

Tube Specialty Tools



Just as there are different reasons for finishing the cut ends of pipe or tubing, there are different tools and methods for doing the job.

1. Often, the only reason for finishing the cut end is to get rid of burrs caused by the cutting process. In that case, Tube End Deburring Cutters may make quick work of the task.
2. To facilitate assembly with other components, tube ends may be chamfered, using Severance Tube End Chamfering Mills.
3. The third method, forming, is used when appearance is important, as in an exposed tube end. Forming may also be recommended when the cut end must be square with the tube axis. Forming is the only method that finishes the end as well as the corners.

Tube End Deburring Cutters

Deburring cutters are identified as having smaller, more numerous cutting teeth than chamfering or forming tools. They can be operated over a wide speed range (slower is better in nonrigid setups) and take light cuts very quickly. Tube End Deburring Cutters are available from stock in sizes ranging from 1/8" to 2-1/4" OD. Each is adjustable for wall thickness. Standard cutters feature 30° and 45° centerline angles.

Inside, outside and tube end deburring cutters are available in carbide as well as HSS.

We also catalog the HR-Series radius deburring tools, which is usually sold with a handle for manual operation.

Tube End Chamfering Mills

Severance Tube End Chamfering Mills have cutting edges designed to provide a shearing action, yielding a smoothly machined surface. The standard tool produces a 30° angle on the tube ID and 45° on the OD. Other angles may be ordered as specials. This series of tools is offered in a range of sizes to accommodate pipe and tubing from 3/16" to 2-1/2" outside diameters. All models are adjustable for different wall thicknesses.

Severance also manufactures separate chamfering mills for inside and outside cutting. Inside Chamfering Mills are stocked in 1/2" to 1-1/2" sizes, with 30° or 45° centerline angles. Outside Chamfering Mills, for working diameters from 1/8" to 3" are also stocked in 30° or 45° models.

Tube End Forming Cutters

As the name implies, Severance Tube End Forming Cutters completely machine the cut ends of tubular products. They produce a smoothly rounded surface, which is both attractive and functional.

Because they are of solid construction, a specific tool is required for each different workpiece diameter and wall thickness. We also make many custom tube end forming cutters ... for nonstandard sizes and for machining profiles other than blended radii. Carbide is available on sizes of 3/8" OD and larger.

