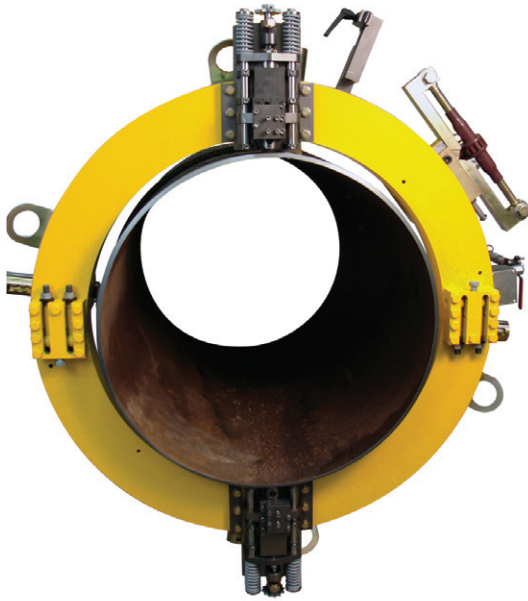


# Heavy Duty Split Frame

**HDSF**



## DESCRIPTION

E.H. Wachs Heavy Duty Split Frame (HDSF) series are the largest and toughest in the Wachs Split Frame family, and are designed to part, bevel, single point, counterbore and face flanges on large diameter pipes from 12 to 84 inches O.D. (DN300-2100)\*.

Named for its ability to split for mounting to the O.D. of inline pipe, the HDSF series is constructed with a bigger cross section, larger gear sets and massive hardened steel components.

## BUILT FOR BIG JOBS

The HDSF is ideal for big, tough jobs where tight radial or axial clearances are less critical. Like all Wachs Split Frames, the HDSF will produce precision lathe finishes using a safe cold cutting process, which minimizes the risk of explosion on gas and petrochemical lines and eliminates a heat affected zone. Wachs Heavy Duty Split Frames come standard with Heavy Duty O.D. tracking slides to compensate for out of round pipe, and to speed setup and machining times. A heavy duty machining system built for big jobs, Wachs HDSF offers a big return on investment.

## HEAVY DUTY SPLIT FRAME FEATURES

- Cuts and preps pipe from 12 to 84 inches O.D. (DN300-2100).
- Safe cold cutting process reduces risk of explosion, eliminates heat affected zone
- Fast setup, cutting and prep times with standard O.D. tracking tool slides
- Select hardened steel components, bigger cross section, larger gear sets
- Built in lifting eyes for vertical and horizontal mounting
- Standard ratcheting hinge mechanism opens and closes frame quickly
- Hydraulic or Pneumatic drive options
- Lathe machining process delivers precision compound bevels and consistent lands
- Applications in power generation, oil refineries, petrochemical and pipeline

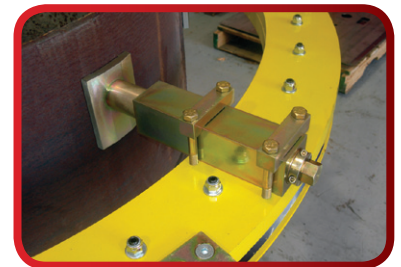
## HDSF DESIGN CAPABILITIES

- Six standard models cover 12 to 84 inches O.D. (DN300-2100)
- Larger sizes available by special order
- 12" (305mm) diameter capacity between the six standard HDSF models
- Larger interior frame clearance to accommodate obstructions and deformed pipe
- Full roller bearing (rather than bushing) load surfaces for durability and stability
- Fully enclosed bearings and drive gears for safety and durability
- Positive mechanical starwheel feed
- Corrosion resistant finishes on all components to withstand harsh environments
- Mounts to O.D. with drive motor and slides installed, ready to operate
- Accessories are interchangeable between all Wachs HDSF machines

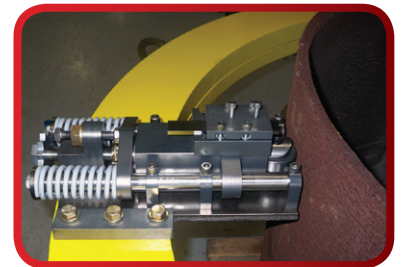
## BUILT FOR BIG JOBS STANDARD O.D. TRACKING SLIDES



HDSF comes standard with lifting rings for horizontal or vertical mounting. Ring and pinion gears are fully enclosed for safety and durability.



HDSF clamping legs are fully adjustable, to accommodate multiple pipe diameters and speed setup. Larger HDSF's have eight clamping legs for maximum rigidity and precision.



All HDSF include heavy duty O.D. tracking slides, to compensate for out-of-round pipe. These self centering slides speed setup and time to cut.

# Heavy Duty Split Frame

## HDSF

### SPECIFICATIONS

**System Function:** Split Frame machine tool designed to part, bevel and counterbore large diameter pipe

**System Capacity:** Machines large diameter pipe from 12" to 84" O.D. (DN300-2100), varies by model number

**Drive Options:** Hydraulic and Pneumatic

**Cutting Tool Speed:**

**Hydraulic** Approximate cutting time with hydraulic motor 60-120 and single trip on 60" O.D. (DN1500) pipe with 1" (25.4mm) wall: 54 minutes cutting and beveling

**Pneumatic** 56 Surface Feet/min (17.07 surface meters/min) Surface speed rating w/ air motor @ max power on 84" (2134mm) O.D. pipe

**Power Requirements:**

**Hydraulic** 10 GPM @ 1500 PSI (38 LPM @ 103 BAR)

**Pneumatic** 95 CFM @ 90 PSI (2.7 Cubic Meters per Minute @ 6.2 Bar)

**Feed Method:** Positive mechanical starwheel

**Feed Rate:** Fixed trip rate .0026" (.0661mm) per trip

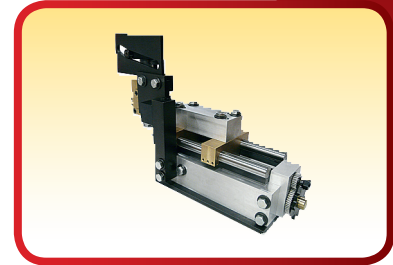
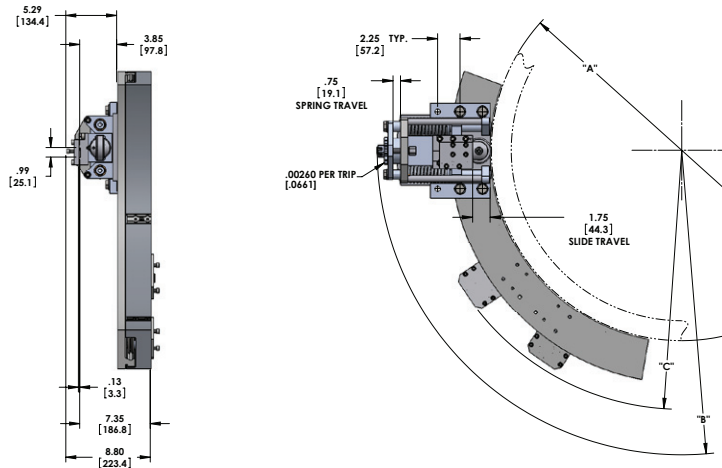
**Construction:** Select hardened alloy steel components, large 6" (152.4mm) cross section, high capacity bearings, heavy duty pinion housing, corrosion resistant finish and ratcheting hinge mechanism.

### STANDARD EQUIPMENT

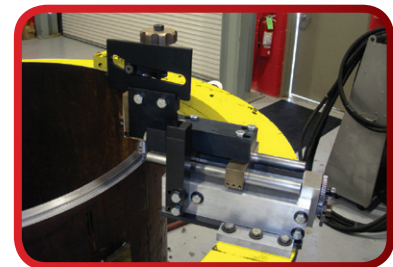
- Hydraulic or Pneumatic Drive Motor
- Heavy Duty O.D. Tracking Tool Slides, (1) Parting and (1) Parting and Beveling
- Auto Resetting Single Trip Assembly
- Lifting Hooks for Vertical or Horizontal Mounting
- Ratcheting Hinge Mechanism for Scissoring Open and Closed
- Self Squaring Mounting System with Adjustable Clamping Legs
- Sealed Chip Resistant Pinion Housing
- Heavy Duty Storage Case
- Operating Hand Tools
- Operation Manual

### OPTIONAL EQUIPMENT

- Dual Pinion Drives
- Cantilever Tool Slide
- Interchangeable Tooling Mounts
- Genuine Wachs Tooling



An innovative accessory, the Cantilever Slide is designed for single point cutting on heavy wall applications, compound bevels, counterboring and flange facing.



Mounted in place of the standard O.D. tracking slides, the Cantilever Slide performs multiple operations via simple reconfiguring.



Ratcheting hinge mechanism allows the HDSF to easily install on the OD of large diameter pipes.

MODEL NUMBER	HDSF 1224	HDSF 2436	HDSF 3648	HDSF 4860	HDSF 6072	HDSF 7284
Machine Capacity Range (Nominal Pipe Size)	12" - 24" (DN300-600)	24" - 36" (DN600-900)	36" - 48" (DN900-1200)	48" - 60" (DN1200-1500)	60" - 72" (DN1500-1800)	72" - 84" (DN1800-2100)
COMPATIBLE WITH COUNTERBORE SLIDE	P03-010-402	P03-010-402	P03-010-402	P03-010-402	P03-010-402	P03-010-402
MAX AXIAL CLEARANCE Cut Line A	10"	10"	10"	10"	10"	10"
MAX AXIAL CLEARANCE Overall B	12"	12"	12"	12"	12"	12"
MAX RADIAL PINION CLEARANCE C	41"	53"	65"	77"	87"	101"
MAX RADIAL SLIDE CLEARANCE D	45"	57"	69"	81"	91"	105"
OPERATING WEIGHT*	950 lbs 431 kg	1200 lbs 544 kg	1800 lbs 816 kg	2200 lbs 998 kg	2600 lbs 1180 kg	3000 lbs 1360 kg

All dimensions shown for pipe diameters are US nominal diameters in inches, plus metric nominal diameters (DN) in parenthesis. Tubing and solid diameters if shown are actual US inches plus metric millimeter equivalents. \*Approximate operating weight, varies by drive and configuration.

**CONTACT US  
 FOR A DEMONSTRATION  
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