12.9mm	RCM-120 (5522930)	RCM-120-10 (5523119)	RC-625-2 (2993372)
5/8	15.88	17-18	.500"-.531" 12.7-13.5mm	RCM-130 (5522931)	RCM-130-10 (5523120)	RC-625-2 (2993372)
5/8	15.88	19-20	.531"-.560" 13.5-14.2mm	RCM-135 (5522996)	RCM-135-10 (5523121)	RC-625-2 (2993372)
5/8	15.88	22	.550"-.580" 14.0-14.7mm	RCM-140 (5522932)	RCM-140-10 (5524952)	RC-625-2 (2993372)
3/4	19.05	12-13	.530"-.560" 13.5-14.2mm	RCM-135-3/4 (5523115)	RCM-135-3/4-10 (5526397)	RC-750-2A (2995865)
3/4	19.05	14-15	.580"-.610" 14.7-15.5mm	RCM-150 (5522933)	RCM-150-10 (5523123)	RC-750-2 (2993374)
3/4	19.05	16	.600"-.630" 15.2-16.0mm	RCM-155 (5522997)	RCM-155-10 (5523124)	RC-750-2 (2993374)
3/4	19.05	17-18	.625"-.650" 15.9-16.5mm	RCM-160 (5522934)	RCM-160-10 (5523125)	RC-750-2 (2993374)
3/4	19.05	19-20	.660"-.690" 16.7-17.5mm	RCM-170 (5522935)	RCM-170-10 (5523126PT)	RC-750-2 (2993374)
7/8	22.22	14-15	.700"-.730" 17.8-18.5mm	RCM-180 (5522936)	RCM-180-10 (5523127)	RC-875-2 (2993384)
7/8	22.22	16-17	.740"-.770" 18.8-19.5mm	RCM-190 (5522937)	RCM-190-10 (5523128)	RC-875-2 (2993384)
7/8	22.22	18	.760"-.790" 19.3-20.0mm	RCM-195 (5522998)	RCM-195-10 (5524478)	RC-875-2 (2993384)
7/8	22.22	19-20	.780"-.810" 19.8-20.6mm	RCM-200 (5522938)	RCM-200-10 (5523241PT)	RC-875-2 (2993384)
1	25.40	12	.760"-.790" 19.3-20.0mm	RCM-195 (5522998)	RCM-195-10 (5524478)	RC-875-2 (2993384)
1	25.40	14	.820"-.850" 20.8-21.6mm	RCM-210 (5522939)	RCM-210-10 (5523131)	RC-1000-2 (2993394)
1	25.40	15	.840"-.870" 21.3-22.1mm	RCM-215 (5522999)	RCM-215-10 (5523132)	RC-1000-2 (2993394)
1	25.40	16-17	.860"-.890" 21.8-22.6mm	RCM-220 (5522940)	RCM-220-10 (5523133)	RC-1000-2 (2993394)

Tube O.D.		BWG	Tube I.D.	Tool Reach		Cutting Bit
in.	mm			6" (152.4mm)	10" (254.0mm)	
1	25.40	18-19	.890"-.910" 22.6-23.1mm	RCM-230 (5522941)	RCM-230-10 (5523134)	RC-1000-2 (2993394)
1	25.40	22	.940"-.970" 23.9-24.6mm	RCM-240 (5522942)	RCM-240-10 (5525584)	RC-1000-2 (2993394)
1-1/4	31.75	12	1.020"-1.050" 25.9-26.7mm	RCM-260 (5523000)	RCM-260-10 (5523136)	RC-1250-2 (2993404)
1-1/4	31.75	13-14	1.050"-1.080" 26.7-27.4mm	RCM-270 (5523001)	RCM-270-10 (5523137)	RC-1250-2 (2993404)
1-1/4	31.75	15-16	1.100"-1.130" 27.9-28.7mm	RCM-280 (5523002)	RCM-280-10 (5523138)	RC-1250-2 (2993404)
1-1/4	31.75	17-19	1.130"-1.160" 28.7-29.6mm	RCM-290 (5523003)	RCM-290-10 (5523139)	RC-1250-2 (2993404)
1-3/8	34.93	13-14	1.180"-1.210" 30-30.7mm	RCM-300 (5523709)	RCM-300-10 (5525838)	RC-1500-2 (2993417)
1-1/2	38.10	12-13	1.280"-1.310" 32.5-33.3mm	RCM-330 (5523004)	RCM-330-10 (5523140)	RC-1500-2 (2993417)
1-1/2	38.10	14-15	1.330"-1.360" 33.8-34.5mm	RCM-340 (5523005)	RCM-340-10 (5523005)	RC-1500-2 (2993417)
1-1/2	38.10	16-17	1.360"-1.390" 34.5-35.3mm	RCM-350 (5523006)	RCM-350-10 (5523142)	RC-1500-2 (2993417)
1-1/2	38.10	18-19	1.390"-1.420" 35.3-36.1mm	RCM-360 (5523007)	RCM-360-10 (5523143)	RC-2000-2 (2993427)
2	50.80	12-13	1.770"-1.810" 45.0-46.0mm	RC-2012 (5521677)	RC-2012-10	RC-2000-2 (2993427)
2	50.80	14-15	1.820"-1.860" 46.2-47.2mm	RC-2014 (5521678PT)	RC-2014-10	RC-2000-2 (2993427)
2	50.80	16-17	1.860"-1.900" 46.2-48.2mm	RC-2016 (5521679)	RC-2016-10	RC-2000-2 (2993427)
2	50.80	18-19	1.890"-1.930" 48.0-49.0mm	RC-2018 (5521680)	RC-2018-10	RC-2000-2 (2993427)
2-1/2	63.50	12-13	2.270"-2.310" 57.6mm-58.6	RC-2512 (5521681)	RC-2512-10	RC-2000-2 (2993427)
2-1/2	63.50	14-15	2.320"-2.360" 58.9-60.0mm	RC-2514 (5521682)	RC-2514-10	RC-2000-2 (2993427)
2-1/2	63.50	16-17	2.360"-2.400" 60.0-61.0mm	RC-2516 (5521683)	RC-2516-10	RC-2000-2 (2993427)
2-1/2	63.50	18-19	2.390"-2.430" 60.7-61.7mm	RC-2518 (5521684)	RC-2518-10	RC-2000-2 (2993427)