



TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL 206B ELECTRIC BEVELMASTER™ SYSTEM

OCTOBER, 1991

MODEL 206B ELECTRIC BEVELMASTER™ PORTABLE PIPE LATHE SYSTEM

The Model 206B Electric BEVELMASTER™ is a portable I.D. 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 206B Electric BEVELMASTER™ System comes complete with:

- a) 1 ea Beveler Subassy
- b) 3 ea Tool Holder Assy
- c) 1 ea Mandrel Assy
- d) 1 ea Carrying Case
- e) 1 ea Wrench Kit
- f) 1 ea Electric Motor Assy
- g) 1 ea Operator's Manual

Optional Accessories:

- 206B Elbow Mandrel Kit
- 206B Flange Facer Kit
- 206B Sleeve Mandrel Kit

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 50 lbs., (22.68 Kg.)] and easily handled by one operator.

Specifications

1. Pipe Cutting Capacities:

a. Basic Pipe Sizes:

- 1 1/2" Pipe Schedule 5 & 10
- 2" & 2 1/2" pipe schedule 5 through 80
- 3" through 6" pipe schedule 5 through 40

b. Basic Tube Sizes:

Up to .280 (7.1 mm) wall tubing with a maximum O.D. of 6.63" (168.4 mm) and a minimum I.D. of 1.63" (41.4 mm) may be beveled with standard procedures.

c. Wall Thickness Capacity:

Wall thickness of all standard pipe schedules [.280 (7.1mm) maximum] in the range listed. Contact Tri Tool for heavier wall procedures.

d. Counterboring Operations:

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

2. 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 paragraph 1.
- 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's engineering department for details.

3. Clearances and dimensions

- a. Maximum rotating head diameter: 6.75" (171.5 mm)
- b. Length over motor: 26.00" (660.4 mm)
- c. Maximum width: 9.50" (241.3 mm)
- d. Length (parallel to axis of pipe): 17.40" (442.0 mm)
- e. Available feed travel 2.00" (50.8 mm)

4. Drive System:

- a. Final Drive: Gear Driven
- b. Electric Motor: Dual Range, Variable Speed

5. Power Supply Options:

- a. 115 VAC, 28-60Hz, 500 Watt Rated Supply
- b. 220 VAC, 28-50Hz, 500 Watt Rated Supply

6. Cutting Head Speeds:

- a. Maximum cutting head speed: 38 RPM
- b. Functional speed range 9-34 RPM

7. Speed Control:

Variable Speed Trigger with adjustable pre-set dial and lock, high/low switch.

8. Mounting:

Manually actuated draw rod expands mandrel ramps and jaw blocks.

9. Feed:

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.

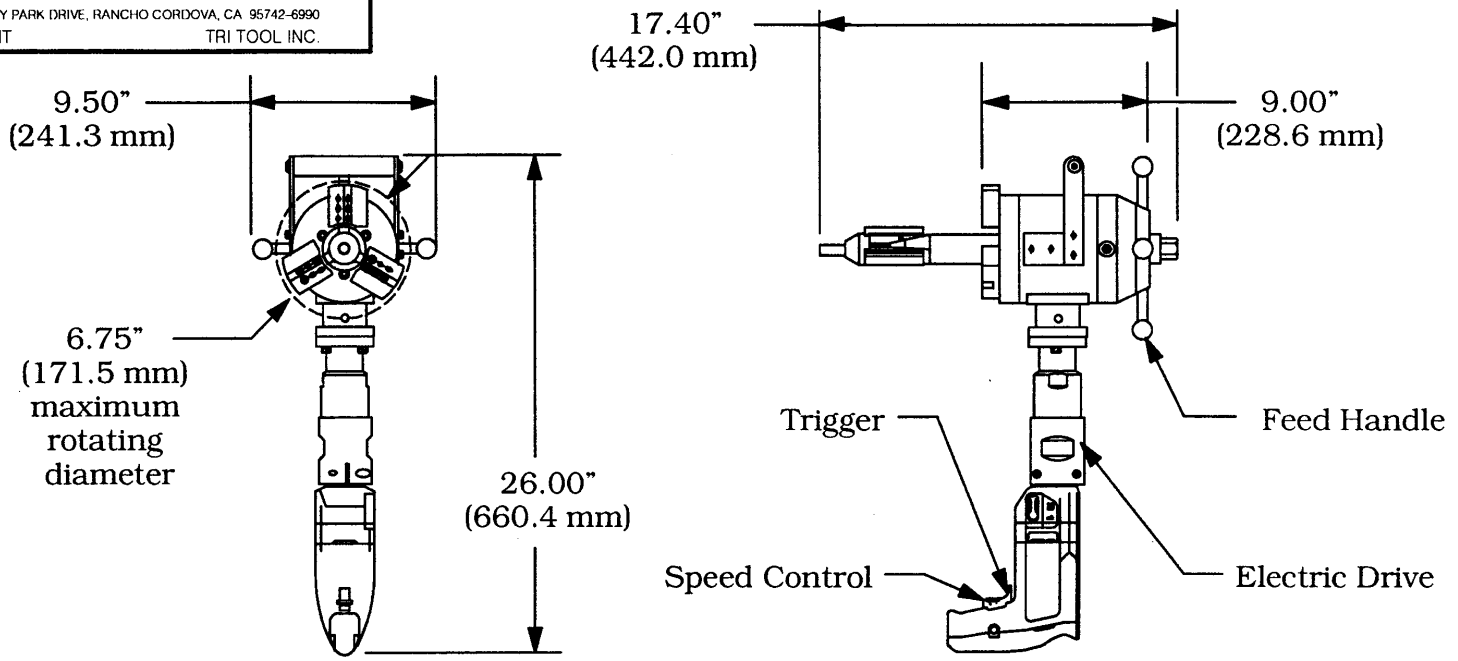
Optional Accessories:

1. Elbow Mandrel Kit for mounting in elbows and applications where only short axial perch is available.
2. Flange Facer Kit for facing flanges.
3. Sleeve mandrel kit for machining of thin wall pipe and tube.

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.

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED




		QTY REQD	FSCM NO.	PART NO IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	MATERIAL SPECIFICATION
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NEXT ASSY USED ON

PART LIST

UNLESS OTHERWISE NOTED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 DECIMALS FRACTIONS ANGLES
 XX ±.03 ±1/16 0° 30'
 .XXX ±.010
 MACHINED SURFACES 125√
 TO BE CONCENTRIC WITHIN .010 TIR
 FLATNESS TO WITHIN .010 TIR
 BREAK ALL SHARP EDGES .005-.015
 FILLET RADII TO BE .030 MAX
 C'SINK THD HOLES TO MAJ DIA X 82°

MATERIAL	CONTRACT NO.	
FINISH	APPROVALS	DATE
DO NOT SCALE DRAWING	DRAWN Pfafman	6/28/91
	CHECKED	
	ISSUED	

 TRI TOOL INC. <small>3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742-6990</small>		Envelope Drawing Model 206B, Electric, BEVELMASTER™	
		SIZE A	FSCM NO.
SCALE None		SHEET 1 of 1	