

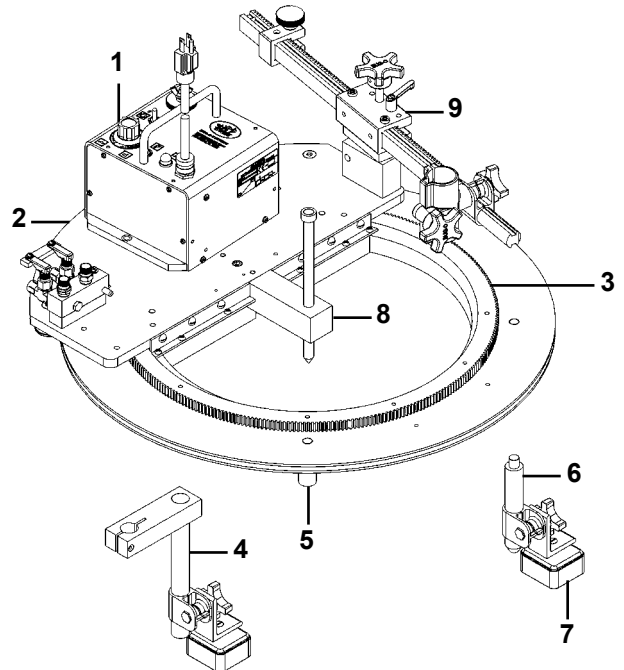
Affordable Automation for Welding, Cutting and Semi-Automatic Processes

CIR-O



* Torch Not Included.

CIR-O machines are lightweight, heavy-duty, multiple-use circular drives. Each of the three sizes of machines has a positive rack and pinion drive and infinitely variable speed control which provides smooth, accurate travel in all positions. The carriage provides a mounting surface for a variety of different process tools. A single center-punch mark is all that is needed to locate the machine on the workpiece. It is then ready to flame-cut, bevel or weld. Permanent magnets or vacuum cups can be purchased separately to hold it in place.



1. **BUG-5100-F** drive unit provides the power with a solid-state variable speed control.
2. **CIR-3040**, **CIR-4040** and **CIR-5040** carriage insures accurate work paths by meshing firmly with the gear. A quick-acting manifold with a short connection hose, and a centering pin are mounted on the carriage.
3. **CON-3000**, **CON-4000**, **CON-5000** ring and gear assembly with its perfectly round cut gear makes every cut true.
4. **OPTIONAL CIR-9002** offset leg and magnet assembly - four of these units are used to eliminate the blind spot under the ring. Each unit clamps onto a standard leg. An adjustable tip adaptor must be used to offset the cutting tip under the ring.
5. Standard 2" (50 mm) leg [four supplied with the machine].
6. **OPTIONAL CIR-9021** 5" (127 mm) leg [use with template kit and CIR-9020 magnet foot].
7. **OPTIONAL CIR-9020** magnet foot [use with CIR-9021 5" (127 mm) leg] locks machine to work - four required.
8. Center location with stainless steel center pin.
9. Rotating post mount - this combination of modules provide accurate positioning of a torch for any single torch operation.



BUG-O SYSTEMS
A DIVISION OF WELD TOOLING CORPORATION



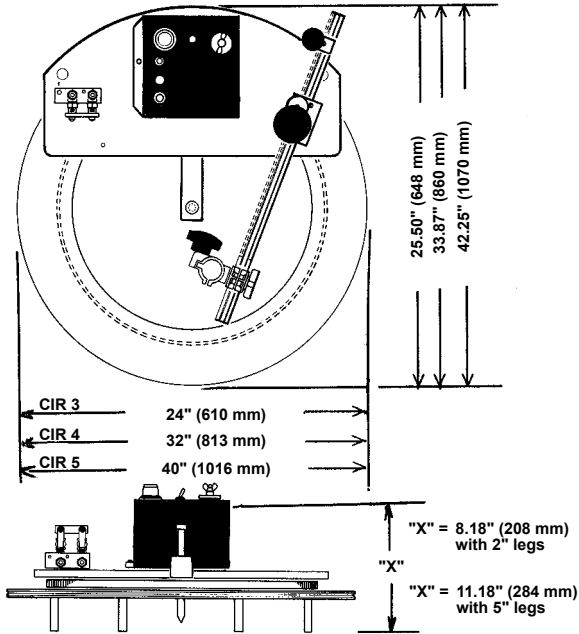
280 TECHNOLOGY DRIVE CANONSBURG, PENNSYLVANIA 15317-9564 USA
PHONE: 1-412-331-1776 <http://www.bugo.com> FAX: 1-412-331-0383



CIR-O HEAVY DUTY CIRCLE CUTTER

Capacities and Speed Ranges

Dimensions:

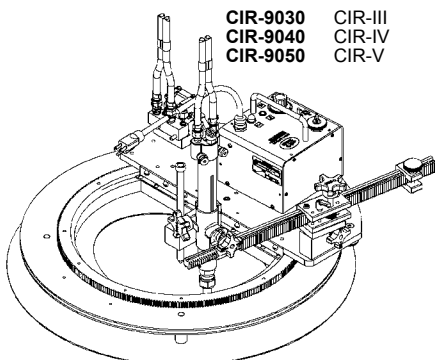


NOTE: Torches, tips and magnets or vacuum cups must be ordered separately.

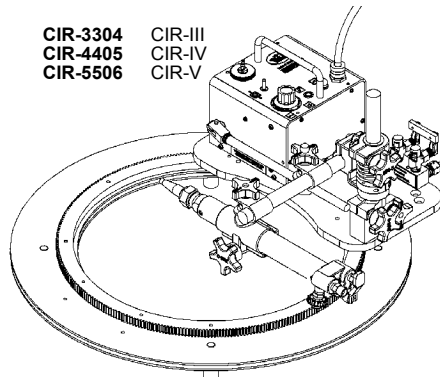
| PART NUMBER | POWER REQUIREMENT | PART NUMBER | SHIPPING WEIGHT | NET WEIGHT |
|-------------|-------------------|------------------------|---|-------------------|
| CIR-3303 | 120 VAC/50-60-1 | CIR-3303 | 66 lbs. (30.0 kg) | 48 lbs. (21.8 kg) |
| CIR-3323 | 240 VAC/50-60-1 | CIR-3323 | | |
| CIR-3313 | 42 VAC/50-60-1 | CIR-3313 | | |
| CIR-4404 | 120 VAC/50-60-1 | CIR-4404 | 90 lbs. (40.8kg) | 65 lbs. (29.5 kg) |
| CIR-4424 | 240 VAC/50-60-1 | CIR-4424 | | |
| CIR-4414 | 42 VAC/50-60-1 | CIR-4414 | | |
| CIR-5505 | 120 VAC/50-60-1 | CIR-5505 | 128 lbs. (58.0 kg) | 90 lbs. (40.9 kg) |
| CIR-5525 | 240 VAC/50-60-1 | CIR-5525 | | |
| CIR-5515 | 42 VAC/50-60-1 | CIR-5515 | | |
| | | INSIDE DIAMETER | OUTSIDE DIAMETER | |
| CIR-3303 | CIR-3323 | CIR-3313 | 3"-14" (75-356 mm) 26"-56" (660-1422 mm) | |
| CIR-4404 | CIR-4424 | CIR-4414 | 3"-22" (75-559 mm) 34"-64" (864-1626 mm) | |
| CIR-5505 | CIR-5525 | CIR-5515 | 3"-30" (75-760 mm) 42"-72" (1060-1830 mm) | |

| | | DIAMETER | | DIAMETER | |
|---------|--------------|----------|---------|----------|----------|
| | | INCH | IPM | MM | MM/MIN |
| CIR-III | INSIDE RING | 3 | .4-8 | 75 | 10-210 |
| | | 6 | .8-16 | 150 | 20-420 |
| | | 10 | 1.4-28 | 250 | 35-700 |
| | OUTSIDE RING | 14 | 2-39 | 350 | 50-1000 |
| | | 26 | 3.5-70 | 650 | 90-1805 |
| | | 30 | 4-80 | 750 | 105-2100 |
| CIR-IV | INSIDE RING | 34 | 4.5-92 | 850 | 120-2400 |
| | | 38 | 5.2-105 | 950 | 130-2640 |
| | | 42 | 5.7-115 | 1050 | 50-3000 |
| | | 46 | 6.3-125 | 1140 | 60-3200 |
| | | 50 | 6.8-135 | 1250 | 175-3500 |
| | OUTSIDE RING | 56 | 7.6-155 | 1420 | 200-4000 |
| | | 3 | .3-5 | 75 | 7-140 |
| | | 6 | .6-11 | 150 | 14-280 |
| | | 10 | .9-18 | 250 | 23-460 |
| | | 14 | 1.3-26 | 350 | 32-650 |
| CIR-V | INSIDE RING | 18 | 1.7-33 | 450 | 42-840 |
| | | 22 | 2-40 | 550 | 50-1000 |
| | | 34 | 3.2-63 | 850 | 80-1600 |
| | | 38 | 3.5-70 | 950 | 87-1760 |
| | | 42 | 3.9-78 | 1050 | 97-1950 |
| | OUTSIDE RING | 46 | 4.3-85 | 1150 | 105-2130 |
| | | 50 | 4.6-93 | 1250 | 115-2300 |
| | | 54 | 5-100 | 1350 | 125-2500 |
| | | 58 | 5.4-110 | 1450 | 135-2700 |
| | | 64 | 6-120 | 1625 | 150-3000 |
| CIR-V | INSIDE RING | 3 | .2-4 | 75 | 5-100 |
| | | 6 | .4-8 | 150 | 10-210 |
| | | 10 | .7-13 | 250 | 17-350 |
| | | 14 | 1-19 | 350 | 24-500 |
| | | 18 | 1.3-25 | 450 | 32-640 |
| | | 22 | 1.5-30 | 550 | 38-760 |
| | OUTSIDE RING | 26 | 1.8-37 | 650 | 45-900 |
| | | 30 | 2-41 | 750 | 52-1050 |
| | | 42 | 2.9-57 | 1050 | 73-1458 |
| | | 46 | 3.2-63 | 1150 | 80-1600 |
| CIR-V | OUTSIDE RING | 50 | 3.4-68 | 1250 | 87-1750 |
| | | 54 | 3.7-75 | 1350 | 94-1900 |
| | | 58 | 4-80 | 1450 | 100-2000 |
| | | 62 | 4.3-85 | 1550 | 105-2150 |
| | | 66 | 4.5-90 | 1650 | 115-2300 |
| | | 72 | 4.9-100 | 1825 | 125-2500 |

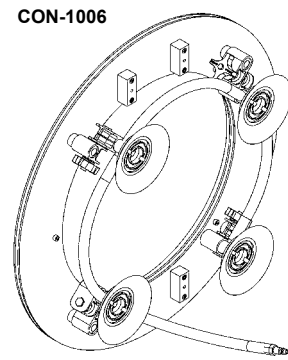
Optional Accessories:



CIR-9030 CIR-III
 CIR-9040 CIR-IV
 CIR-9050 CIR-V



CIR-3304 CIR-III
 CIR-4405 CIR-IV
 CIR-5506 CIR-V



CON-1006

TEMPLATE KIT - consists of a sheet aluminum master template, alignment bars, spacer legs, tensioning assembly and torchholder. Pattern is cut in tempered hardboard and bolted to ring.

ANNULAR CARRIAGE - for special welding and cutting applications - when material to be cut or welded passes through the ring track.

VACUUM MOUNTS - CON-1006 for use on non-ferrous material such as stainless, aluminum etc. Use with ARV-2020 Vacuum Pump Kit.