



# TRI TOOL INC.

3806 Security Park Drive, Rancho Cordova, CA 95742-6990 USA • (916) 351-0144 • (888) TRI TOOL • FAX (916) 351-0372  
[www.tritool.com](http://www.tritool.com) [customer.service@tritool.com](mailto:customer.service@tritool.com)

TRI TOOL INC.  
TECHNICAL SPECIFICATION  
MODEL 212B ELECTRIC BEVELMASTER™, 115V AND 230V HD  
FEBRUARY 4, 2005

## Model 212B Electric BEVELMASTER™, 115V and 230V HD, Portable Lathe System

The Model 212B Electric BEVELMASTER™ is a portable ID mount machine tool for beveling, facing and counterboring 4" through 12" pipe. The tool is configured with an in-line feed knob and electric drive motor at a right angle to the lathe head.

The Model 212B Electric BEVELMASTER™ System comes complete with:

- Model 212B Sub-Assembly 1 ea.
- Tool Holder Assembly (Aluminum) 2 ea.
- Tool Holder Assembly (Steel) 1 ea.
- Mandrel Assembly 1 ea.
- Electric Motor Assembly 1 ea.
- Wrench Kit 1 ea.
- Carrying Case 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 tools needed for operation (less tool bits) are provided with the system.

4. The lathe, provided with a convenient handle, is lightweight at less than 80 lbs. (36.3 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. 77-1671
2. Pipe Cutting Capacities
  - A. Basic Pipe Sizes
    - i. 4"
      - a. Schedule 5 through 160
  - B. All Schedules of 5" through 12" pipe
  - C. Basic Tube Sizes
    - a. Up to 1.32" (33.4 mm) wall tubing with a maximum OD of 12.75" (323.9 mm) and a minimum ID of 3.44" (87.4 mm) may be beveled with standard mandrel.
  - D. Wall Thickness Capacity
    - i. Wall thickness of all standard pipe schedules 1.32" (33.4 mm) maximum in the range listed. Tubing with greater wall thickness may be handled provided the ID is greater than 3.44" (87.4 mm) and the OD is less than 12.75" (323.9 mm). Contact TRI TOOL Inc. for heavier wall procedures.
  - E. Counterboring Operations
    - i. The tool will counterbore pipe and tubing with an ID range of 3.44" (87.4 mm) to 12.44" (316.0 mm).
3. Material Cutting Capabilities
  - A. Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel alloys and aluminum without limitations except size and wall thickness as specified.

- 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 DIA.

- i. 13.25" (336.6 mm)

B. Length Over Motor

- i. 26.68" (677.67 mm)

C. Length (Parallel to Axis of Pipe)

- i. 21.25" (539.8 mm)

5. Drive System

A. Final Drive

- i. Gear Driven

B. Electric Motor

- i. Free Speed
  - a. 150 rpm
- ii. Maximum HP Speed
  - a. 100 rpm

C. Pneumatic Motor Drive and Hydraulic Motor Drive are also available.

6. Power Supply

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. 10 rpm

B. Cutting Head Speed @ Maximum HP

- i. 6.7 rpm

C. Functional Speed Range

- i. 4 – 9 rpm

D. RPM at 200 Surface Inches per Minute

- i. 12.75" (323.9 mm) DIA.
  - a. 6 rpm
- ii. 4.00" (101.6 mm) DIA.
  - a. 16 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.
- B. Maximum available feed travel is 2.00" (50.8 mm).

Accessories (Optional)

- 1. Flange Facer Kit
- 2. Elbow Mandrel Kit

3. Elbow Mandrel Pointer Kit
4. Dial Indicator Kit
5. Miter Mandrel Kit
6. Sleeve Mandrel Kit
7. ID Tracking Module Kit

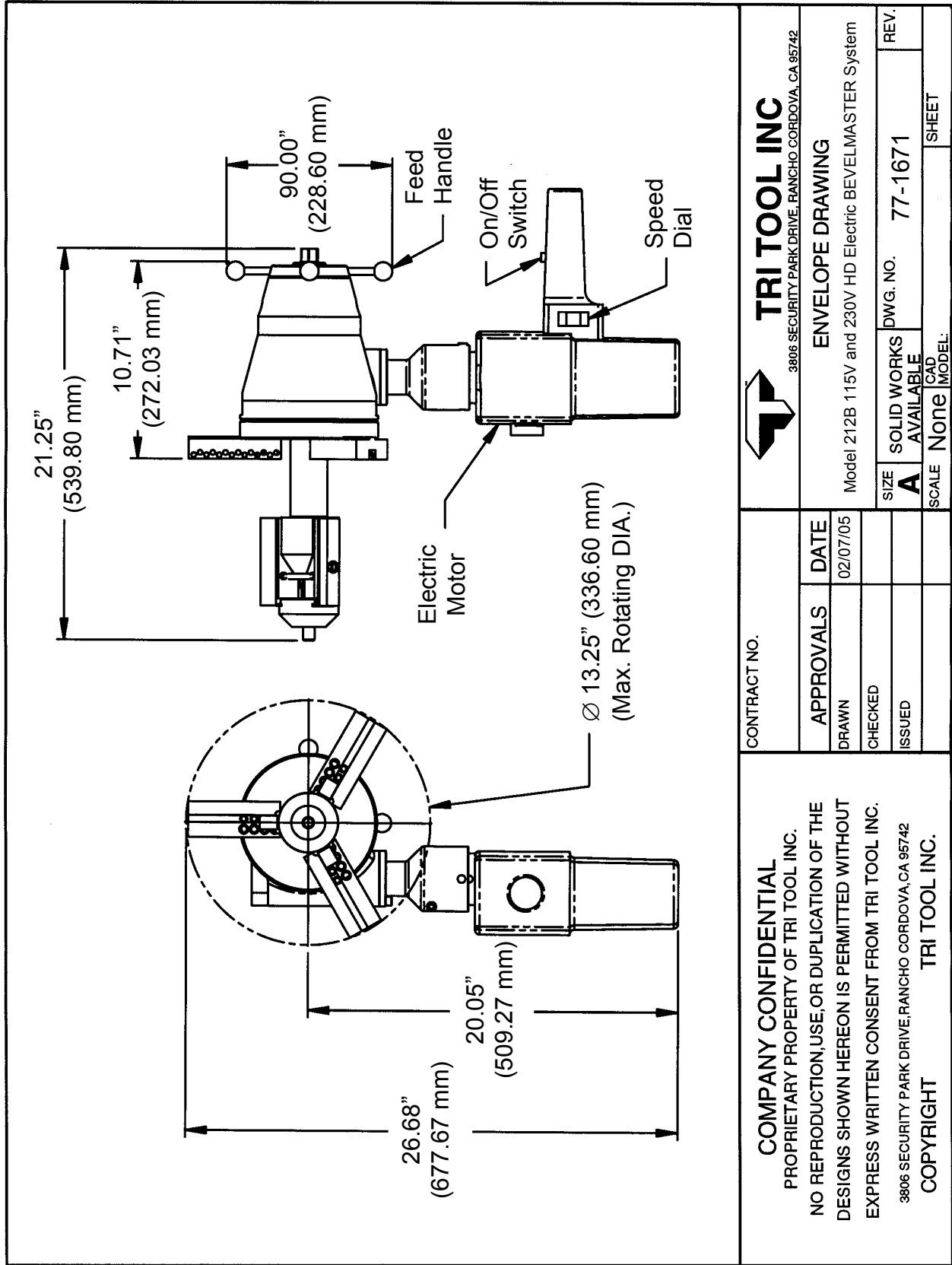
#### Note To The Customer

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.



<p><b>TRI TOOL INC</b> 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</p>		<p><b>ENVELOPE DRAWING</b></p>	
		<p>Model 212B 115V and 230V HD Electric BEVELMASTER System</p>	
<p>CONTRACT NO.</p>	<p>APPROVALS</p>	<p>DATE</p>	<p>REV.</p>
	<p>DRAWN</p>	<p>02/07/05</p>	<p>77-1671</p>
	<p>CHECKED</p>		<p>DWG. NO.</p>
	<p>ISSUED</p>		<p>SIZE</p>
			<p><b>A</b> SOLID WORKS</p>
			<p>AVAILABLE</p>
			<p>SCALE None</p>
			<p>CAD MODEL: SHEET</p>
<p><b>COMPANY CONFIDENTIAL</b> PROPRIETARY PROPERTY OF TRI TOOL INC. NO REPRODUCTION, USE, OR DUPLICATION OF THE DESIGNS SHOWN HEREON IS PERMITTED WITHOUT EXPRESS WRITTEN CONSENT FROM TRI TOOL INC. 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742 COPYRIGHT TRI TOOL INC.</p>			