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SAFETY PRECAUTIONS

IN GENERAL

When using rotating head cutting equipment, basic safety precautions should always be followed to reduce the risk of personal injury.

Operate this tool only in accordance with specific operating instructions.

WARNING:

Do not override the deadman switch on the power unit. Locking down, obstructing, or in any way defeating the deadman switch on the power drive unit may result in serious injury.

DRESS CONSIDERATIONS

Use standard safety equipment. Hard hats, safety shoes, safety harnesses, protective clothes, and other safety devices should always be used when appropriate.

Use safety glasses. Do not operate cutting tools without eye protection.

Dress properly. Do not wear loose clothing or jewelry. They can be caught in rotating and moving parts. Avoid slippery floors or wear nonskid footwear. If you have long hair, wear protective hair covering to contain it.

WORK AREA

Keep the work area clean. Cluttered work areas and benches invite injuries.

Consider the work area environment. Keep the area well lit. Keep electrical cords, cables, rags, rigging straps, and etc. clear of rotating equipment. Do not use power-cutting tools in the presence of flammable liquids and gasses.

Keep visitors away. Do not let visitors or untrained personnel at or near operating tools. Enforce eye protection requirements for all observers.

Do not over reach. Keep proper footing at all times.

Stay alert. Watch what you are doing. Use common sense. Do not operate tools when you are tired.

TOOL CARE

Maintain tools with care. Keep tools in good operating condition. Sharp tool bits perform better and safer than dull tool bits. Well maintained tools function properly when needed.

Check for damaged parts. If a tool has malfunctioned, been dropped or hit, it must be checked for damage. Run no-load tests and feed function checks. Do a complete visual inspection.

Electric motors. Use only with proper AC voltage power sources and observe all normal electric shock hazard procedures.

Do not abuse power and control cords. Pulling or running over cords and cables can result in electrical shock hazards and malfunctions. Keep control and power cords out of all cutting fluids and water.

Hydraulic drives. Observe proper procedures for electrically driven power sources. Avoid damage to hydraulic lines. Keep quick-disconnects clean. Grit contamination causes malfunctions.

Air tools. Check the exhaust muffler. Broken or damaged mufflers can restrict air flow or cause excessive noise. Use air motors only with a filtered, lubricated and regulated air supply. Dirty air, low-pressure air or over pressure air will cause malfunctions, including delayed starting.

AREA EQUIPMENT

Secure work. Whenever possible use clamps, vises, chains and straps to secure pipe.

Make sure the tool is secured; it is safer to have both hands free to operate the tool.

TOOL USE

Use the right tool and tool bit for the job. Do not use a tool, which is incorrect for the job you are doing.

Keep the tool bits fully engaged in the tool bit holders. Loose bits are a safety hazard.

Disconnect the power supply during setup and maintenance. Use all 'Stop' or 'Shut off' features available when changing or adjusting tool bits, maintaining the tool, or when the tool is not in use.

Remove adjusting keys and wrenches before applying power to the equipment. Develop a habit of checking the tool before turning it on to make sure that all keys and wrenches have been removed.

Do not force tools. Tools and tool bits function better and safer when used at the feed and speed rate for which they were designed.

Do not reach into rotating equipment. Do not reach into the rotating head stock to clear chips, to make adjustments, or to check surface finish. A machine designed to cut steel will not stop for a hand or an arm.

Handle chips with care. Chips have very sharp edges and are hot. Do not try to pull chips apart with your hands; they are very tough.

Avoid unintentional starts. Do not carry or handle tools with your hand on the operating switches or levers. Do not lay the tool down in a manner that will start the drive. Do not allow the tool to flip around or move when adjusting or changing tool bits.

Store idle tools properly. Disconnect tools from the power source and store in a safe place. Remove tool bits for safe handling of the tool.

GENERAL DESCRIPTION

The information contained in this manual should be used in conjunction with 'Operator's Manual' 92-1482.

The ID Tracking Module is designed to track out of round pipe/tube where control of the land thickness is critical on the wall pipe/tube.

SPECIFICATIONS

DESIGN AND OPERATING FEATURES

The 208B IDTM bolts directly to the Model 208B in lieu of the standard Tool Modules.

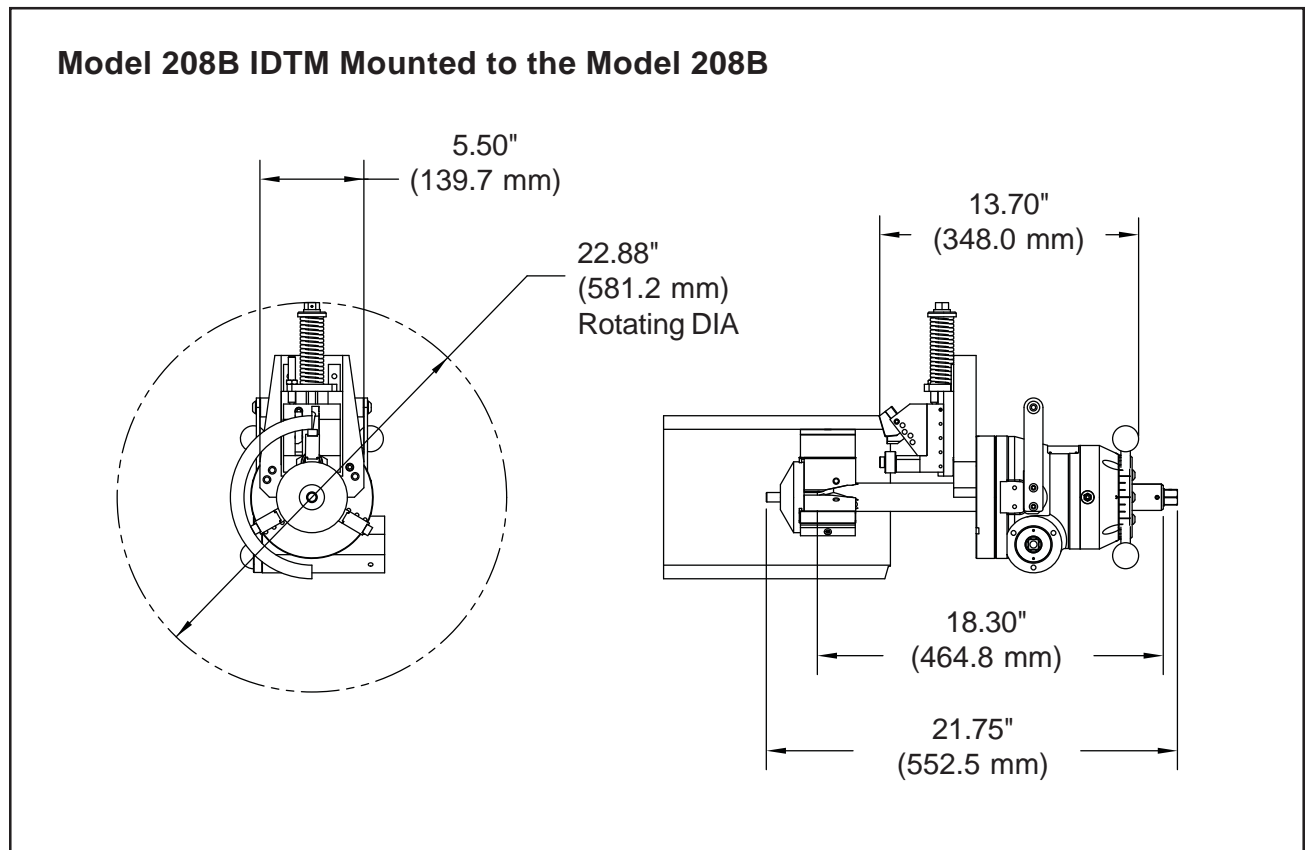
The Tool Holder has two (2) Slots to allow facing and beveling simultaneously.

Easy to assemble unit bolts directly to the Model 208B in lieu of the standard tool modules.

The .88" (24.4 mm) of radial tool holder spring travel accommodates pipes that are out of round.

The tool holder has two tool bit slots to allow facing and beveling simultaneously.

SPECIFICS



Weight

15 lbs (33.1 kg)

Clearance and Dimensions

Reference the Envelope Drawing.

Tool Holder Spring Travel (Radial)

.88 (22.4 mm)

Cutting Capacity

Basic Pipe Sizes

4" - Schedules 5 through 40

5" and 8" - All schedules

ID Mounting DIA (Min.)

4.00" (101.6 mm)

Wall Thickness (Max.)

.750" (19.1 mm)

Material Cutting Capabilities

Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel and aluminum without limitations other than size and wall thickness as specified.

Inconel and some other high-temperature alloys may require special procedures as a function of wall thickness and type of end preparation. Contact TRI TOOL's Engineering Department for details.

SETUP AND OPERATION

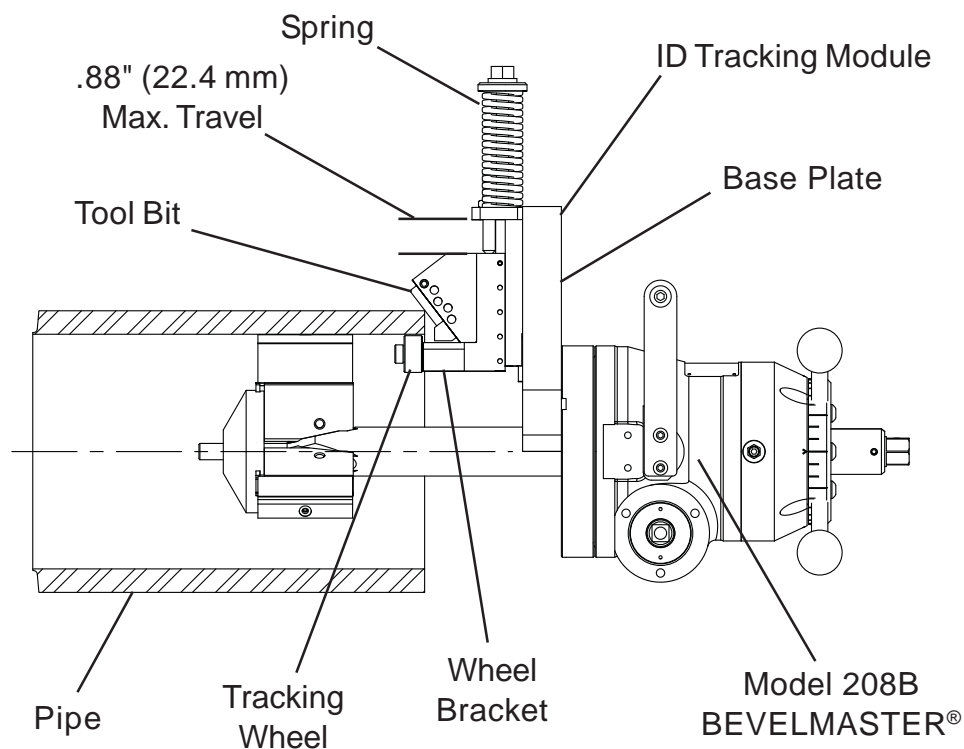
Always read the operating instructions carefully/completely before attempting to operate the Model 208B ID Tracking Module.

When operating any/all Tri Tool Inc. equipment follow the 'Note' statements through the manual for equipment safety and the 'Warning' and/or 'Caution' notes for operator safety.

SETUP

Remove the three (3) Tool Holders from the Model 208B.

Mounting the Model 208B IDTM into the ID of the Pipe



Mount the Model 208B IDTM to the 208B Headstock using the eight (8) Cap Screws that have been provided.

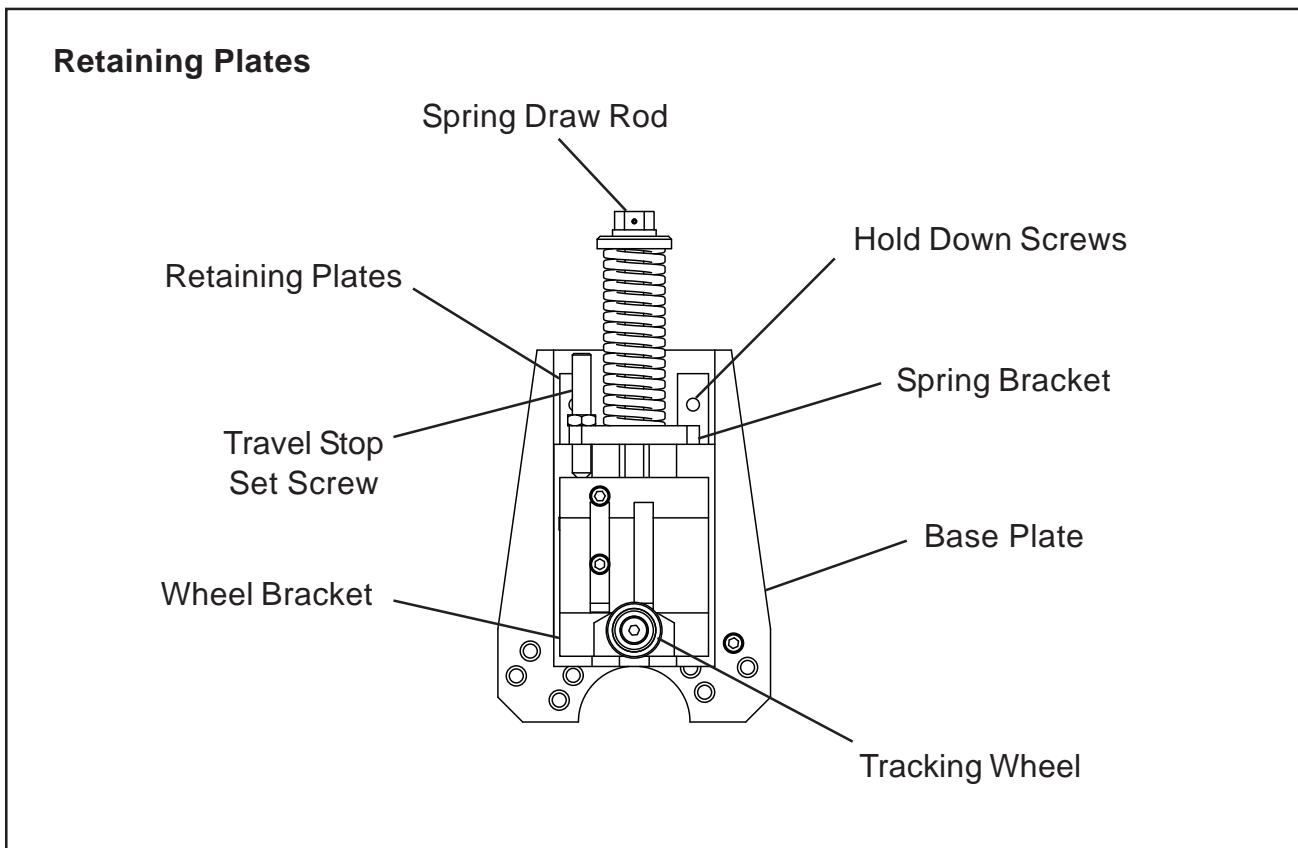
Install the Mandrel Assy into the pipe.

NOTE:

Use the Standard Jaw Blocks, Ramps and Adapters with the Extended Mandrel that's provided with the Model 208B IDTM Kit.

Position the ID Tracking Module Assy so that the Tracking Wheel is in contact with the ID of the pipe.

Tightly lock the Retaining Plates in place with the Hold Down Screws from the back of the Base Plate.



Tighten the Spring Draw Rod, but leave enough travel to accommodate out of round pipe.

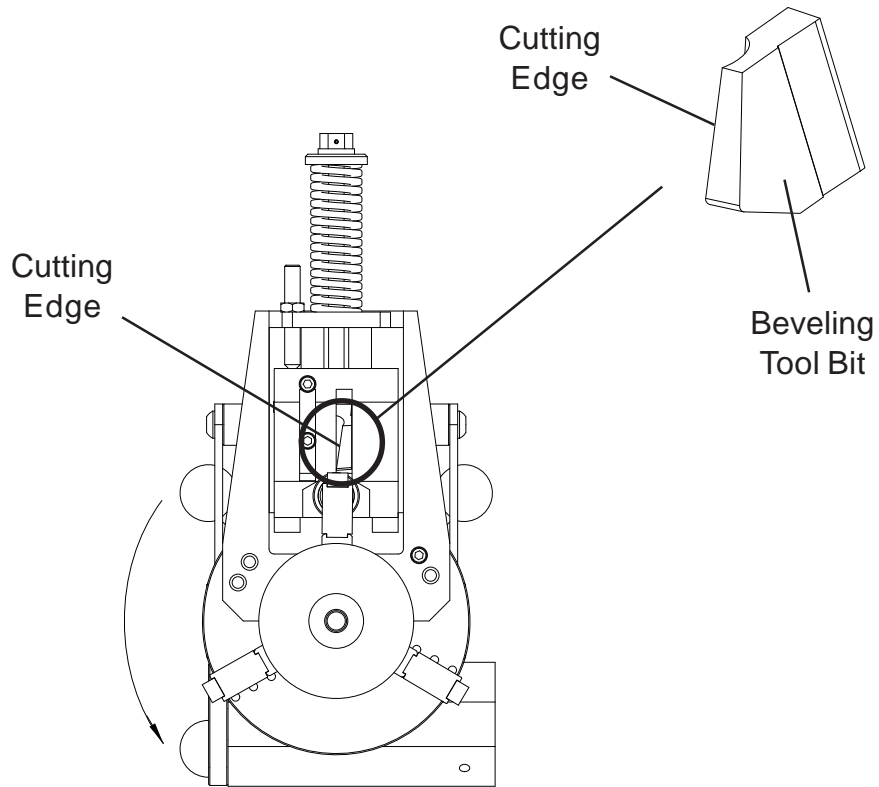
NOTE:

Make sure the Travel Stop Set Screw is retracted back flush with the bottom of the Spring Bracket.

Install the Tool Bits in the ID Tracking Module.

Install the Beveling Tool Bit with the cutting edge on the centerline of the pipe or tube.

Beveling Tool Bit Installation

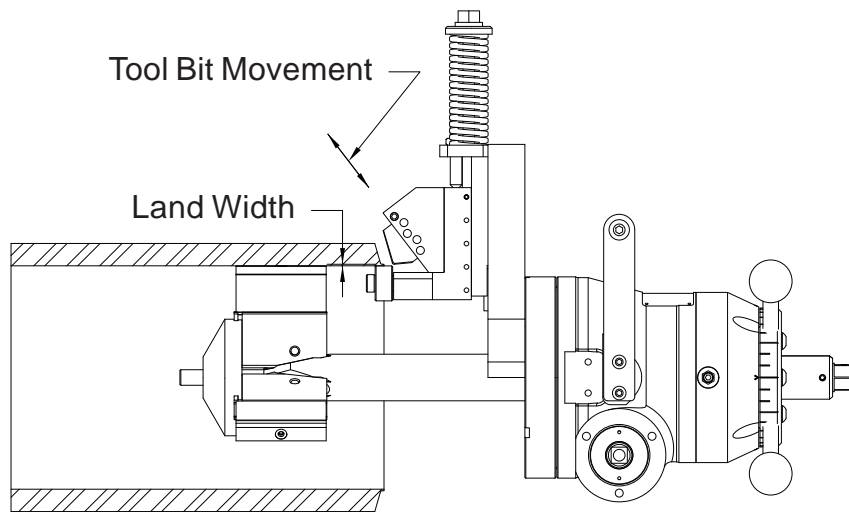


The Land thickness will be determined by the position of the Beveling Tool bit in the slot.

Slide the Beveling Tool Bit up and down in the slot keeping the bottom of the Tool Bit flat against the bottom of the slot.

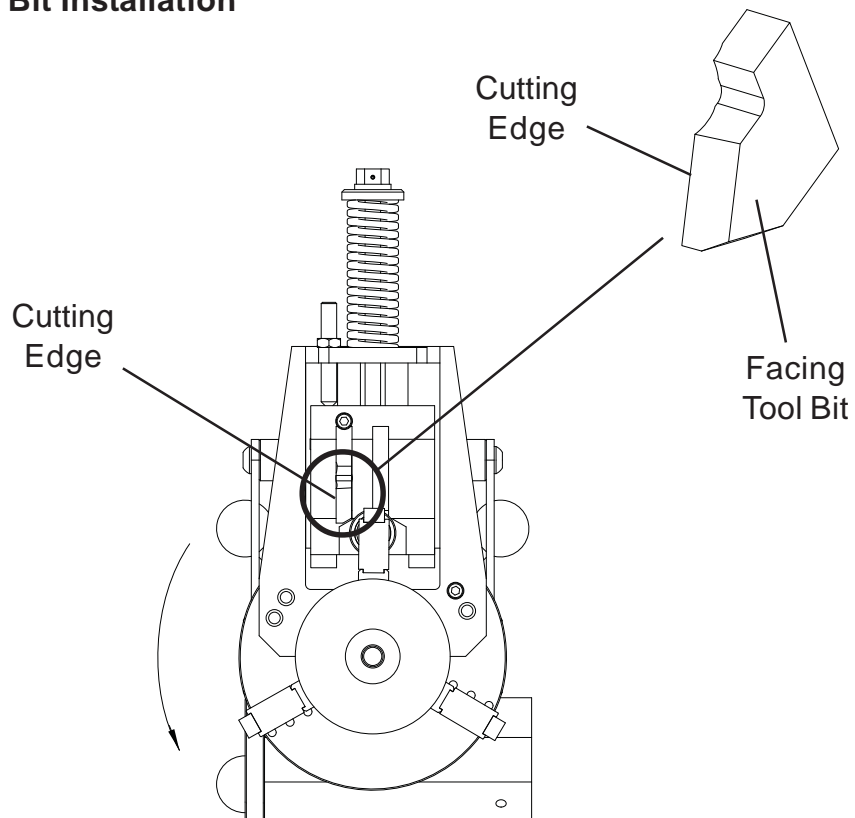
Once the desired position has been achieved, then tighten all of the Set Screws which make contact with the Tool Bit.

Beveling Tool Bit Land Width



Install the Facing (Land) Tool Bit with the cutting edge to the outside of the Tool Holder.

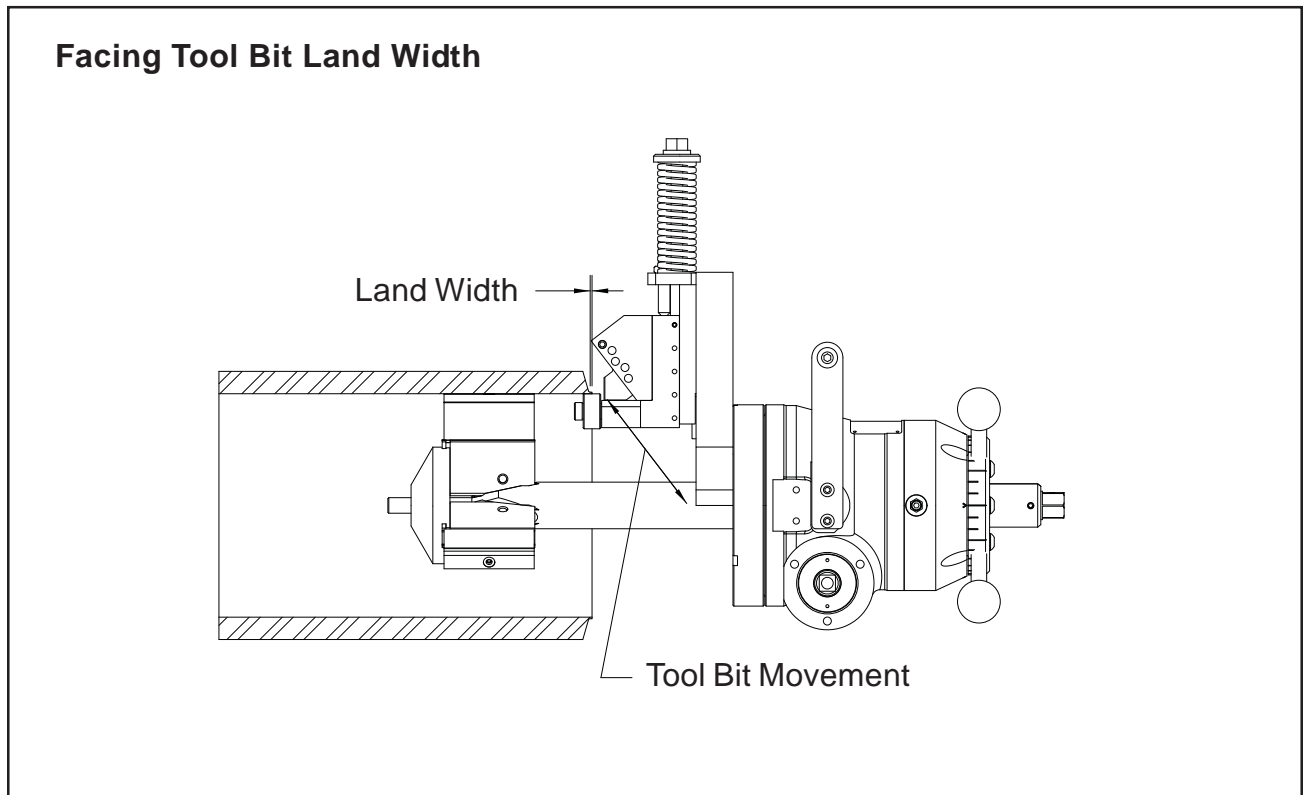
Facing Tool Bit Installation



Model 208B IDTM (ID Tracking Module)

The Land width will be determined by the position of the Beveling Tool Bit in the slot.

Slide the Facing Tool Bit up and down in the slot keeping the bottom of the Tool Bit flat against the bottom of the slot.



Once the desired position has been achieved, then tighten all of the Set Screws which make contact with the Facing Tool Bit.

Attach the proper power supply line to the Model 208B.

Check that the Air Supply (FRL) is installed and set properly.

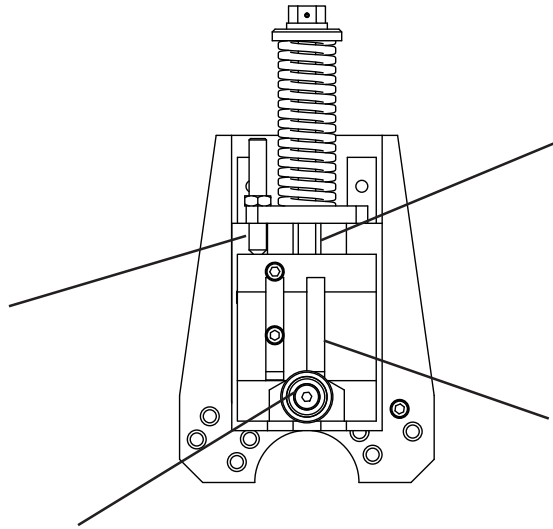
Turn the Motor on and start cutting.

After the cut is finished, turn the Motor off to stop the Headstock rotation.

Tighten down the Travel Stop Set Screw and lock it against the wheel Bracket to prevent the spring from releasing when removing the machine from the pipe.

If the Model 208B IDTM is operated in such a manner that the Tool Block collects debris while cutting, the Tool Block and Feed Screw should be brushed clean after each cutting operation.

Areas to Brush Clean After the Cutting Operation



NOTE:

Tool life may be severely shortened, unless chips and/or other debris that have been deposited on the Cutting Head during the machining operation are removed.

OPERATION

For the Model 208B operating instructions refer to the Model 208B BEVELMASTER® "Operator's Manual", 92-1482.

MAINTENANCE

RECOMMENDED MAINTENANCE

Daily Before/After Operation

Wipe the unit down and spray with rust preventative under severe humidity conditions.

Visually inspect for loose screws, missing screws, damage, etc.

After 20 Hours of Operation

Clean and lubricate the Slide Rails.

Disassemble the unit and wipe the Slide Rails down.

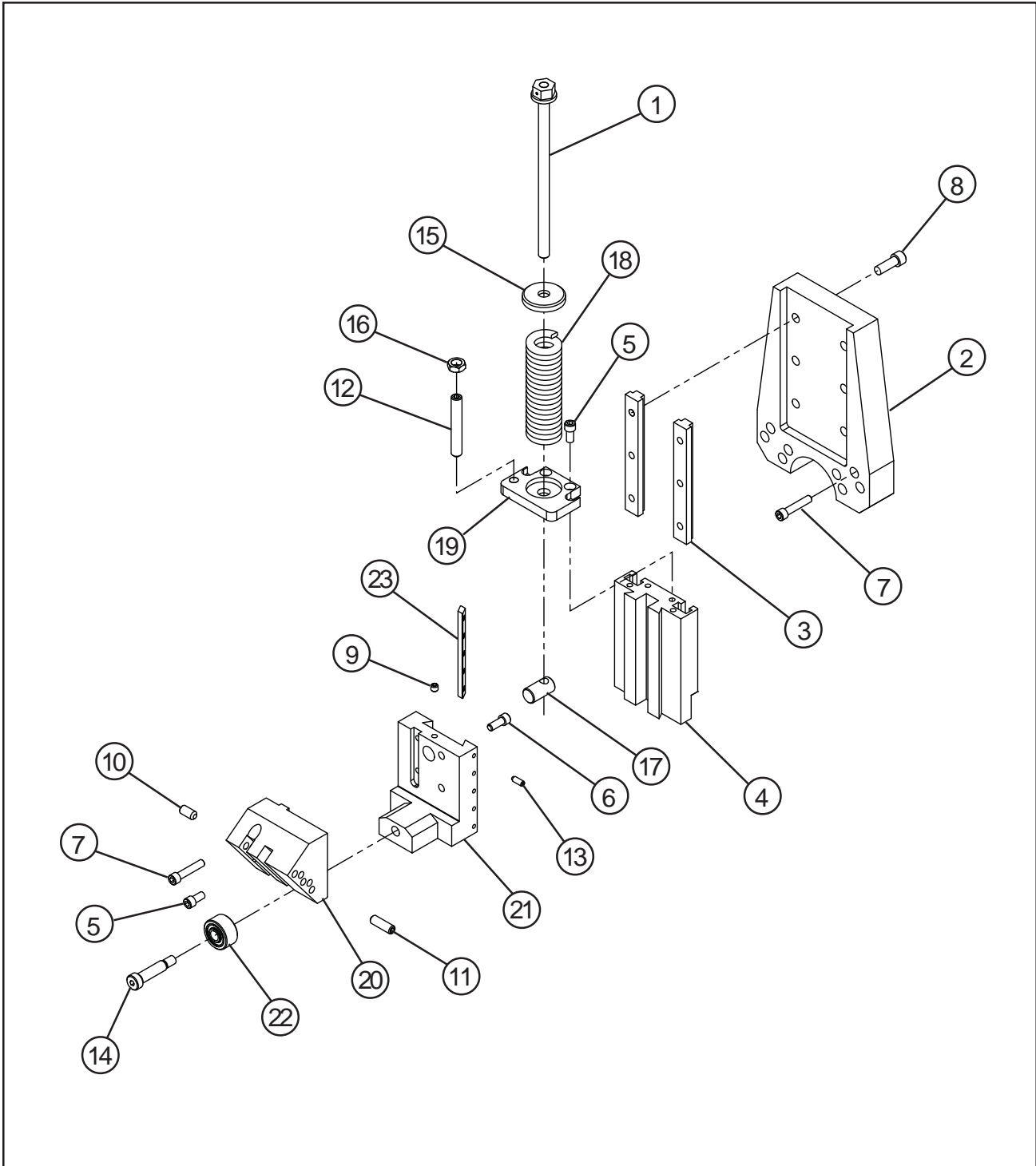
Excess lubricant will collect grit and/or chips and tend to cause jamming and/or damage to the Slide Rails.

STORAGE

When/if the ID Tracking Module is to be stored or will remain out of service for a significant period of time, 30 days or more, it should be thoroughly cleaned, lubricated and sprayed with a rust preventative prior to storage.

ILLUSTRATED PARTS BREAKDOWN

MODEL 208B IDTM (P/N 82-0087)

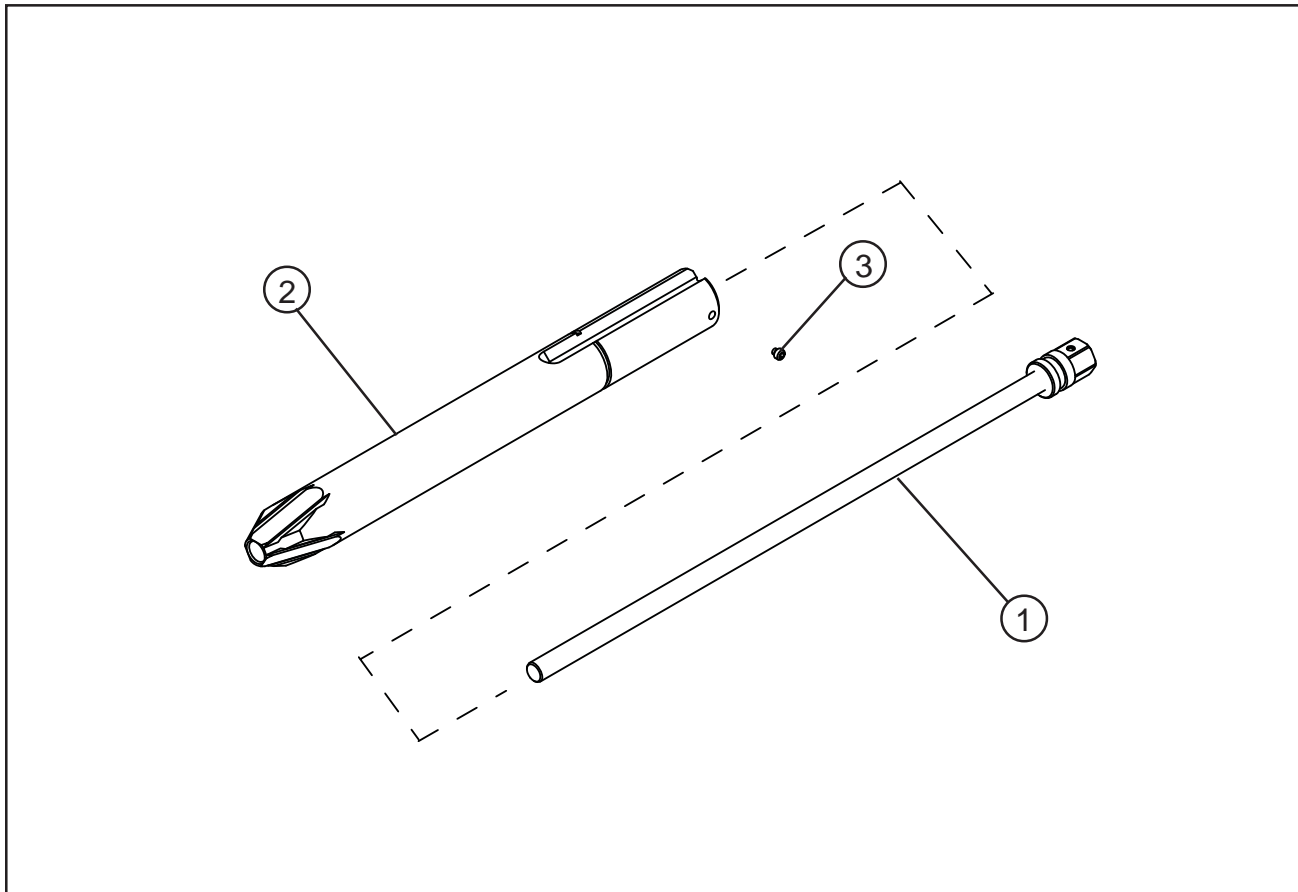


Model 208B IDTM (ID Tracking Module)

Parts List, Model 208B IDTM (P/N 82-0087)

Item No.	Part No.	Description	Qty
1.	11-0089	ROD ASSY, DRAW	1
2.	24-1144	PLATE, BASE	1
3.	24-1145	PLATE, RETAINING	2
4.	24-1146	PLATE, SLIDE	1
5.	33-0038	SCREW, CAP, 1/4-20 X 1/2	5
6.	33-0039	SCREW, CAP, 1/4-20 X 5/8	2
7.	33-0043	SCREW, CAP, 1/4-20 X 1 1/4	9
8.	33-0055	SCREW, CAP, 5/16-18 X 7/8	6
9.	33-0499	SCREW, SET, 1/4-20 X 1/4, CUP PT	1
10.	33-0517	SCREW, SET, 5/16-18 X 5/8, CUP PT	5
11.	33-0520	SCREW, SET, 5/16-18 X 1, CUP PT	5
12.	33-0538	SCREW, SET, 3/8-16 X 2 1/2, CUP PT	1
13.	33-0914	SCREW, SET, 10-24 X 1/2, HDOG	5
14.	33-1757	SCREW, SHOULDER, 3/8 X 1 1/4	1
15.	34-0267	WASHER, SPRING	1
16.	35-0192	NUT, JAM	1
17.	35-0363	NUT, FEED	1
18.	40-0182	SPRING, COMPRESSION	1
19.	47-0749	BRACKET, SPRING	1
20.	47-0757	BRACKET, WHEEL	1
21.	49-0242	HOLDER, TOOL	1
22.	61-0057	WHEEL ASSY, TRACKING	1
23.	66-0120	GIB	1
NOT SHOWN			
	36-0003	WRENCH, L, 3/32" HEX	1
	36-0007	WRENCH, L, 5/32" HEX	1
	36-0008	WRENCH, L, 3/16" HEX	1
	36-0010	WRENCH, L, 1/4" HEX	1
	36-0043	WRENCH, COMBINATION, 11/16"	1
	36-0076	WRENCH, COMBINATION, 9/16"	1
	86-0304	CASE, CARRYING	1

MANDREL ASSEMBLY (P/N 06-0530)



Parts List, Mandrel Assembly (P/N 06-0530)

Item No.	Part No.	Description	Qty
1.	11-0150	ROD ASSEMBLY, DRAW 1/2" - 13UNC	1
2.	13-0568	MANDREL, 208B IDTM	1
3.	33-1527	SCREW, SET, 1/4-20 X 1/4", HDOG	2