

# AIR-DRIVEN CUTTER FEED ASSIST



Model number	Free speed	Governed speed	Weight	Air inlet
CF-150-500	600 rpm	150 – 550 rpm	4.8 kg.	1/4" NPT
CF-400-1200	1250 rpm	400 – 1200 rpm	4.8 kg.	1/4" NPT

Minimum hose size : 1/4" ( 6 mm )

Increase your productivity with the TECO air-driven Cutter Feed Assist. The Cutter Feed Assist is designed to aid the TECO PTC Push Type Tube Cutters for OD tube sizes of 5/8" through 1" (15.9 - 25.4 mm). Powered by an air-driven variable speed drill.

## FEATURES

- Constant pressure on tube cutting surface increases tool bit life, more time cutting tubes, less time changing bits.
- Independent cutter bit feed trigger for operator safety.
- Positive feed stop controls tube cutting depth.
- Easy operation reduces operator fatigue, increasing productivity.
- RPM speed control dial on powerful Drills accommodate various tube sizes and materials for optimum tube cutting speed, increasing your productivity.
- Saving you valuable time and money.
- Simple tube cutter size change over for easy set up.
- Compact design allows the Cutter Feed Assist easier access to confined areas.

## RECOMMENDED CUTTING SPEEDS FOR TUBE CUTTER, TUBE-END FACERS AND WELD REMOVAL TOOLS

Tube Material	Tube O.D.									
	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1"	1 1/4"	1 1/2"	2"
Aluminium (153 mtr / min)	7500 Rpm	5000 Rpm	3800 Rpm	3000 Rpm	2500 Rpm	2200 Rpm	1900 Rpm	1500 Rpm	1275 Rpm	950 Rpm
Brass (92 mtr / min)	4600 Rpm	3050 Rpm	2300 Rpm	1825 Rpm	1525 Rpm	1300 Rpm	1150 Rpm	925 Rpm	750 Rpm	575 Rpm
Copper (76 mtr / min)	3825 Rpm	2550 Rpm	1900 Rpm	1525 Rpm	1275 Rpm	1100 Rpm	950 Rpm	750 Rpm	625 Rpm	500 Rpm
Carbon steel (43 mtr / min)	2150 Rpm	1425 Rpm	1075 Rpm	850 Rpm	700 Rpm	625 Rpm	525 Rpm	425 Rpm	350 Rpm	275 Rpm
Stainless steel (29 mtr / min)	1000 Rpm	660 Rpm	500 Rpm	400 Rpm	330 Rpm	285 Rpm	250 Rpm	200 Rpm	165 Rpm	125 Rpm
Titanium (9.5 mtr / min)	450 Rpm	300 Rpm	230 Rpm	185 Rpm	155 Rpm	130 Rpm	115 Rpm	95 Rpm	75 Rpm	60 Rpm
Inconel (6 mtr / min)	305 Rpm	205 Rpm	155 Rpm	125 Rpm	100 Rpm	90 Rpm	75 Rpm	60 Rpm	50 Rpm	40 Rpm

The recommended cutting speeds above are based on published speeds and feeds.  
A slower speed may be necessary depending on tube material analysis and hardness.  
Proper lubricant must be used.