



# TRI TOOL INC.

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TRI TOOL INC.  
TECHNICAL SPECIFICATION  
MODEL 206B ELECTRIC BEVELMASTER™, 115V AND 230V HD  
APRIL 25, 2005

## Model 206B Electric BEVELMASTER™, 115V and 230V HD, Portable Lathe System

The Model 206B Electric BEVELMASTER™ is a portable ID mount machine tool for beveling, facing and counterboring 2" through 6" pipe. The tool is configured with an inline feed knob and electric drive motor at a right angle to the lathe head.

The Model 206B Electric BEVELMASTER™ System comes complete with:

- Beveler Sub-Assembly 1 ea.
- Tool Holder Assembly 3 ea.
- Mandrel Assembly 1 ea.
- Wrench Kit 1 ea.
- Electric Motor Assembly 1 ea.
- Operator's Manual 1 ea.

## Design and Operating Features

1. The lathe accepts it's own torque through the mandrel.
2. The expanding mandrel provides fast, accurate self-centering and alignment.
3. All wrenches needed for operation are provided with the system.
4. The lathe provided with a convenient handle is lightweight, at less than 60 lbs. (27.22 Kg), and easily handled by one operator.

5. All 115V motors require a minimum of a 20-amp circuit.

### Specifications

1. Reference Envelope Drawing No.:

- A. 77-1670

2. Pipe Cutting Capacities

- A. Basic Pipe Sizes

- i. 1 1/2"

- a. Schedules 5 and 10

- ii. 2"

- a. Schedules 5 through 160

- iii. All schedules of 3" through 6" pipe

- B. Basic Tube Sizes

- i. Up to .875 (22.2 mm) wall tubing with a maximum OD of 6.63" (168.4 mm) and a minimum ID of 1.63 (41.4 mm) may be beveled with standard mandrel.

- C. Wall Thickness Capacity

- i. Wall thickness of all standard pipe schedules, .875 (22.2 mm) maximum, in the range listed. Tubing with greater wall thickness may be handled provided the ID is greater than 1.63" (41.4 mm) and the OD is less than 6.63" (168.4 mm). Contact TRI TOOL Inc. for heavier wall procedures.

- D. Counterboring Operations

- i. The tool will counterbore pipe and tubing with an ID range of 2.00" (50.8 mm) to 6.41" (162.8 mm).

3. Material Cutting Capabilities

- A. Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel and aluminum with out limitations except size and wall thickness as specified in the previous information.

- B. 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 Inc. Engineering Department for details.

4. Clearances and Dimensions

A. Maximum Rotating Head Diameter

- i. 6.75" (171.5 mm)

B. Length Over Motor

- i. 26.00" (660.4 mm)

C. Maximum Width

- i. 9.63" (244.6 mm)

D. Length (Parallel to Axis of Pipe)

- i. 17.40" (442.0 mm)

E. Available Feed Travel

- i. 2.00" (50.8 mm)

5. Drive System

A. Final Drive

- i. Gear Driven

B. Electric Motor

- i. Dual Range, Variable Speed

6. Power Supply Options

A. 115 VAC, 40 – 60 Hz, 2300 Watt rated Supply

B. 230 VAC, 40 – 60 Hz, 2300 Watt Rated Supply

7. Cutting Head Speeds

A. Maximum Cutting Head Speed

- i. 40 rpm
  - B. Functional Speed Range
    - i. 16 - 37 rpm
- 8. Speed Control
  - A. Trigger with lock and adjustable speed dial.
- 9. Mounting
  - A. Manually actuated draw rod expands mandrel ramps and jaw blocks.
- 10. Feed
  - A. Manual-Feed handle is in line at the back of the machine. Feed rate is .083" (2.1 mm) per revolution of the feed handle.

Accessories (Optional)

- 1. Elbow Mandrel Kit
- 2. Elbow Mandrel Pointer Kit
- 3. Flange Facer Kit
- 4. Dial Indicator Kit
- 5. Sleeve Mandrel Kit
- 6. Miter Mandrel Kit
- 7. ID Tracking Module Kit

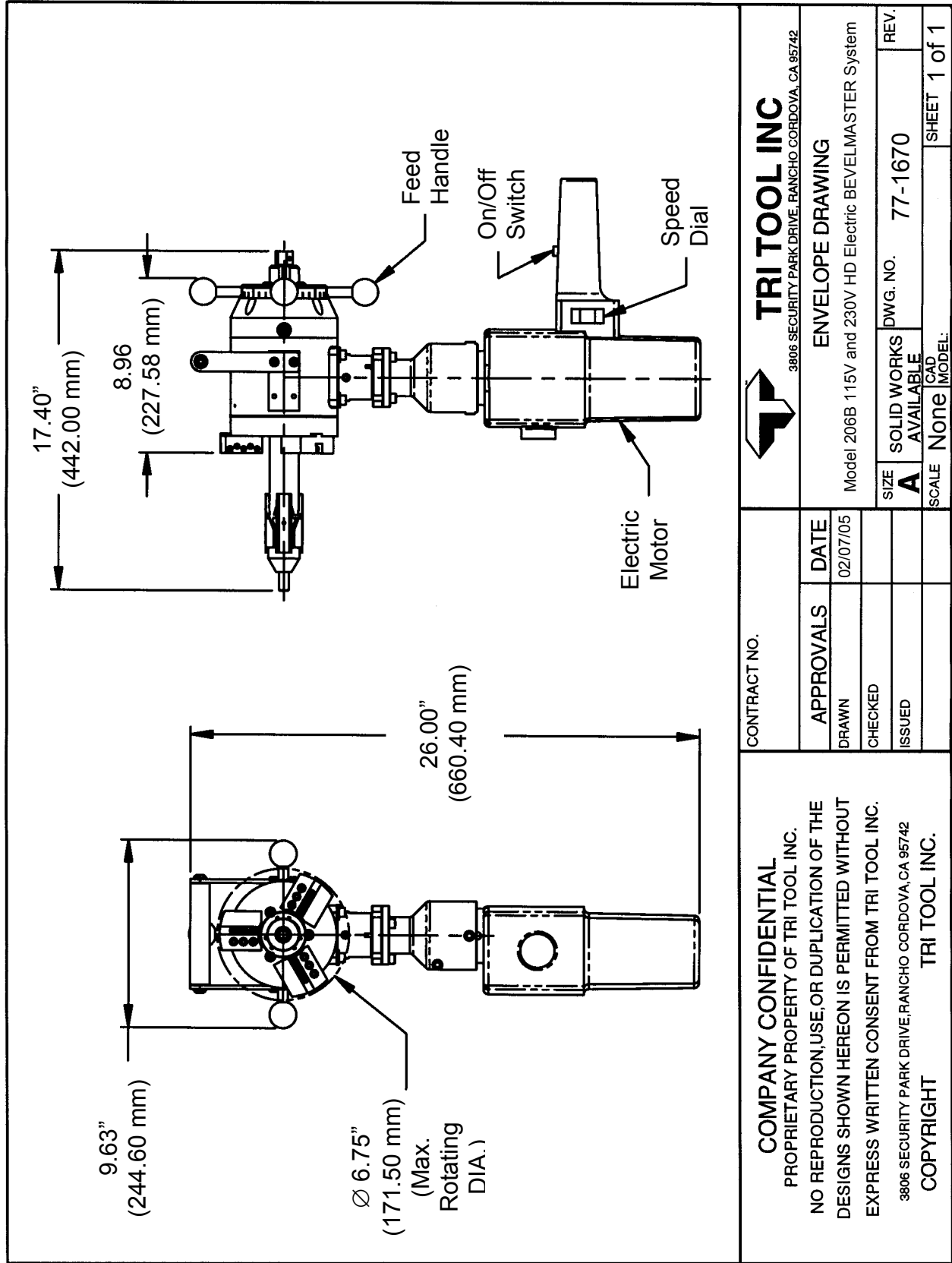
Note To The Customer


Spare Parts and Standard Tool Bits are available from stock. Engineering design services for custom tool bits and special function modifications are available from the factory.

All Tri Tool and allied equipment products are subject to design improvements and specification changes at any time with no obligation to units already sold.

Warranty (limited): Parts and equipment are warranted against defects in material and workmanship for a period of one (1) year from date of purchase. Full details supplied on request and/or with the tools.

Filter, regulator and lubricator are required to protect the warranty on air powered tools.



 <b>TRI TOOL INC</b> <small>3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</small>		<b>ENVELOPE DRAWING</b>		Model 206B 115V and 230V HD Electric BEVELMASTER System	REV.
		SIZE <b>A</b>	SOLID WORKS DWG. NO. <b>77-1670</b>	SCALE <b>None</b>	SHEET <b>1 of 1</b>
CONTRACT NO.		APPROVALS	DATE	Model 206B 115V and 230V HD Electric BEVELMASTER System	
		DRAWN	02/07/05		
		CHECKED			
		ISSUED			
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