

METAL TUBING

HI-DUTY® TUBE CUTTERS

For 1/8" to 1-1/8" and 1/4" to 1-5/8" O.D. tubing.

- Enclosed hardened steel, thrust bearing feed mechanism for smoothest cutting action and trouble free operation.
- Unique design eliminates spiraling for clean right angle cuts. Our high precision machining and construction method permits one-piece screw-type axle for easy access to cutter wheel – no clip to lose or replace.
- Rugged aluminum alloy body designed for handling ease. Body is hand buffed and nickel chrome plated to a high-luster finish.
- Foldaway hardened steel reamer with turned cutting edge removes inside burrs cleanly. Filing surface removes outside burrs.
- Rollers feature flare cut-off groove to reduce tube loss when damaged flare is removed.
- Imperial® cutter wheels are made of the highest quality wear and abrasion-resistant chromium steel and precision machined to exacting specifications for accurate cutting and long life. Each tool is supplied with a spare cutter wheel.
- All Imperial tube cutters are 100% factory tested to ensure accurate spiral-free cutting.



TC-1000

TC-1000 For 1/8" to 1-1/8" (4 mm to 28 mm) O.D. tubing. Includes (2) S75015 general purpose cutter wheels. Length 5". Wt. 8.8 oz.

TC-1010 For 1/8" to 1-1/8" (4 mm to 28 mm) O.D. tubing. Includes (2) S75046 cutter wheels for continuous cutting of stainless steel, monel and other hard-temper tubing. Length 5". Wt. 8.8 oz.

TC-1020 Combination tube constrictor & tube cutter. For 1/8" to 1-1/8" (4 mm to 28 mm) O.D. tubing. Includes S76637 constrictor wheel and S75015 general purpose cutter wheel. Length 5-1/2". Wt. 8.8 oz.

312-FC For 1/4" to 1-5/8" (7 mm to 41 mm) O.D. tubing. Includes (2) S75015 general purpose cutter wheels. Length 5-1/2". Wt. 10.4 oz.

Conforms to Federal Specification GGG-C-771d, Type II, Class I.

S75015 General purpose cutter wheel.

S75046 Wheel for continuous cutting of stainless steel, monel and other hard temper tubing. For cutters TC-1000, TC-1010, TC-1550, TC-1560, 312-FC, 174-F, TC-2050 and TC-3050.

S16003162 Replacement cutter wheel for soft copper & aluminum tubing is extra sharp to minimize burr buildup.

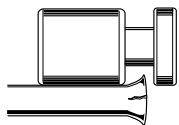
S76637 Constrictor wheel for producing sweat joints.



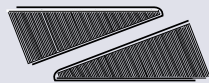
TC-1010



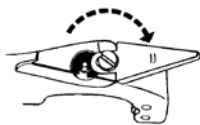
312-FC



FLARE CUT-OFF GROOVE
Groove in rollers reduces tube loss when cracked flare is removed.

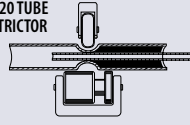


FOLDAWAY REAMER
Hardened steel reamer with turned cutting edge removes inside burrs cleanly. Filing surface removes outside burrs.



SPARE CUTTING WHEEL
Spare cutter wheel carried under foldaway locking reamer.

TC-1020 TUBE CONSTRICTOR



FILL WITH SOLDER
Joint is ready for sweating when constricted tube contacts smaller tube. Can be used for crimping applications.

JUNIOR TUBE CUTTER

For 1/8" to 3/4" (4 mm to 19 mm) O.D. tubing.

227-FA Includes S32633 general purpose cutter wheel. Swing radius 2". Length 3-1/2". Wt. 5.0 oz.



227-FA

TUBING TOOL SELECTOR

TUBING TOOL SELECTOR				TUBE MATERIAL															
TOOL	PART NO.	PAGE NO.	SIZE RANGE TUBE O.D. (in.)	COPPER								ANNEALED ALUMINUM (SOFT)	ANNEALED BRASS (SOFT)	SAE 1020 STEEL (SOFT)	BRAZED- BUNDY WELD GM STEEL	STAINLESS STEEL ANNEALED (SOFT)	STAINLESS STEEL (1/8 HARD)	TITANIUM	
				ANNEALED GENERAL PURPOSE	TYPE K			TYPE L			TYPE M								
					SOFT	BENDING TEMPER-HARD	HARD	SOFT	BENDING TEMPER- HARD	HARD									
Tube Cutters	TC-1000	1	1/8 - 1-1/8	•	•	•	•	•	•	•	•	•	•	•	•	(1)	(1)	(1)	
Metal Tubing	TC-1050	2	1/8 - 5/8	•	•	•	•	•	•	•	•	•	•	•	•				
	TC-2050	2	3/16 - 7/8	•	•	•	•	•	•	•	•	•	•	•	•	(1)	(1)	(1)	
	TC-3050	2	1/8 - 1-1/8	•	•	•	•	•	•	•	•	•	•	•	•	(1)	(1)	(1)	
	174-F	2	3/8 - 1-1/8	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
	206-FB	3	3/8 - 2-5/8	•	•	•	•	•	•	•	•	•	•	•	•				
	227-FA	1	1/8 - 3/4	•	•	•	•	•	•	•	•	•	•	•	•	(1)	(1)	(1)	
	312-FC	1	1/4 - 1-5/8	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
	406-FA	3	2 - 4-1/8	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	
Thermoplastic	307-FP	4	1/16 - 1/2 (4)																
Rubber Hose	327-FP	4	1/8 - 13/16 (4)																
Bending Tools	101-F	4	1/4 - 5/8	•	•	•		•	•				•	•					
	102-F	4	1/4 - 7/8	•	•	•		•	•				•	•					
	112-F	4	1/4 - 3/8	•	•	•		•	•				•	•					
	163-F	4	1/4 - 5/8	•	•	•		•	•				•	•					
	201-F	4	1/4 - 7/8	•	•	•		•	•				•	•					
	260-FHA	9	1/4 - 7/8	•	•	•		•	•				•	•	•	•			
	270-F	10	3/8 - 1-1/8	•	•	•	•	•	•	•			•	•	•	•	•	•	
	350-FHA	9	1/4 - 3/4	•	•	•		•	•				•	•	•	•			
	360-FHA	9	3/8 - 3/4		•			•					•						
	364-FH	7	1/8 - 3/16	•	•			•					•	•	•	•	•		
	364-FHA	7	1/4 - 1 (3)	•	•			•					•	•	•	•	•		
	364-FHAM	7	6 - 12 mm	•	•			•					•	•	•	•	•		
	364-FHB	7	1/4 - 1/2	•	•			•					•	•	•	•	•		
	364-FHBM	7	6 - 12 mm	•	•			•					•	•	•	•	•		
	367-FH	6	1/8, 3/16, 1/4	•	•			•					•	•	•	•			
	368-FH	6	3/16, 1/4, 5/16, 3/8	•	•			•					•	•	•	•			
	370-FH	6	3/16, 1/4, 3/8, 1/2	•	•			•					•	•	•				
	470-FH	5	3/16, 1/4, 5/16, 3/8	•				•					•	•	•				
	564-FH	8	3/8, 1/2	•	•	•		•	•	•			•	•	•	•	•	•	
	600-F	10	1/4 - 3/4	•	•			•					•	•	•	•	•	•	
	664-FH	8	1/4, 3/8, 1/2	•	•			•					•	•	•	•	•	•	
	664-FH(Metric)	8	6 - 12 mm	•	•			•					•	•	•	•	•	•	
37" Flaring Tool	400-F	13	3/16 - 5/8	•	•	•		•	•		(2)		•	•	•	•	•	•	
	437-FB	13	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
	447-F	14	1/8 - 1/2	•	•	•		•	•		(2)		•	•	•	•	•	•	
	507-FB	13	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
	555-FS	15	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
	537-F	14	3/4 - 1-1/4	•	•	•		•	•		(2)		•	•	•	•	•	•	
	637-F	14	1-1/4 - 2	•	•	•		•	•		(2)		•	•	•	•	•	•	
	2000-FS	20	1/8 - 3/4	•	•	•		•	•		(2)		•	•	•	•	•	•	
45" Flaring Tool	103-FS	11	3/4 - 1	•	•	•		•	•		(2)		•	•					
	195-FC	11	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
	203-FA	11	5/8 - 1-1/8	•	•	•		•	•		(2)		•	•					
	275-FS	16	1/8 - 3/4	•	•	•		•	•		(2)		•	•					
	275-FSM		4 - 22 mm	•	•	•		•	•		(2)		•	•					
	300-FB	11	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
	375-FS	11	1/8 - 3/4	•	•	•		•	•		(2)		•	•					
	376-FS		1/2 - 3/4	•	•	•		•	•		(2)		•	•					
	395-FAM		4 - 16 mm	•	•	•		•	•		(2)		•	•					
	500-FC	11	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
	525-F	12	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
			4.75 - 16 mm	•	•	•		•	•		(2)		•	•					
	555-FS	15	3/16 - 5/8	•	•	•		•	•		(2)		•	•					
	2000-FS	20	1/8 - 3/4	•	•	•		•	•		(2)		•	•	•	•	•	•	
45" Double Flaring Tools	93-FB	12	3/16 - 1/2	•				•					•	•	•	•			
	195-FB		1/4 - 3/4	•				•					•	•					
	2000-FS	20	3/16 - 3/4	•				•					•	•	•	•			
Reaming and Deburring Tools	208-F	23	3/16 - 1-1/2	•	•	•	•	•	•	•	•		•	•					
	208-FSS	23	3/16 - 1-1/2	•	•	•	•	•	•	•	•		•	•	•	•	•	•	
	210-F	23		•	•	•		•	•	•	•		•	•	•	•			
Tube Constrictor	TC-1020	1	1/8 - 1-1/8	•	•								•	•					
Swaging Tools	93-S	18	3/16 - 7/8	•	•				•				•	•					
	94-SSP	18	1/2, 5/8, 7/8	•	•				•				•	•					
	95-S	18	3/16 - 5/8	•	•				•				•	•					
	193-S	18	1/4 - 5/8	•	•				•				•	•					
	195-SA	18	1/4 - 5/8	•	•				•				•	•					
	275-FS	16	3/16 - 3/4	•	•				•				•	•					
	555-FS	15	3/16 - 5/8	•	•				•				•	•					
	2000-FS	20	3/16 - 3/4	•	•				•				•	•					
Metric Bubble Flaring Tool	293-F	15	4.75 - 10 mm	•					•				•	•	•	•			

(1) Heavy duty cutting wheel No. S75046 is recommended for continuous service with steel, stainless steel, monel, titanium and hard temper copper tubing.

(2) Type M tubing should be torch annealed before flaring.

(3) No.364-FHA, 5/8" - 1" size should be used only with annealed (softened) non-ferrous tubing.

(4) Not to be used with metal reinforced hose.