H&S TOOL
A CLIMAX COMPANY

J

.500" I.D. to 2.000" O.D. (12.7 to 50.8 mm)

Reliable Performance

The Model J is a compact tube beveling tool that is small enough to work in a 1.500" (38.1 mm) wide area, yet is powerful enough to bevel tubes up to 2.000" (50.8 mm) O. D.

Specifically designed for quick turnaround, single tube replacements and dutchman applications, the Model J can reduce your downtime by reducing the amount of cutting and welding required.

The right-angle design and the wrench-feed at the back of the head makes it ideal for working in tight spaces. It features attached, replaceable wrenches for both the internal locking and the tool feed.

- Dutchman Applications
- Waterwall Single Tube Replacement
- Corner Tubes
- Narrow Head Fits In 1.500" (38.1 mm) Wide Space
- Weighs Just 10.0 lbs. (4.5 kg)
- Reliable Pneumatic and Electric Power
- Torque-Free Operation

Specifications*

Working Range	.500" (12.7 mm) I.D. to 2.000" (50.8 mm) O.D.
Pneumatic Motor	0.9 H.P. (.66 kW)
Recommended Air Pressure	90 PSI (6.1 Bar)
Recommended Volume	38 CFM (1.1 m3/min.)
Speed	160 RPM
Electric Motor	1.0 H.P. (.74 kW), 120/230 V, 6.0A
Speed	0-550 RPM
Minimum Working Clearance	1.500" (38.1 mm) X 12.500" (317.5 mm)
Pneumatic Weight	10.0 lbs. (4.5 kg)
Pneumatic Length	18.000" (457.2 mm)
Electric Weight	8.0 lbs. (3.6 kg)
Electric Length	13.000" (330.2 mm)
Head Width	1.500" (38.1 mm)

* Specifications are subject to change without notice.

I.D. Range

Collet Size	Inches	MM	Rod/ Shaft
.625	.625 - .750	15.9 - 19.1	Std.
.750	.750 - .875	19.1 - 22.2	Std.
.875	.875 - 1.000	22.2 - 25.4	Std.
1.000	1.000 - 1.125	25.4 - 28.6	Std.
1.125	1.125 - 1.250	28.6 - 31.8	Std.
1.250	1.250 - 1.375	31.8 - 34.9	Std.
1.375	1.375 - 1.500	34.9 - 38.1	Std.
1.500	1.500 - 1.625	38.1 - 41.3	Std.
1.625	1.625 - 1.750	41.3 - 44.5	Std.
1.750	1.750 - 1.875	44.5 - 47.6	Std.
1.875	1.875 - 2.000	47.6 - 50.8	Std.

I.D. Range

Plate Sets	Inches	MM	Rod/ Shaft
*AA	.500 - .563	12.7 - 14.3	.500
*BB	.563 - .625	14.3 - 15.9	.500
*CC	.625 - .688	15.9 - 17.5	.500
.625	.625 - .750	15.9 - 19.1	.625 Cone
.750	.750 - .875	19.1 - 22.2	.625 Cone
.875	.875 - 1.000	22.2 - 25.4	.875 Cone
1.000	1.000 - 1.125	25.4 - 28.6	.875 Cone
1.125	1.125 - 1.250	28.6 - 31.8	.875 Cone
1.250	1.250 - 1.375	31.8 - 34.9	1.250 Cone
1.375	1.375 - 1.500	34.9 - 38.1	1.250 Cone
1.500	1.500 - 1.625	38.1 - 41.3	1.250 Cone
1.625	1.625 - 1.750	41.3 - 44.5	1.250 Cone
1.750	1.750 - 1.875	44.5 - 47.6	1.250 Cone
1.875	1.875 - 2.000	47.6 - 50.8	1.250 Cone

* Special .500" (12.7 mm) wedge shaft and rod.

Distributed by:

Accurate, Safe and Productive

There are two internal locking systems for torque-free operation. Both automatically center the tool for accurate machining. The wedge plate system is lighter while the collet system provides a larger surface contact. A special wedge shaft is required for tube sizes from .500" (12.7 mm) to .625" (15.9 mm) I.D.

Tooling

Tool holders use the S-Base blades which allows coverage of the full tool holder range. A 1.500" (38.1 mm) diameter holder is available for work in tight spaces. A 2.000" (50.8 mm) holder can also be used for larger O.D. tubes where room permits. The tooling illustrated covers the standard machining applications. Custom tooling made from high quality tool steel, carbide and titanium nitride coated materials is also available. The tool holder will accept multiple cutters, allowing you to perform two operations at the same time.

A fast, economical way to internal bevel tubes

Two reamers are available. One has a working range of .500" to 1.750" (12.7 to 44.5 mm). The other working range is 1.250" to 2.500" (31.8 to 63.5 mm).

1.500" (38.1 mm) Tool Holder
.500" (12.7 mm) I.D. to 1.500" (38.1 mm) O.D.
S-37.5°

2.000" (50.8 mm) Tool Holder
.500" (12.7 mm) I.D. to 2.000" (50.8 mm) O.D.
S-37.5°

1.500" (38.1 mm) Tool Holder
.500" (12.7 mm) I.D. to 1.500" (38.1 mm) O.D.
S-F

2.000" (50.8 mm) Tool Holder
.500" (12.7 mm) I.D. to 2.000" (50.8 mm) O.D.
S-F

1.500" (38.1 mm) Tool Holder
.500" (12.7 mm) I.D. to 1.500" (38.1 mm) O.D.
S-I

2.000" (50.8 mm) Tool Holder
.500" (12.7 mm) I.D. to 2.000" (50.8 mm) O.D.
S-I

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