

OVERVIEW

The **M700 Large Tube Module (M700LT)** utilizes a large rotary style cutter head which can squarely cut many grades of large diameter tubing. The M700LT can be connected directly to the Control Module or to a Control/Feeder setup for automated material processing.

TECHNICAL DATA

Material Specifications:*

Minimum material size: 1/2" (12.7mm) OD

Maximum material size: 1-1/8" (28.6mm) OD

Minimum cut length: 0.100" (.254cm)

Maximum cut length: 99,999.0 (in or cm)

Maximum programmable quantity: 99,999 pieces

Cut Tolerances:*

Material Length

Under 2" (5.08cm): ± 0.010 (± 0.025 cm)

Over 2" (5.08cm): $\pm 1\%$

Squareness of Cut: $\pm 2^\circ$

** Specification is material dependent and/or dependent on de-reeling system*

Module Dimensions (L x W x H):

16" x 7.25" x 8" (40.64cm x 18.42cm x 20.32cm)

Module Weight:

24lb (10.9kg)

PERFORMANCE

Supported Modes

Continuous Mode

Single Piece Flow Mode

Jobs/Batches:

Up to 100 programmable Jobs;

1-20 Batches per Job

Feed/Cut Parameters:

Feed Rates: 10 selectable rates (0-9)

Cut Rates: 10 selectable rates (0-9)

Cut Time: 0.2 seconds - 3.0 seconds

POWER

Voltage supplied by the Control Module

REQUIRED PARTS

Custom Bushings: (Material sample is required to properly size bushings)

OPTIONAL PARTS

Carbide Blade: IR1390

Material Length Stop: IR3324

REPLACEMENT PARTS

Tube Cutting Blade (standard): IR1296



M700LT Large Tube Module

BUSHING INSTALLATION

1. Turn off machine and disconnect from power supply.
2. If necessary, decouple the LT Module from the system.
3. Choose the proper size bushing set for the material to be processed.
4. To install the cut bushing, slide the bushing from left to right into the upstream cut bushing sleeve with the bushing chamfer facing toward the Control Module. Ensure the bushing is fully inserted and pressed against the LT cutting blade, and then tighten the set screw.
5. To install the exit bushing, slide the bushing from right to left into the downstream exit bushing sleeve with the bushing chamfer facing the cutting blade. Ensure the bushing is fully inserted and pressed against the LT cutting blade, and then tighten the set screw.

NOTE: To best align either bushing relative to the cutting blade, carefully actuate the cutter head's blade holder arm so that it is fully in the 'cut' position. While holding the blade holder arm in this position, push the bushing toward the cutting blade until it just makes contact. Tighten the set screw and carefully release the blade holder arm. Test the holder arm to ensure the blade does not make any contact with either bushing. Any blade contact with a bushing will cause blade damage and/or erratic material cuts.

MODULE ASSEMBLY

1. Turn off machine and disconnect from power supply.
2. Open the clamping latch on the backside of the upstream module (either the Control or Feeder Module) by first loosening the thumb screw and then pulling the latch out and away from the module.
3. Align the LT Module's upstream interface connection (alignment pins and electrical connector) with the upstream module's downstream interface connection, and gently slide the LT into the upstream module so that it just begins to engage.
4. On the backside of the upstream module, push the clamping latch back in toward the module and it will draw the LT Module into the upstream module.
5. Once the clamping latch is in the closed position, fasten the clamping latch's thumb screw to the rear panel of the module.
6. Install the Endcap into the LT Module's downstream interface connection using the same technique.
Note: The Endcap (supplied with the M700C) must always be installed into the last connected module's downstream interface connection.

NOTE: All doors must be closed and the downstream Endcap installed for the system to function.

BLADE REPLACEMENT

1. Turn off machine and disconnect from power supply.
2. If necessary, decouple the LT Module from the system.
3. Remove the cut and exit bushings.
4. Remove the blade holder screws and nylon washers.
5. Slide the blade out of the blade holder.
6. Replace the blade with a new standard (or optional) blade and then reinstall the hardware. Ensure the blade sits flat against the blade holder and under the nylon washers.

CAUTION: When handling or removing a cutting blade, be aware that it is extremely sharp and can cause serious injury if improperly handled.