



# Vulcan Tool Company

## Automatic Tube Cutting Equipment

With Brehm® Supported Shear Technology

## Ultimate Tube Cutters for High Speed, Burr-Free Cut-Off with No Waste Between Cuts

### Standard Features:

- The Ultimate Brehm® Single-Pass machine is a servo-driven advance with a MicroCentric Hydraulic Collet System
- Quickpanel Interactive Graphic Display Operator Panel
- Includes a Custom Length Integrated Magazine Loader
- Automatic Scrap Separator
- Single-Pass Tube Shearing
- Optional In-Process Length Measurement and Gauging



2<sup>1</sup>/<sub>2</sub>" Model with Quickpanel Option

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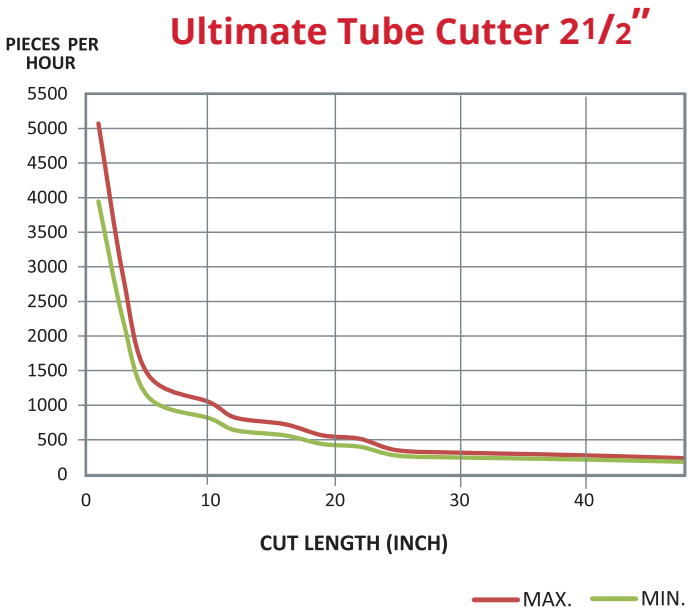
# What the Ultimate can do for You:

- High Production-High Speed Cut-Off
- Fully Automatic
- Standard machine cuts to length from under 1" up to 48"
- No material loss between cut pieces
- Commercially Burr-Free, with little to no distortion
- Cuts length to tolerances in thousandths
- High speed cut-off of tubing for the 2 1/2" Model range from 3/4" OD to 2 1/2" OD and the 4" model range from 3/4" OD to 4" OD
- 6" model available - Please inquire
- Single-Pass High Clearance ID Tooling is preferred for out of camber tube



Finishing up a Vulcan Ultimate with a sound enclosure.

## Production Capacity Example



## Tube Cutting Capacity Example

The maximum wall thickness that can be cut in the tube diameters is governed by the construction of the tooling. It should not exceed 8% of the OD or the hydraulic cutting capacity of each machine. The following are maximum wall thicknesses for cutting mild steel:

2 1/2" Model		4" Model	
Tube OD	Maximum Tube Wall	Tube OD	Maximum Tube Wall
1/2"	.040	3/4"	.059
3/4"	.060	1"	.080
1"	.080	1 1/4"	.100
1 1/4"	.110	1 1/2"	.120
1 1/2"	.112	2"	.160
1 3/4"	.110	2 1/2"	.200
2"	.095	3"	.170
2 1/4"	.085	3 1/2"	.145
2 1/2"	.075	4"	.125