

SADDLE MACHINE MOTORIZED / MANUAL



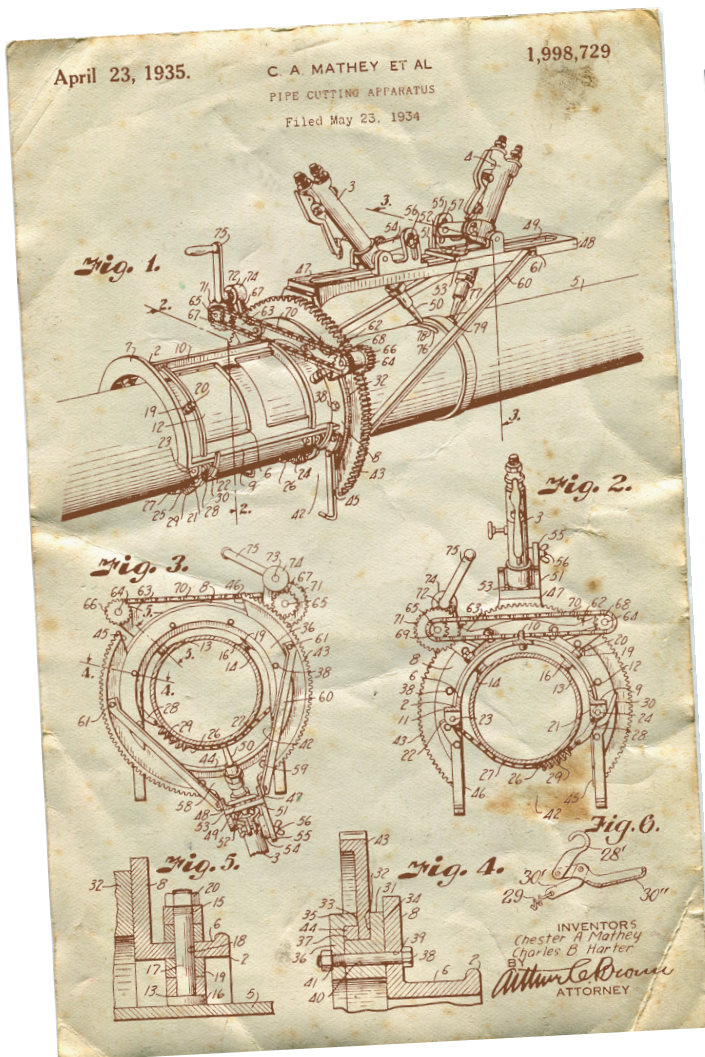
PRODUCT BROCHURE

1.5 - 48" / 38 - 1,219 mm

The industry standard for over 90 years, the Mathey Dearman saddle machine is versatile, simple to use, and perfect for almost any pipe cutting and beveling application. Lightweight and durable, the Mathey Dearman machine is designed for accurate, quality cuts on 1.5 - 48" / 38 - 1,219 mm pipes.

- Versatile** - every model works on a range of pipe sizes
- Adaptable** - works with all standard torches, including plasma
- Portable** - light and compact, perfect for shop or field applications
- Easy set-up** - mount and begin cutting in as little as 5 minutes
- Proven** - depended on by professionals for over 70 years
- Fast** - pipe is ready to weld up to five times quicker than hand cutting and grinding

Mathey Dearman has been the leader in pipe cutting since its invention of the saddle machine in 1934.



Manual saddle machine includes:

- Saddle machine
- Torch arm
- Torch carrier assembly (torch diameter 1.375" / 35 mm)
- Boomer assembly (fastens the machine to the pipe)
- Spacer bolt set
- Parts and operating manual

Note: Machine torches sold separately.



Want the easiest way to get a perfect cut every time?

Motorized saddle machines from Mathey Dearman are precise and fast, delivering smooth cuts requiring little or even no grinding. Both experienced and inexperienced welders can benefit from the increased productivity (up to 5 times quicker!) and cut quality of motorized saddle machines compared to traditional hand-cutting or manual machines.

Motorized PLASMASPEED saddle machines can use 110/230 VAC for pipe sizes 1.5 - 48" / 38 - 1,219 mm and can operate at increased cutting speeds to use powerful plasma torches.

It's what Mathey Dearman calls PLASMASPEED!

Motorized saddle machine includes:

- 110/230 VAC motorized saddle machine
- Torch arm
- Torch carrier assembly
- Boomer assembly (fastens the machine to the pipe)
- Spacer bolt set
- Parts and operating manual
- Mounting bracket
- Right-angle precision stepper motor
- Motor control box
- Plasma communication cable (10 foot length, compatible with Hypertherm plasma cutter with a CPC port)

Note: Machine torches sold separately - machine shown with optional step spacers and pro model torch.



Conventional cutting vs saddle cutting time

Hand cutting

Time: 30 minutes

- 8" schedule 40 pipe being cut by hand. Time includes measuring, cutting and grinding
- Longer than necessary layout time
- Excessive amount of time to cut the pipe
- Inaccurate/uneven cut requiring grinding
- Extended fit-up time
- Uneven weld gap

Mathey Dearman cutting

Time: 6 minutes

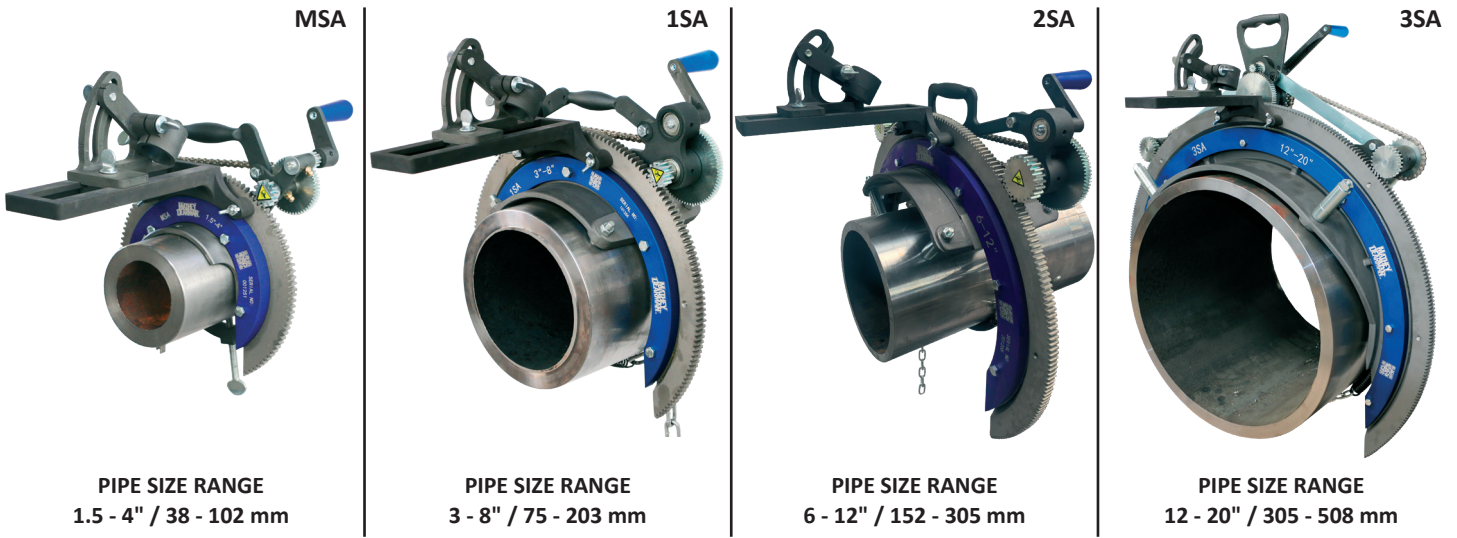
- 8" schedule 40 Pipe being cut with a 1SA manual saddle machine
- Perfect cut
- No grinding
- Perfect fit-up

The above is approximate



SADDLE MACHINE MOTORIZED / MANUAL

1.5 - 48" / 38 - 1,219 mm



MANUAL SADDLE MACHINES

MACHINE MODEL	MSA	1SA	2SA
Manual with spacer bolts	03.0100.000	03.0101.000	03.0102.000
Manual with step spacers	n/a	03.01S1.000	03.01S2.000

MOTORIZED SADDLE MACHINES / PLASMASPEED

MACHINE MODEL	MSA	1SA	2SA
Motorized with spacer bolts 115/230 VAC	03.0100.S01	03.0101.S01	03.0102.S01
Motorized with step spacers 115/230 VAC	n/a	03.01S1.S01	03.01S2.S01

PLASMASPEED RETROFIT KITS

MACHINE MODEL	MSA	1SA	2SA
PLASMASPEED retrofit kits 115/230 VAC	03.0100.SA1	03.0101.SA1	03.0101.SA1

GENERAL SPECIFICATIONS

MACHINE MODEL	MSA	1SA	2SA
Pipe size	1.5 - 4" / 38 - 102 mm	3 - 8" / 75 - 203 mm	6 - 12" / 152 - 305 mm
Net weight	10 lbs / 5.00 kg	16 lbs / 7.00 kg	26 lbs / 12.00 kg
Estimated shipping weight	12 lbs / 5.44 kg	24 lbs / 10.89 kg	34 lbs / 15.40 kg
Shipping dimensions	12 x 12 x 10" (305 x 305 x 254 mm)	18 x 18 x 11.5" (457 x 457 x 492 mm)	23 x 23 x 12.5" (584 x 584 x 318 mm)
Maximum speed (motorized) ipm* / mpm**	141 / 3,581	71 / 1,803	89 / 2,261
Minimum speed (motorized) ipm* / mpm**	4 / 102	4 / 102	6 / 152
Includes spacer bolts to cut pipe sizes	2", 3", 4" (60.3, 88.9, 114.3 mm)	3", 4", 6", 8" (88.9, 114.3, 168.2, 219 mm)	6", 8", 10", 12" (168.2, 219, 273, 323.8 mm)

* inches per minute | ** millimeters per minute



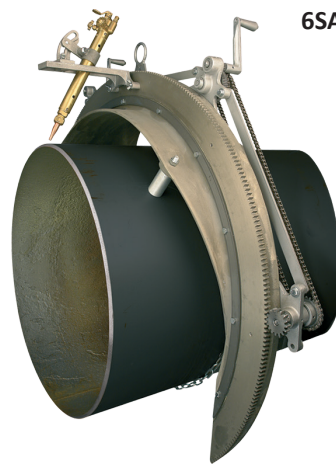
4SA

PIPE SIZE RANGE
20 - 26" / 508 - 660 mm



5SA

PIPE SIZE RANGE
24 - 30" / 610 - 762 mm



6SA

PIPE SIZE RANGE
28 - 36" / 711 - 914 mm



8SA

PIPE SIZE RANGE
36 - 48" / 914 - 1,219 mm

3SA	4SA	5SA	6SA	8SA
03.0103.000	03.0104.000	03.0105.000	03.0106.000	03.0108.000
03.01S3.000	n/a	n/a	n/a	n/a

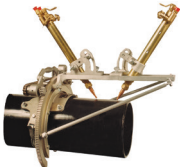
3SA	4SA	5SA	6SA	8SA
03.0103.S01	03.0104.S01	03.0105.S01	03.0106.S01	03.0108.S01
03.01S3.S01	n/a	n/a	n/a	n/a

3SA	4SA	5SA	6SA	8SA
03.0103.SA1	03.0103.SA1	03.0105.SA1	03.0105.SA1	03.0105.SA1

3SA	4SA	5SA	6SA	8SA
12 - 20" / 305 - 508 mm	20 - 26" / 508 - 660 mm	24 - 30" / 610 - 762 mm	28 - 36" / 711 - 914 mm	36 - 48" / 914 - 1,219 mm
50 lbs / 22.00 kg	75 lbs / 34.00 kg	110 lbs / 50.00 kg	180 lbs / 82.00 kg	287 lbs / 130.00 kg
73 lbs / 33.10 kg	150 lbs / 68.00 kg	185 lbs / 71.70 kg	295 lbs / 133.80 kg	537 lbs / 243.60 kg
34 x 32 x 12" (864 x 813 x 305 mm)	40.5 x 41 x 19" (1,029 x 1,041 x 423 mm)	40.5 x 41 x 19" (1,029 x 1,041 x 423 mm)	57 x 43 x 18" (1,488 x 1,002 x 483 mm)	69 x 60 x 21" (1,753 x 1,524 x 533 mm)
47 / 1,194	53 / 1,346	34 / 864	35 / 889	36 / 914
7 / 178	7 / 178	8 / 203	5 / 127	5 / 127
12", 14", 16", 18", 20" (323.8, 356, 406, 457, 508 mm)	20", 22", 24", 26" (508, 559, 610, 660 mm)	24", 26", 28", 30" (610, 660, 711, 762 mm)	28", 30", 36" (711, 762, 914 mm)	36", 38", 40", 42", 48" (914, 964, 1,016, 1,067, 1,219 mm)

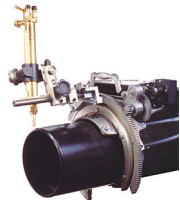
DOUBLE TORCH ARM

Reduce set up and cutting time by up to 50% with the double torch arm accessory. By eliminating the need to rotate one torch to obtain a forward or back bevel on the pipe end, the double torch arm dramatically reduces cutting and beveling time. Torch arm accommodates American torch rack size only.

PART NO.	MODEL	PIPE SIZE		PACKAGED WEIGHT		PACKAGED DIMENSIONS		PICTURE
03.0101.030	1SA	3 - 8"	88.9 - 219 mm	5 lbs	2.30 kg	20 x 6 x 6"	508 x 152 x 152 mm	
03.0102.015	2SA	8 - 12"	219 - 323.8 mm	5 lbs	2.30 kg	20 x 6 x 6"	508 x 152 x 152 mm	
03.0103.030	3SA	12 - 20"	323.8 - 508 mm	5 lbs	2.30 kg	23 x 10 x 9"	584 x 254 x 229 mm	
03.0104.021	4SA	20 - 26"	508 - 660 mm	5 lbs	2.30 kg	23 x 10 x 9"	584 x 254 x 229 mm	
03.0105.025	5SA	24 - 30"	610 - 762 mm	5 lbs	2.30 kg	23 x 10 x 9"	584 x 254 x 229 mm	
03.0106.018	6SA	28 - 36"	711 - 914 mm	5.5 lbs	2.50 kg	23 x 10 x 9"	584 x 254 x 229 mm	
03.0108.014	8SA	36 - 48"	914 - 1,219 mm	5.5 lbs	2.50 kg	23 x 10 x 9"	584 x 254 x 229 mm	

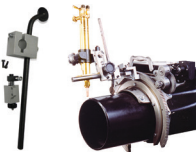
PRO MODEL TORCH ARM

Choose the pro model torch arm with the innovative out-of-round roller attachment to create perfect cuts and bevels on oversize, undersize or out-of-round pipe. Torch arm accommodates American torch rack size only.

PART NO.	DESCRIPTION	PACKAGED WEIGHT		PACKAGED DIMENSIONS		PICTURE
03.0209.000	Pro model with out of round	9.50 lbs	4.30 kg	16 x 8 x 8"	406 x 203 x 203 mm	
03.0209.001	Pro model basic assembly	7 lbs	3.20 kg	16 x 8 x 8"	406 x 203 x 203 mm	
03.0209.012	Tracer point	1.60 lbs	0.70 kg	12 x 6 x 6"	305 x 152 x 152 mm	
Torch holders that can accommodate up to 2" barrel diameter torches are available						

OUT-OF-ROUND ROLLER ATTACHMENT

The out-of-round roller attachment kit, that can be fitted on the pro model torch arm, compensates for oversize and undersize pipe, handling out-of-round conditions up to ¼" / 6 mm. This separate attachment comes with all required parts and assembly instructions.

PART NO.	DESCRIPTION	PACKAGED WEIGHT		PACKAGED DIMENSIONS		PICTURE
03.0209.003	Out-of-round roller attachment kit <i>The picture shows pro model with out-of-round roller attachment kit installed</i>	2.50 lbs	1.10 kg	12 x 6 x 6"	305 x 152 x 152 mm	

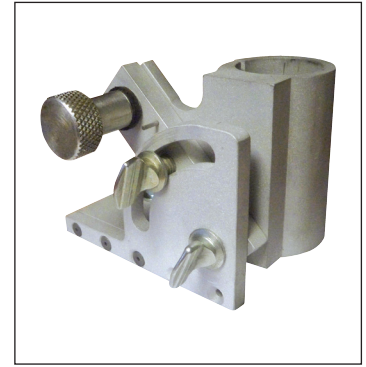
CAM-ADJUSTABLE TORCH CARRIER

The cam-adjustable torch carrier (diameter of 1.375" / 35 mm) makes it simple to make perfect, no-notch cuts, every time. Just start the cut away from the desired cut line, use the knurled cam adjustment knob to move the torch into the cut line then start cutting.

In addition, the torch holder's large wing screw makes tightening the torch in the torch holder easy, even when wearing gloves.

The innovative design even allows forward or back-beveling without the need to reverse the torch holder in the torch arm.

PART NO. 03.0100.052



SADDLE MACHINE STORAGE BOX

Store and help protect the saddle machine, torch, torch arm, torch carrier, spacer bolts and parts and operating manual in this specially-designed storage box.

MSA, 1SA, and 2SA storage boxes are made of 16 gauge, powder-coated steel, with attached lifting handles.

Storage boxes for saddle machines larger than the 3SA are made of plywood with reinforced corners and edges.



PART NO.	MODEL	DIMENSIONS		MANUAL OR MOTORIZED	BOX TYPE	PACKAGED WEIGHT	
03.0100.BOX	MSA	18 x 18 x 10"	457 x 457 x 254 mm	Manual only	Metal	23 lbs	10.40 kg
03.0101.BOX	1SA	23 x 23 x 13"	584 x 584 x 330 mm	Manual only	Metal	33 lbs	14.90 kg
03.0102.BOX	2SA	34 x 32 x 12"	635 x 559 x 305 mm	Manual only	Metal	41 lbs	18.50 kg
03.0103.BOX	3SA	34 x 32 x 14"	635 x 559 x 356 mm	Manual or motorized	Wood	60 lbs	27.00 kg
03.0104.BOX	4SA	40 x 38 x 14"	1,016 x 965 x 356 mm	Manual or motorized	Wood	79 lbs	35.60 kg
03.0105.BOX	5SA	42 x 40 x 14"	1,067 x 1,016 x 356 mm	Manual or motorized	Wood	84 lbs	37.80 kg
03.0106.BOX	6SA	56 x 48 x 16"	1,422 x 1,219 x 406 mm	Manual only	Wood	100 lbs	45.00 kg
03.0108.BOX	8SA	70 x 56 x 19"	1,778 x 1,422 x 483 mm	Manual only	Wood	125 lbs	56.30 kg

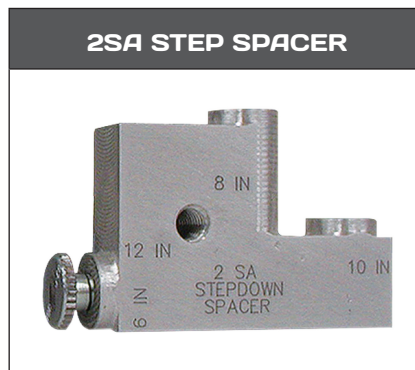
*** No spacers required for 4" pipe set up**

SELF-STORING STEP-DOWN SPACER

Combining multiple spacer bolt sizes into one easy-to-use part, the step-down spacers are machined to the same tolerances as spacer bolts. Each step spacer covers a range of four (4) pipe sizes; eliminating the need to store 16 spacer bolts. No more searching for lost or misplaced spacer bolts with high quality aluminum alloy or stainless steel self-storing step-down spacers.

STEP SPACER KIT

PART NO.	DESCRIPTION	FOR PIPE SIZES		PACKAGED WEIGHT	
03.0110.1SAKIT	1SA Step Spacers	3", 4", 6", 8"	88.9 mm, 114.3 mm, 168.2 mm, 219 mm	1.60 lbs	0.70 kg
03.0110.2SAKIT	2SA Step Spacers	6", 8", 10", 12"	168.2 mm, 219 mm, 273 mm, 323.8 mm	1.60 lbs	0.70 kg
03.0110.3SAKIT	3SA Step Spacers	12", 14", 16", 18", 20"	323.8 mm, 356 mm, 406 mm, 457 mm, 508 mm	1.60 lbs	0.70 kg



SADDLE MACHINE SPACER BOLTS

Spacer Bolt Kits include the spacer bolts in one handy container available for any Mathey Dearman saddle machine model. An actual-size diagram is located on the lid, making finding the correct Spacer Bolts quick and easy. All spacer bolts are precision-machined for maximum cutting accuracy and labeled with the Mathey Dearman logo and Part No. for quick identification.

Actual size is shown on box lid for quick spacer bolt identification.



SPACER BOLT KITS

PART NO.	DESCRIPTION	FOR PIPE SIZES		PACKAGED WEIGHT	
03.0MSA.KIT	MSA	2", 3"	60.3 mm, 88.9 mm	1 lbs	0.50 kg
03.01SA.KIT	1SA	3", 4", 6", 8"	88.9 mm, 114.3 mm, 168.2 mm, 219 mm	4 lbs	1.80 kg
03.02SA.KIT	2SA	6", 8", 10", 12"	168.2 mm, 219 mm, 273 mm, 323.8 mm	5 lbs	2.30 kg
03.03SA.KIT	3SA	12", 14", 16", 18", 20"	323.8 mm, 356 mm, 406 mm, 457 mm, 508 mm	9 lbs	4.10 kg
03.04SA.KIT	4SA	20", 22", 24", 26"	508 mm, 559 mm, 610 mm, 660 mm	10 lbs	4.50 kg
03.05SA.KIT	5SA	24", 26", 28", 30"	610 mm, 660 mm, 711 mm, 762 mm	10 lbs	4.50 kg
03.06SA.KIT	6SA	28", 30", 36"	711 mm, 762 mm, 914 mm	20 lbs	9.00 kg
03.08SA.KIT	8SA	36", 38", 40", 42", 48"	916 mm, 964 mm, 1,016 mm, 1,069 mm, 1,219 mm	20 lbs	9.00 kg

*** No spacers required for 4" pipe set up**