

SADDLE MACHINES | MOTORIZED / MANUAL

The industry-standard for over 70 years, the Mathey Dearman Saddle Machine is versatile, simple to use, and perfect for almost any pipe cutting and beveling application. Lightweight and durable, Mathey Dearman Saddle Machines are designed for accurate, quality cuts on 1 ½" – 48" (38 mm – 1219 mm) pipes.

EASY SET-UP | Mount and begin cutting in as little as 5 minutes

ADAPTABLE | Works with all standard torches, including plasma

PRECISE | Produces square cuts and exact bevels quickly and easily

FASTER | Quicker than manual machines by virtually eliminating grinding

Motorized Saddle Machine Includes:

- | 115 VAC or 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 DC drive motor
- | Motor Control Box

NOTE: MACHINE TORCHES SOLD SEPARATELY



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



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 Saddle Machines are available in 115 VAC and 230 VAC for pipe sizes 1 1/2" – 48" (38 – 1219 mm) and can operate at increased cutting speeds to use powerful plasma torches. It's what Mathey Dearman calls PLASMASPEED!.

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

Saddle Machine Includes:

- | Saddle Machine
- | Torch Arm
- | Torch Arm Assembly
- | Boomer Assembly (fastens the machine to the pipe)
- | Spacer Bolts
- | Parts and Operating Manual

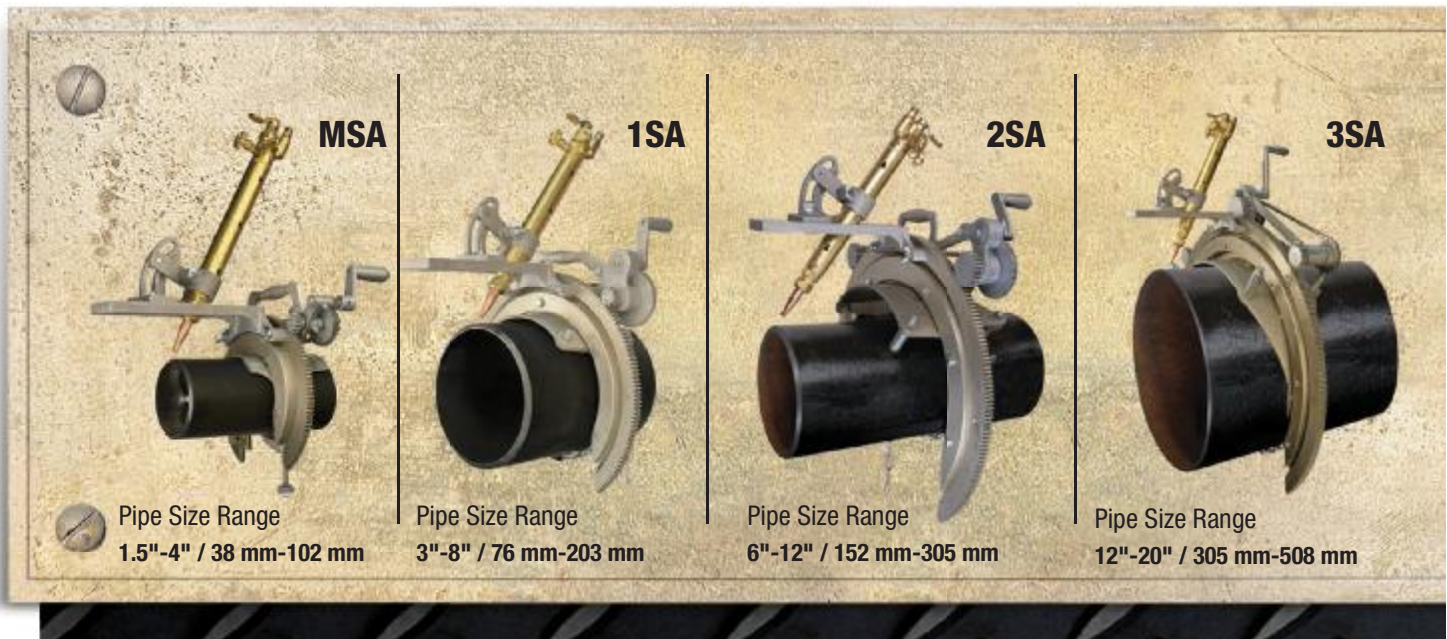
NOTE: MACHINE TORCHES SOLD SEPARATELY

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

SADDLE MACHINES | MOTORIZED / MANUAL



Machine Model	MSA	1SA	2SA
Manual with Spacer Bolts	03.0100.000	03.0101.000	03.0102.000
Manual with Step Spacers	-----	03.01S1.000	03.01S2.000

SADDLE MACHINES | SPECIFICATIONS

Machine Model	MSA	1SA	2SA
Motorized with Spacer Bolts 115 VAC 230 VAC	03.0100.M00 03.0100.M02	03.0101.M00 03.0101.M02	03.0102.M00 03.0102.M02
Motorized with Step Spacers 115 VAC 230 VAC	-----	03.01S1.M00 03.01S1.M02	03.01S2.M00 03.01S2.M02
Pipe Size in (mm)	1.5-4 (38-102)	3-8 (76-203)	6-12 (152-305)
Net Weight lbs / kg	10 / 5	16 / 7	26 / 12
Estimated Shipping Weight lbs / kg	12 / 5.4	24 / 11	34 / 15.5
Shipping Dimensions in (mm)	12 x 12 x 10 (305 x 305 x 254)	18 x 18 x 11 ¹ / ₂ (457 x 457 x 492)	23 x 23 x 12 ¹ / ₂ (584 x 584 x 318)
Max. Speed (Motorized) ipm* / mpm**	141 / 3581	71 / 1803	89 / 2261
Min. Speed (Motorized) ipm* / mpm**	4 / 102	4 / 102	6 / 152
Includes Spacer Bolts to cut pipe sizes	2", 3", 4" (51, 76, 102 mm)	3", 4", 6", 8" (76, 102, 152, 203 mm)	6", 8", 10", 12" (152, 203, 254, 305 mm)

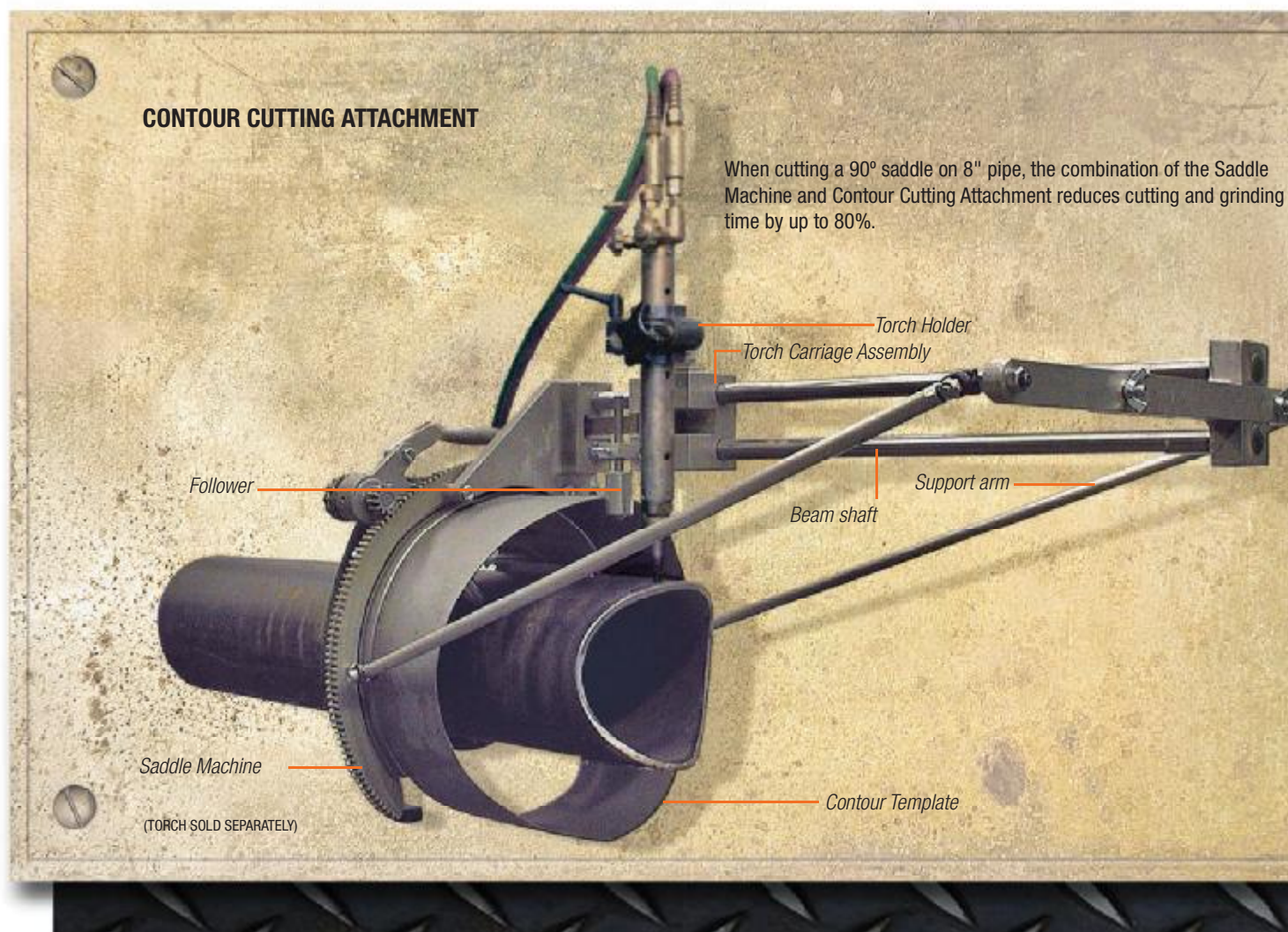
* Inches per minute

** Millimeters per minute



	3SA	4SA	5SA	6SA	8SA
	03.0103.000	03.0104.0 00	03.0105.000	03.0106.000	03.0108.000
	03.01S3.000	-----	-----	-----	-----

	3SA	4SA	5SA	6SA	8SA
	03.0103.M00 03.0103.M02	03.0104.M00 03.0104.M02	03.0105.M00 03.0105.M02	03.0106.M00 03.0106.M02	03.0108.M00 03.0108.M02
	03.01S3.M00 03.01S3.M02	-----	-----	-----	-----
	12-20 (305-508)	20-26 (508-660)	24-30 (610-762)	28-36 (711-914)	40-48 (1016-1219)
	50 / 22	75 / 34	110 / 50	180 / 82	287 / 130
	73 / 33	150 / 68	185 / 84	295 / 134	537 / 244
	34 x 32 x 12 (864 x 813 x 305)	40 1/2 x 41 x 19 (1029 x 1041 x 423)	40 1/2 x 41 x 19 (1029 x 1041 x 423)	57 x 43 x 18 (1488 x 1002 x 483)	69 x 60 x 21 (1753 x 1524 x 533)
	47 / 1194	53 / 1346	34 / 864	35 / 889	36 / 914
	7 / 178	7 / 178	8 / 203	5 / 127	5 / 127
	12", 14", 16", 18", 20" (305, 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)	40", 42", 48" (1016, 1067, 1219 mm)



Contour Cutting Attachment

Model	Item Numbers	Pipe Size Range in (mm)	Est. Shipping Weight
MSA	03.0116.MSA	1.5 - 4 (38 - 102)	7 lbs / 3 kg
1SA	03.0116.1SA	3 - 8 (76 - 203)	8 lbs / 4 kg
2SA	03.0116.2SA	6 - 12 (152 - 305)	8 lbs / 4 kg
3SA	03.0116.3SA	12 - 20 (305 - 508)	9 lbs / 4 kg
4SA	03.0116.4SA	20 - 26 (508 - 660)	9 lbs / 4 kg
5SA	03.0116.5SA	24 - 30 (610 - 762)	11 lbs / 5 kg
6SA	03.0116.6SA	28 - 36 (711 - 914)	13 lbs / 6 kg
8SA	03.0116.8SA	40 - 48 (1016 - 1219)	16 lbs / 7 kg

Shape Templates

Model	Item Numbers	Est. Shipping Weight
MSA	03.0115.M__	3.5 - 5 lbs / 1.6 - 2.3 kg
1SA	03.0115.1__	4.5 - 6 lbs / 2 - 2.7 kg
2SA	03.0115.2__	6 - 8 lbs / 2.7 - 3.6 kg
3SA	03.0115.3__	11 - 15 lbs / 5 - 7 kg
4SA	03.0115.4__	18 - 27 lbs / 8 - 12 kg
5SA	03.0115.5__	22 - 31 lbs / 10 - 14 kg
6SA	03.0115.6__	27 - 35 lbs / 12 - 16 kg
8SA	03.0115.8__	31 - 40 lbs / 14 - 1 kg

*Includes 32 pitch Torch Holder. Please add the letter "E" at the end of the item number when ordering a Contour Cutting Attachment with a Metric Torch Holder (example: 03.0116.MSAE)



EASY INSTALLATION | Takes just minutes to install

ACCURATE | Shape Templates are precisely designed and manufactured to produce accurate cuts every time

VERSATILE | Works with standard oxy-fuel and plasma torches

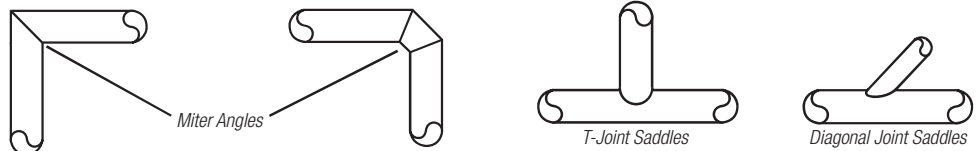
FAST | Produce perfect miters and saddles in less than a quarter of the time of hand layout, cutting and grinding

NOTE: CUSTOM DESIGNED SHAPE TEMPLATES AVAILABLE FOR YOUR SPECIFIC APPLICATION INCLUDE MITERS, SADDLES AND DIAGONALS

Saddle and Miter Cutting

1. Specify Mathey Dearman Machine Model (Example: 2SA).
2. Specify size/schedule (wall thickness) of pipe branch to be cut.
(Example: 8" / 203 mm pipe-Schedule 80.)
3. Specify size of main pipe to which the branch pipe will be fitted.
(Example: 8" / 203 mm pipe actual OD = 8 5/8" / 219 mm.)
4. Specify the angle of the cut and whether it is a saddle or miter.
(Example: 45 degree miter) (See figure 2)
5. Specify whether the joint is "Saddle In" or "Saddle On"
(See figure 1)
6. Specify if pipe is to be offset. If the answer is yes, specify how much the pipe is to be offset (in or mm).

Please copy this page for use as a convenient reference. You can fax the completed form to us at 918 447-0188. Please include your contact information so we can get in touch with you.



Produce perfect miter and saddle cuts with the easy to use Mathey Dearman Contour Cutting Attachment. Simply choose the Template for the desired type of cut and the torch will follow the Template around the pipe. Contour Cutting Attachments and Templates are available for 1 1/2" – 48" (38 mm – 1219 mm) pipe.

Figure 1

Saddle In
(ID of branch to ID of main)

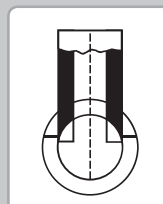
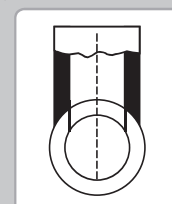


Figure 2

Saddle On
(ID of branch to ID of main)



PRO MODEL TORCH ARM

Choose the Pro Model Torch Arm with our innovative Out-of-Round Roller Attachment to create a perfect cuts and bevels on oversize, undersize or out-of-round pipe.

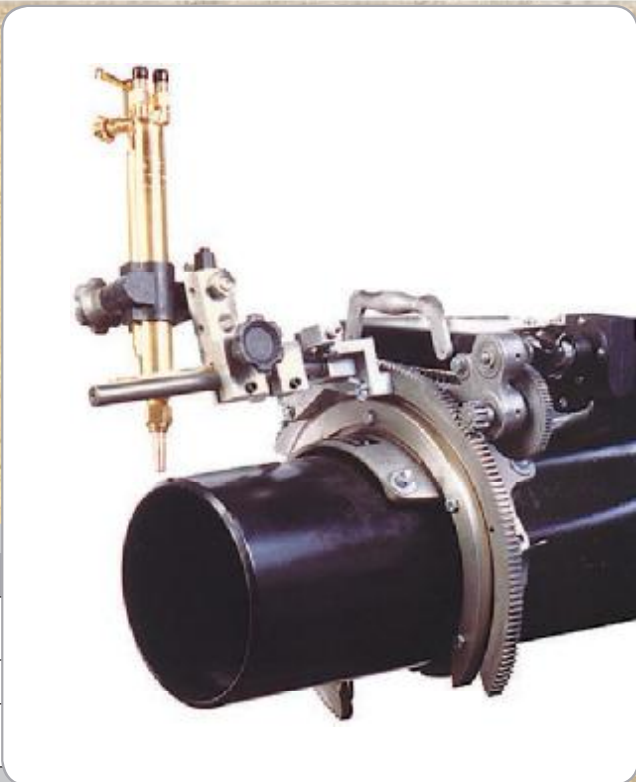
MINIMIZES NOTCHING | Torch automatically elevates over pipe weld seams and surface imperfections

SMOOTHER BEVELING | Precise pipe-to-torch distance maintained throughout the cut for more accurate beveling

INTERCHANGEABLE | Use the Pro Model Torch Arm with your current torch holder and adapter for oversized and undersized pipe

Model	Item Number	Shipping Weight
Pro Model with Out-of-Round Roller Attachment	03.0209.000	9.5 lbs / 4.3 kg
Pro Model Base Unit	03.0209.001	6 - 8 lbs / 2.7 - 3.6 kg
Out-of-Round Roller Attachment Kit	03.0209.003	4.5 - 6 lbs / 2 - 2.7 kg

**Includes 32 pitch Torch Holder. Please add the letter "E" at the end of the item number when ordering a Pro Model Torch Arm with a Metric Torch Holder (example: 03.0209.000E)*
NOTE: MACHINE TORCHES AVAILABLE SEPARATELY. BACK BEVELING NOT RECOMMENDED WITHOUT THE USE OF THE DOUBLE TORCH ARM ACCESSORY.

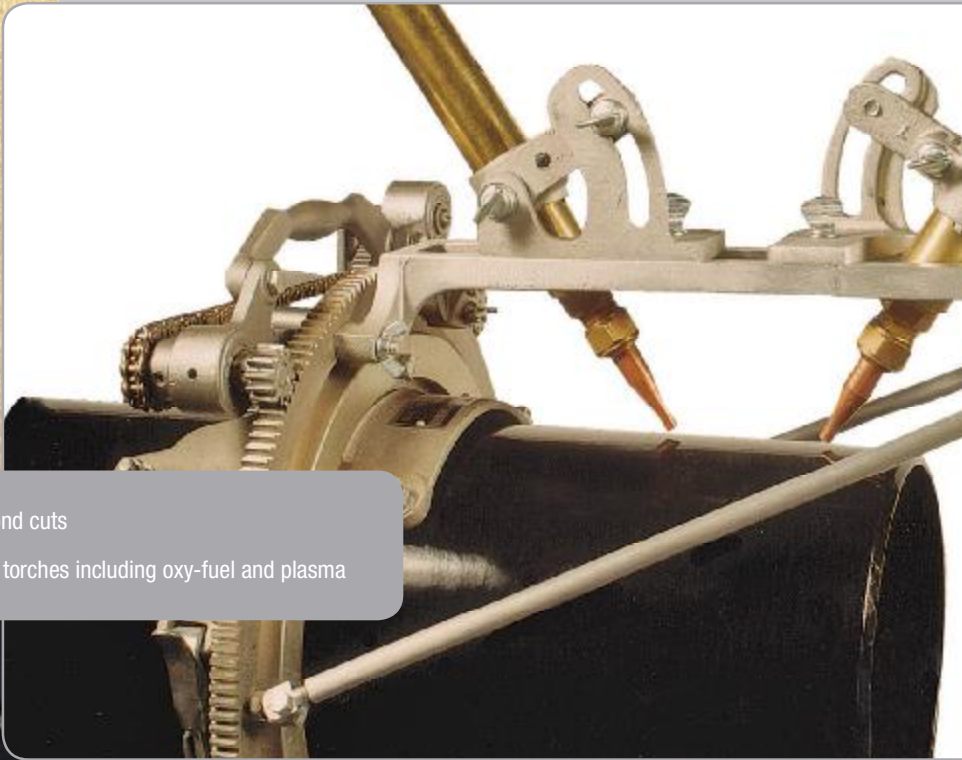


DOUBLE TORCH ARM

Reduce setup and cutting time by up to 50% with our Double Torch Arm accessory. By eliminating the need to rotate one torch to obtain a forward or back bevel on the pipe end, our Double Torch Arm dramatically reduces cutting and beveling time.

REDUCE EXPENSES | Eliminate second cuts

VERSATILE | Works with all standard torches including oxy-fuel and plasma



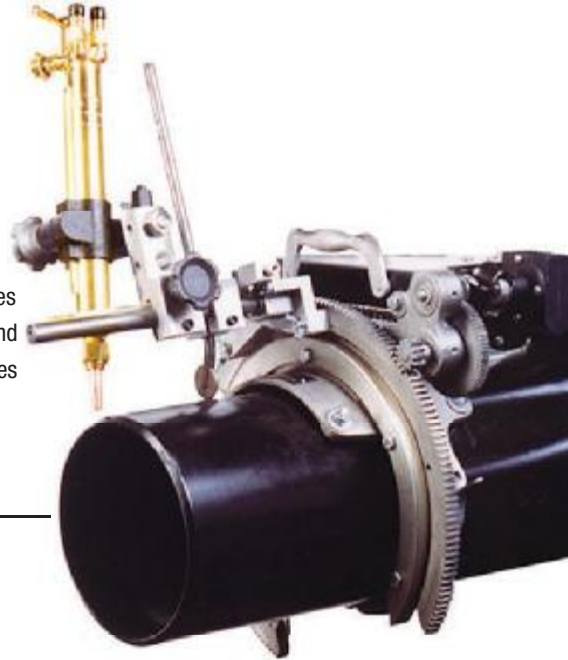


OUT-OF-ROUND ROLLER ATTACHMENT



Would you like to add out-of-round compensating capabilities to your current Pro Model Torch Arm? Our Out-of-Round Roller Attachment Kit compensates for oversize and undersize pipe, handling out-of-round conditions up to $\frac{1}{4}$ " (6mm). Order separately. Comes with all required parts and assembly instructions.

PRO Model with Out-of-Round Roller Attachment
Kit installed



DOUBLE TORCH ARM ITEM NUMBERS AND SHIPPING WEIGHTS

Model	With Torch Holder for 1 3/8" (35 mm) Diameter Torch	Est. Shipping Weight
1SA	03.0101.030	5 lbs / 2.3 kg
2SA	03.0102.015	5 lbs / 2.3 kg
3SA	03.0103.030	5 lbs / 2.3 kg
4SA	00.0104.021	5 lbs / 2.3 kg
5SA	03.0105.025	5 lbs / 2.3 kg
6SA	03.0106.018	5.5 lbs / 2.5 kg
8SA	03.0108.014	5.5 lbs / 2.5 kg



CAM-ADJUSTABLE TORCH CARRIER

Our Cam-adjustable Torch Carrier 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 your cut. In addition, the Torch Holder's large wing screw makes tightening the torch in the Torch Holder easy, even when wearing gloves. Our innovative design even allows forward or back-beveling without the need to reverse the Torch Holder in the Torch Arm.

Item : 03.0100.052

SELF-STORING STEP-DOWN SPACER

Combining multiple Spacer Bolt sizes into one easy-to-use part, our 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 twelve (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.



1SA STEP SPACER



2SA STEP SPACER



3SA STEP SPACER

STEP SPACER KIT

Description	Item Number	For Pipe Sizes		Est. Shipping Weight
		in	mm	
1SA Step Spacers	03.0110.1SAKIT	3, 4, 6, 8	76, 102, 152, 203	1.6 lbs / .7 kg
2SA Step Spacers	03.0110.2SAKIT	6, 8, 10, 12	152, 203, 254, 305	1.6 lbs / .7 kg
3SA Step Spacers	03.0110.3SAKIT	12, 14, 16, 18, 20	305, 356, 406, 457, 508	1.6 lbs / .7 kg

STEP SPACERS (INDIVIDUAL)

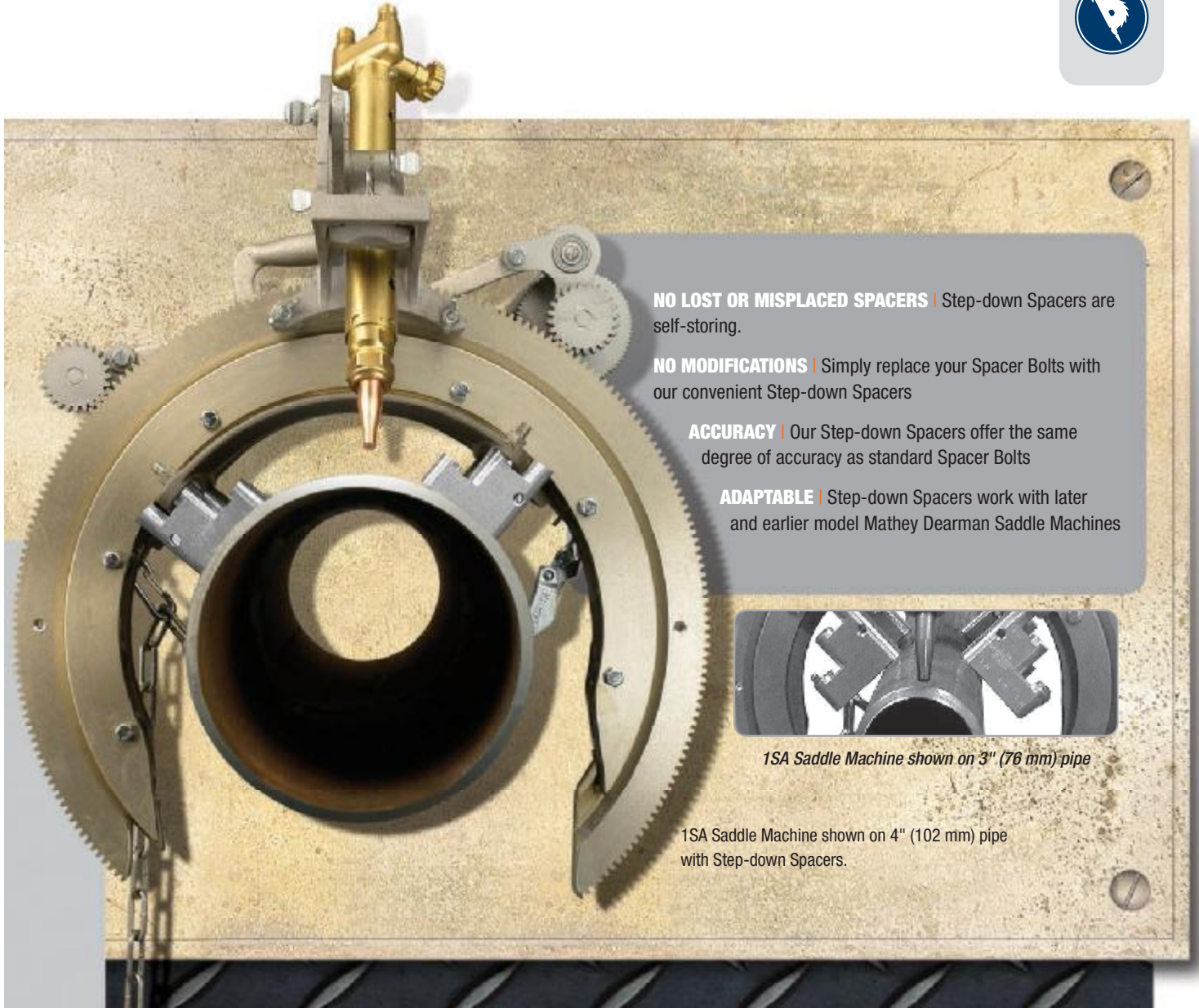
Description	Item Number	For Pipe Sizes		Est. Shipping Weight
		in	mm	
1SA Step Spacer	03.0110.1SA	3, 4, 6, 8	76, 102, 152, 203	0.4 lbs / 0.2 kg
2SA Step Spacer	03.0110.2SA	6, 8, 10, 12	152, 203, 254, 305	0.4 lbs / 0.2 kg
3SA Step Spacer	03.0110.3SA	12, 14, 16, 18, 20	305, 356, 406, 457, 508	0.4 lbs / 0.2 kg



SADDLE MACHINE SPACER BOLTS

Our Spacer Bolt Kits include the Spacer Bolts available for any Mathey Dearman Saddle Machine model in one handy container. 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 item number for quick identification.

*Spacer Bolts can be replaced individually or in sets.
Actual size is shown on box lid for quick spacer bolt identification.*



NO LOST OR MISPLACED SPACERS | Step-down Spacers are self-storing.

NO MODIFICATIONS | Simply replace your Spacer Bolts with our convenient Step-down Spacers

ACCURACY | Our Step-down Spacers offer the same degree of accuracy as standard Spacer Bolts

ADAPTABLE | Step-down Spacers work with later and earlier model Mathey Dearman Saddle Machines



1SA Saddle Machine shown on 3" (76 mm) pipe

1SA Saddle Machine shown on 4" (102 mm) pipe with Step-down Spacers.

SPACER BOLT KITS

Description	Item Number	For Pipe Sizes		Est. Shipping Weight
		in	mm	
MSA	03.0MSA.KIT	2, 3*	51, 76	1.0 lbs / 0.5 kg
1SA	03.01SA.KIT	3, 4, 6, 8	76, 102, 152, 203	4.0 lbs / 1.8 kg
2SA	03.02SA.KIT	6, 8, 10, 12	152, 203, 254, 305	5.0 lbs / 2.3 kg
3SA	03.03SA.KIT	12, 14, 16, 18, 20	305, 356, 406, 457, 508	9.0 lbs / 4.1 kg
4SA	03.04SA.KIT	20, 22, 24, 26	508, 559, 610, 660	10.0 lbs / 4.5 kg
5SA	03.05SA.KIT	24, 26, 28, 30	610, 660, 711, 762	10.0 lbs / 4.5 kg
6SA	03.06SA.KIT	28, 30, 36	711, 762, 914	20.0 lbs / 9.0 kg
8SA	03.08SA.KIT	40, 42, 48	1016, 1069, 1219	20.0 lbs / 9.0 kg

SADDLE MACHINE STORAGE BOX

To help protect your valuable investment, store your 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 2SA are made of ¼" plywood with reinforced 18 gauge metal corners and edges. STORAGE BOXES ARE SPECIFICALLY DESIGNED TO PROTECT MACHINES DURING TRANSPORTATION AND STORAGE



PROTECT YOUR INVESTMENT | Our heavy-duty Storage Boxes are specifically designed for transportation and storage

STAY ORGANIZED | Plenty of room to conveniently store accessories and Spacer Bolts when not in use



Model	Item Number	Dimensions in (mm)	For Manual or Motorized	Box Type	Est. Shipping Weight
MSA	03.0100.BOX	17 x 17 x 17 (432 x 432 x 432)	Manual Only	METAL	23 lbs / 11 kg
1SA	03.0101.BOX	20 x 18 x 17 (205 x 457 x 432)	Manual Only	METAL	33 lbs / 15 kg
2SA	03.0102.BOX	25 x 22 x 18 (635 x 559 x 457)	Manual Only	METAL	41 lbs / 19 kg
3SA	03.0103.BOX	34 x 34 x 14 (864 x 864 x 356)	Manual or Motorized	WOOD	60 lbs / 27 kg
4SA	03.0104.BOX	40 x 38 x 14 (1016 x 965 x 356)	Manual or Motorized	WOOD	75 lbs / 34 kg
5SA	03.0105.BOX	42 x 40 x 14 (1067 x 1016 x 356)	Manual or Motorized	WOOD	75 lbs / 34 kg
6SA	03.0106.BOX	56 x 48 x 16 (1422 x 1219 x 406)	Manual Only	WOOD	175 lbs / 79 kg
8SA	03.0108.BOX	70 x 56 x 19 (1778 x 1422 x 483)	Manual Only	WOOD	250 lbs / 102 kg



Rugged, lightweight and dependable, Mathey Dearman Jolli Chain Machines accurately cut a wide range of pipe and vessels, precisely following the outside pipe diameter to produce consistent bevels. Jolli Chain Machines easily adjust from one pipe size to the next. Multiple wheel positions, a Double or Triple-row Chain, and available Guide Tracks ensure horizontal and vertical cutting accuracy making the Mini or Maxi Jolli the best choice when working with multiple pipe diameters.



CUTTING AND BEVELING | CHAIN MACHINES

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