

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 (152.4-1829mm).

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 options.



TRAV-L-CUTTER Features

Portable Pipe Milling Machine

Fast & Accurate

Wachs high-performance cutters remove 3/16in (4.8mm) 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, pre-cut 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 (152.4-1829mm) can be cold cut and beveled simultaneously.

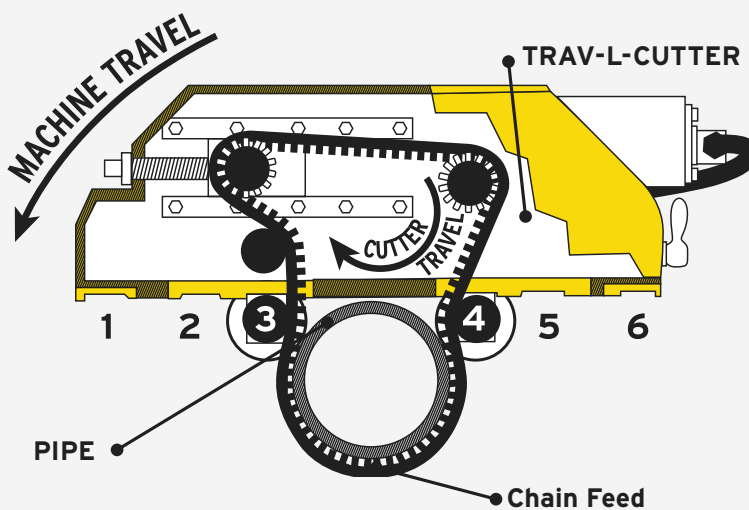
Corrosion Resistance

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.

Trav-L-Cutter Features

- Safe cold cutting
- Simultaneous cutting and beveling
- Compact design, easy set-up
- Horizontal and vertical cutting
- Mounts to larger diameters with additional chain



Model HE Hydraulic



Trav-L-Cutter shown in steel storage case



Trav-L-Cutter is designed for pipeline operations.



First generation Trav-L-Cutter photo circa 1952

TRAV-L-CUTTER Specifications

SPECIFICATIONS	
Machining capacity	6in - 72in (152-1829mm)
Cutter drive	Pneumatic: Governed air motor coupled with worm gearbox. Hydraulic: As above, with hydraulic motor.
Cutter speed	Pneumatic: Adjustable from 35-55rpm for use on work-hardened alloys. Hydraulic: Adjustable from 0-60rpm.
Feed	Pneumatic: Air motor coupled through overload clutch, gearbox and chain reduction to final machine drive sprocket. Hydraulic: 4hp (2.9kW) hydraulic motor.
Feed method	Positive, nonslip chain drive
Air requirements	100cfm at 90psi (2.8m ³ /min)
Hydraulic requirements	15gal/min at 1500psi (55l/min)
Work speed	Provides cutting time of 1inch/min of pipe diameter. 10in (254mm) = 10 minutes. Over.5in (12.7mm) wall and most alloys require reduced feed rate.
Clearance	Radial: 10in - 12in (254-305mm) Axial: 20in (508mm)
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: 215lb (97.5kg) Shipping: 418lb (189.6kg)
Finish	Corrosion resistant powder coat
Dimensions (LxWxH)	24 x 20 x 10.75in (61 x 51 x 28cm)

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 (152-1219mm) 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 (1219mm) for vertical cutting multiple pass cutting or high accuracy cutting
- Long cutter spindle for use with grooving cutters

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

* STANDARD EQUIPMENT INCLUDES A BASIC MOUNTING CHAIN FOR OD 6IN - 48IN (152-1219MM) ONLY.



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.	PART #
Slitting Blade HSS	6in (152.4mm)	3/16in (4.8mm)	Steel	1in (25.4mm)	02-601-00
Slitting Blade HSS*	7in (177.8mm)			1.5in (38.1mm)	02-602-00
Slitting Blade HSS**	7in (177.8mm)			92in (7.1mm)	02-603-00
Slitting Blade HSS	8in (203.2mm)	3/16in (4.8mm)		2.125in (54.0mm)	02-604-00
Slitting Blade Carbide tipped	6in (152.4mm)		1in (25.4mm)	02-605-00	
	7in (177.8mm)		1.5in (38.1mm)	02-606-00	
	8in (203.2mm)		2.125in (54.0mm)	02-607-00	



6in HSS Slitting blade



7in HSS Slitting blade



5in 30° Left Hand Bevel cutter

Bevel Cutters

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

Saw Blade & Bevel Cutter Combination Options

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

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



6in 30° Left Hand Bevel cutter

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

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



Inside Outside Bevel with Slitting Blade

* FOR PARTING ONLY

** FOR USE WITH 6IN BEVEL CUTTER

TRAV-L-CUTTER Accessories

Clamping Chains

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

Guide Tracks

GUIDE TRACKS REQUIRE PURCHASE OF GUIDE TRACK WHEEL (SET OF TWO).

DESCRIPTION	PART #
6in (108.3mm) Track	02-428-06
8in (219.1mm) Track	02-428-08
10in (273.1mm) Track	02-428-10
12in (323.9mm) Track	02-428-12
14in (355.6mm) Track	02-428-14
16in (406.4mm) Track	02-428-16
18in (457.2mm) Track	02-428-18
20in (508.0mm) Track	02-428-20
22in (558.8mm) Track	02-428-22
24in (609.6mm) Track	02-428-24
26in (660.4mm) Track	02-428-26
28in (711.2mm) Track	02-428-28
30in (762.0mm) Track	02-428-30
32in (812.8mm) Track	02-428-32
34in (863.6mm) Track	02-428-34
36in (914.4mm) Track	02-428-36
38in (965.2mm) Track	02-428-38
40in (1016.0mm) Track	02-428-40
42in (1066.8mm) Track	02-428-42
48in (1219.2mm) Track	02-428-48

Miscellaneous Accessories & Spare Parts

ITEM	PART #
Hydraulic hose set 13.9m (45ft 5/8in). Includes 4 sets M/F quick disconnects. FOR USE WITH TRAV-L-CUTTER MODEL HE	02-408-00
Hydraulic female disconnect	09-025-00
Hydraulic male disconnect	09-026-00
Set of 2 guide track wheels	02-429-00
Spare parts kit with air motor (includes both air motors)	02-500-01
Spare parts kit	02-500-02
Steel wedges	02-175-00

Hydraulic Power Units

For available Hydraulic Power Unit options, see page 74.

Cutting Lubrication KSS-TOP

Cutting lubrication "KSS-TOP", see page 51.



Chain assembly & pins



Guide track



Gasoline Driven
HPU Hydraulic Power Unit



KSS Top