



TRI TOOL INC.

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TRI TOOL INC. TECHNICAL SPECIFICATION MODEL 212B BEVELMASTER™ FLANGE FACER JANUARY 2001

MODEL 212B BEVELMASTER™ FLANGE FACER

The Model 212B Flange Facer is supplied as a kit to provide a Model 212B BEVELMASTER™ with flange facing capabilities over a cutting range of 3.44" (87.4 mm) to 24.00" (609.6 mm) diameters. The kit allows a quick, easy field conversion of the Model 212B from a beveling configuration to a flange facer configuration and back again as required.

The Model 212B Flange Facer Kit comes complete with:

- Flange Facer Assembly, 212B
- Tripper Block Assemblies
- Tool Bit, Outside, Record Finish
- Tool Bit, Outside, Smooth Finish
- Carrying Case
- Operator's Manual
- Wrench Kit

Design and Operation Features

1. Radial feed can be either .013" (.33 mm) with one tripper pin or .026" (.66 mm) with two tripper pins per revolution with standard lead screw.
2. Axial position adjustment is provided with the Model 212B mandrel system and then locked to prevent movement during the facing operation.
3. The standard 212B mandrel provides mounting from 3.31" (84.1 mm) to 13.09" (332.5 mm) inside diameter range. Short perch length mandrels are available as an optional accessory.

Specifications

1. Reference Envelope Drawing No.: 77-1079
2. Range 3.44" (87.4 mm) to 24.00" (609.6 mm) dia.

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| 3. | Automatic radial feed travel | 9.50" (241.3 mm) |
| 4. | Feed rate | .013" (.330 mm) or .026" (.66 mm) per rev. |
| 5. | Maximum chip width | .020" (.51 mm) |
| 6. | Materials | |

Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel alloys and aluminum.

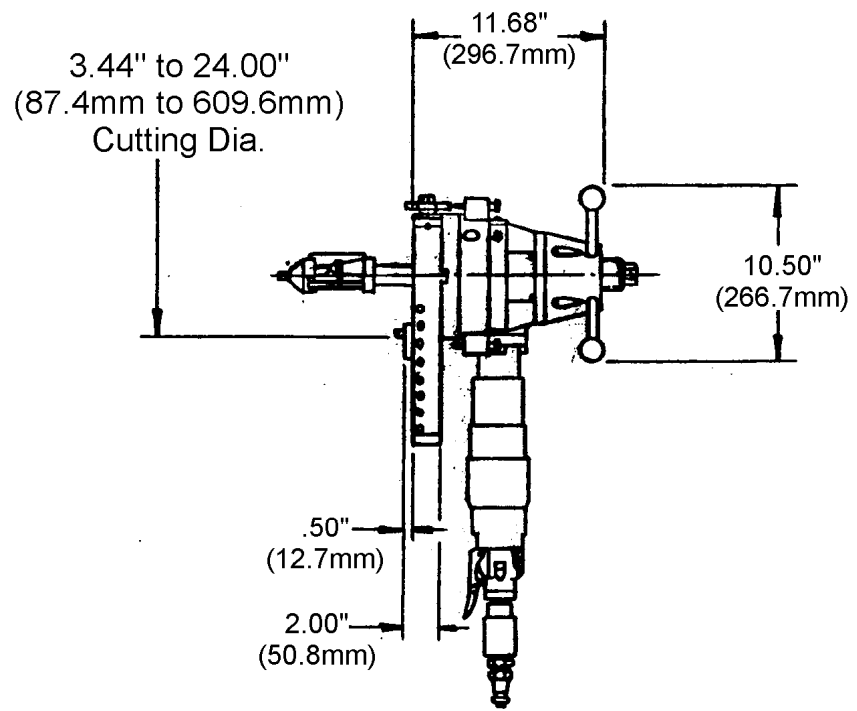
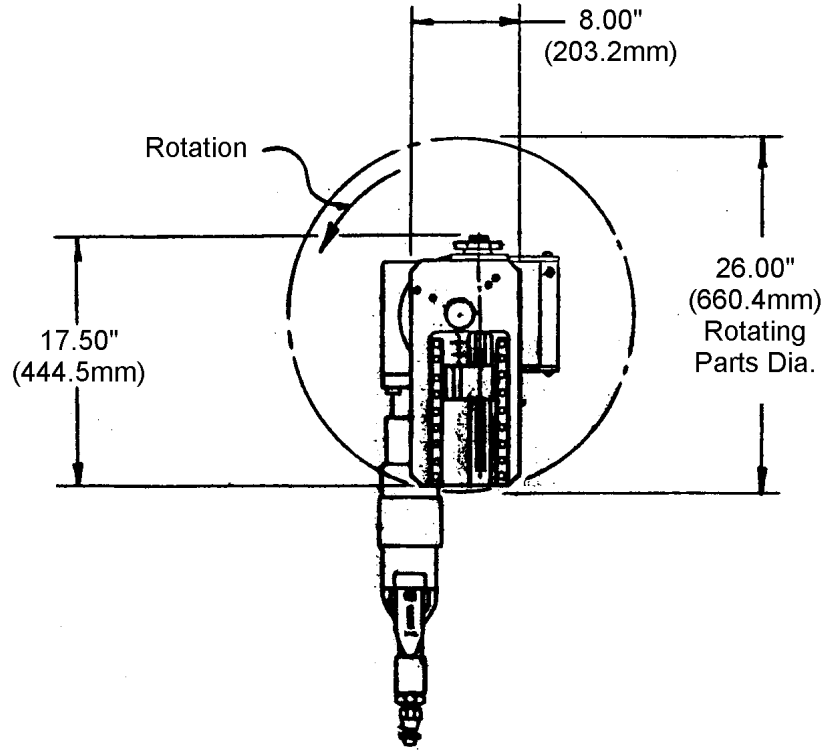
Note To The Customer

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 Inc. 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.



NEXT ASSY		USED ON		QTY REQD	PCOM NO.	PART OR IDENTIFYING NO.	NUMERICAL OR DESCRIPTION	MATERIAL SPECIFICATION					
				PARTS LIST									
<p>COMPANY CONFIDENTIAL PROPRIETARY PROPERTY OF TRI TOOL INC. NO REPRODUCTION, USE, OR DUPLICATION OF THE DESIGN SHOWN HEREON IS PERMITTED WITHOUT EXPRESS WRITTEN CONSENT FROM TRI TOOL INC. 300 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</p> <p>COPYRIGHT TRI TOOL INC.</p>		<p>UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES TOLERANCES ARE: DECIMALS FRACTIONS ANGLES .XX ±.00 ± 1/16 0° 30' .XXX ±.010 MACHINED SURFACES 125- € TO BE CONCENTRIC WITHIN .010 TRI FLATNESS TO WITHIN .010 TRI BREAK ALL SHARP EDGES .005-.015 FILLET RADII TO BE .005 MAX C'SINK THE HOLES TO MAJ DIA X 80°</p>		MATERIAL		CONTRACT NO.		<p>TRI TOOL INC. 300 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</p>					
				FINISH		APPROVALS				DATE			
								DRAWN		3/21/91		<p>ENVELOPE DRAWING, MODEL 212B FLANGE FACER</p>	
								CHECKED					
								<p>SIZE: B PCOM NO. DWG. NO. 77-1079 REV.</p>					
								<p>SCALE: NONE SHEET 1 OF 1</p>					