HAUTAU *Tube Cutoff Systems*

- RC15 Cut-Off Lathe Specifications -

Method of Cutoff	The tube is held stationary during cutoff by dual self-centering 6-jaw chucks. The rotating-headstock cuts the tube, then chamfers both ends, inside and out. Use carbide inserts for thick-wall or cutoff discs and sizing rollers for thin-wall
Maximum Cut-off Diameter	1.50" (standard configuration)
Minimum Cut-off Diameter	Consult factory
Maximum Tube Wall	Cutoff & OD/ID chamfer: .50" (depends on tube OD)
Minimum Tube Wall	Consult factory
Minimum Tube ID	Depends on tube O.D. and wall thickness
Chamfer Angles	17.5°, 27.5°, 40°, 45° (using single ISO-standard inserts) 15°, 20° and custom angles (using tandem ISO-standard inserts) Custom ground inserts for radius or dual-angle chamfers
Maximum OD Chamfer Depth	.250" (depends on tool size, angle, measurement method) Two-step chamfer sequence can be used for deeper chamfers
Maximum ID Chamfer Depth	Approx .150" (depends on tool size, angle, measurement method)
Tube Feeder	
Feeder Stroke	30" standard, up to 60" optional
Feeder Drive	Servo-solenoid valve, hydraulic cylinder, linear encoder feedback
Advance Speed	50"/second (max.)
Cut Lengths	.50" min., 480" max. Up to three cut lengths per tube. Random lengths are automatically measured and optimized.
Trim and Face Cuts	.50" min. trim cut, 28" max. trim cut, within ±.010" End-face and chamfer without trim (add ±.005")
Squareness of Cut	.001" T.I.R. per 1.0" of tube diameter
Cut Length Repeatability	Up to 30": ±.005" Up to 90": ±.012" Up to 60": ±.008" Up to 120": ±.015"
Electrical Controls	
Service requirements	480VAC 3Ø @ 100A (average load: 22kW) – other voltage POR
Headstock Drive	Baldor® 30HP Energy-Efficient, invertor-duty, 1000 RPM max. headstock RPM
Control System	Allen-Bradley© ControlLogix®, CF Memory card, Ethernet/IP Rack-mounted, closed-loop servo motion control modules Allen-Bradley© PanelViewPlus® ColorTouch screen Allen-Bradley© PowerFlex® variable-frequency headstock drive Integrated cabinet (requires no added floor-space)
Control Options	Allen-Bradley© Dial-Up Modem or Paging Modem VersaView® ColorTouch screen with imbedded Windows CE Cabinet cooling Constant surface speed headstock control
Hydraulic System	
Hydraulic Pump	Bosch® 26 GPM Whisper Pump®, pressure-comp. vane, 3000 PSI rated
Pump Motor	Baldor® 20HP Energy-Efficient, ODP
Hydraulic Valving	Bosch-Rexroth® servo and directional valves, Hydac® accumulator
Hydraulic Filtration	Hydac® 10µ pressure, 10µ return, 10µ circulator pump
Hydraulic Cooling	Standard: Water-to-oil heat exchanger, 1-4 GPM at 30 PSI appx. Optional: Oil-Air® integrated pump/cooler/filter system with 12 GPM circulating pump. 1 HP Baldor® motor.

- RC15 Rotating-Head Cut-Off Lathes are compatilble with our strap loaders, chain loaders and indexing conveyors.