

TRI TOOL INC.

TECHNICAL SPECIFICATION
MODEL 212B BEVELMASTER™ SINGLE POINT
NOVEMBER, 1998

MODEL 212 BEVELMASTER™ SINGLE POINT

The Model 212B Single Point is supplied as a kit to provide a Model 212B BEVELMASTER™ with flange facing and beveling capabilities over a cutting range of 8.20" (208.3mm) to 24.00" (609.6mm) diameter beveling angles between 0° and 45°. The kit allows quick, easy field conversion of the 212B from beveling configuration to a single point configuration and back again as required.

The 212B Single Point Kit comes complete with:

a.	Single Point Assembly	
b.	Tripper Block Assembly	2 ea.
c.	Inset Tool Holder	1 ea.
d.	Counterbore Tool Bit Holder	1 ea.
e.	Mandrel Assembly	1 ea.
f.	Safety Guard	1 ea.
g.	Operator's Manual	1 ea.
h.	All required operator's wrenches.	1 kt.

Optional Equipment:

a.	3-Jaw Block Mounting Kit 6.10" (154.9mm) to 23.50" (596.9mm)	1 kt.
b.	Miter Mandrel Head Kit 6.10" (154.9mm) to 23.50" (596.9mm)	1 kt.

Design and Operating Features:

1. Radial feed can be set from 0 to .013" (0.33mm), with one tripper, or 0 to .026" (0.66mm) with two trippers, per revolution.
2. Axial position adjustment is provide with the 212B mandrel system and then locked to prevent movement during the facing operation.
3. Slide assembly has infinitely variable bevel angle adjustment between 0° and 45°. The system has preselected angle locations at 0°, 5°, 10°, 15°, 20°, 25°, 30°, 37.5°, and 45°.
4. Maximum radial feed travel is 3.30" (83.8mm), when single point is set at 0°.
5. The 212B Single Point mandrel jaw block kit and Miter mandrel head kit provide mounting from 6.10" (154.9mm) to 23.50" (596.9mm) inside diameter range.

Specifications:

1. Range: 8.20" (208.3mm) to 24.00" (609.6mm) dia.
2. Bevel Angle: 0° to 45°.
3. Feed Rate: 0" to .026" (0.66mm) per revolution
4. Maximum Wall Thickness: 1.50" (38.1mm) at 37.5°
2.34" (59.4mm) at 37.5°/10° compound bevel
5. Maximum chip width: .200" (5.1mm), depending on material
6. Alignment: When used with Miter Mandrel:
Angular: ± 5°
Offset: ±.190" (4.8mm)
7. Materials:
 - a. Mild steels, Chrome steels (Rc 35 max.) stainless steel, copper-nickel and aluminum.
 - 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.

8. Clearances and dimensions: See attached envelope drawings.

77-1590
77-1591

212B Single Point with Jaw Blocks
212B Single Point with Miter Mandrel.

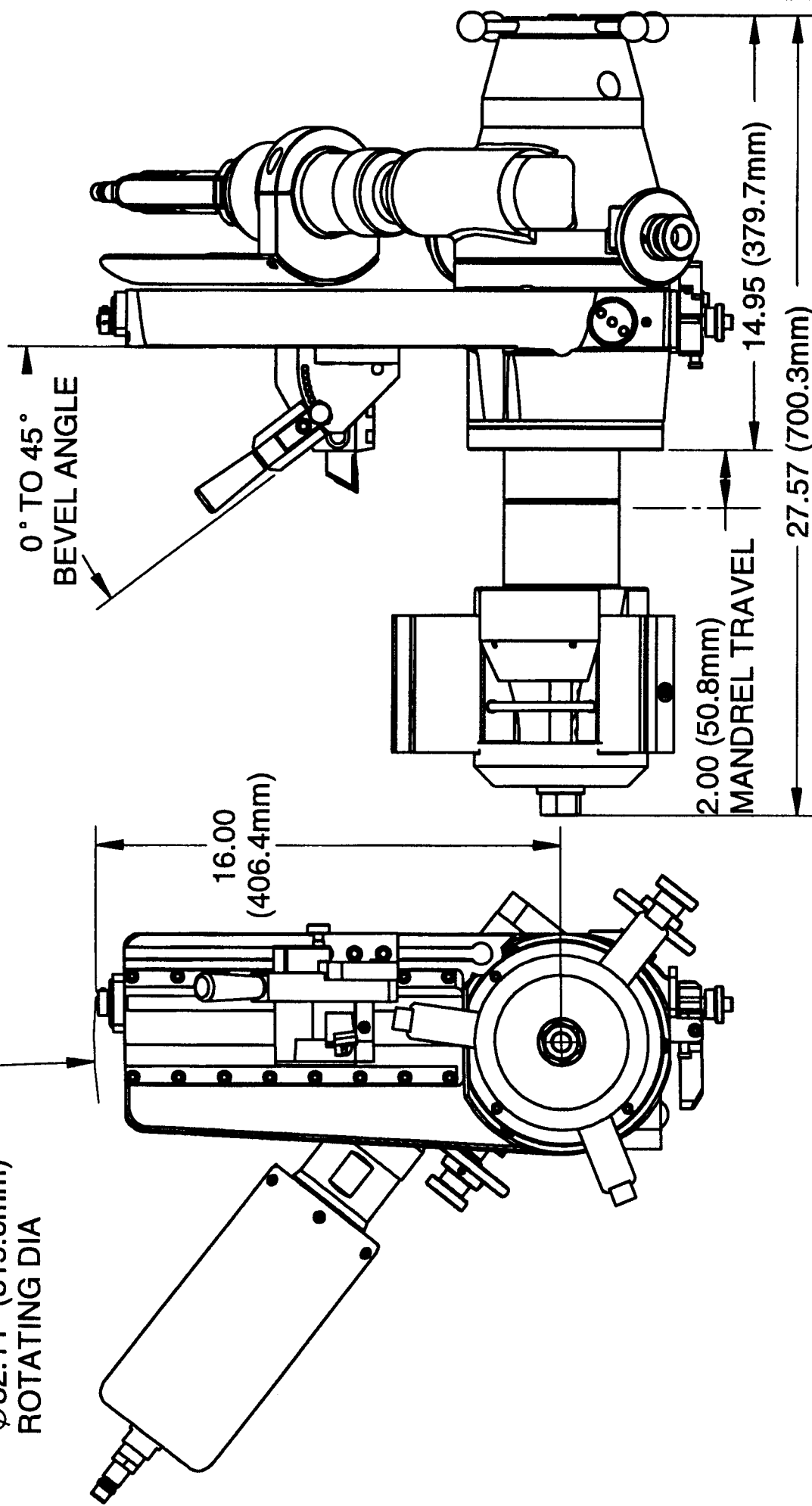
Spare parts and standard tool bits are available from stock. Engineering design services for custom tool bits and special function modifications are available from the factory.

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.

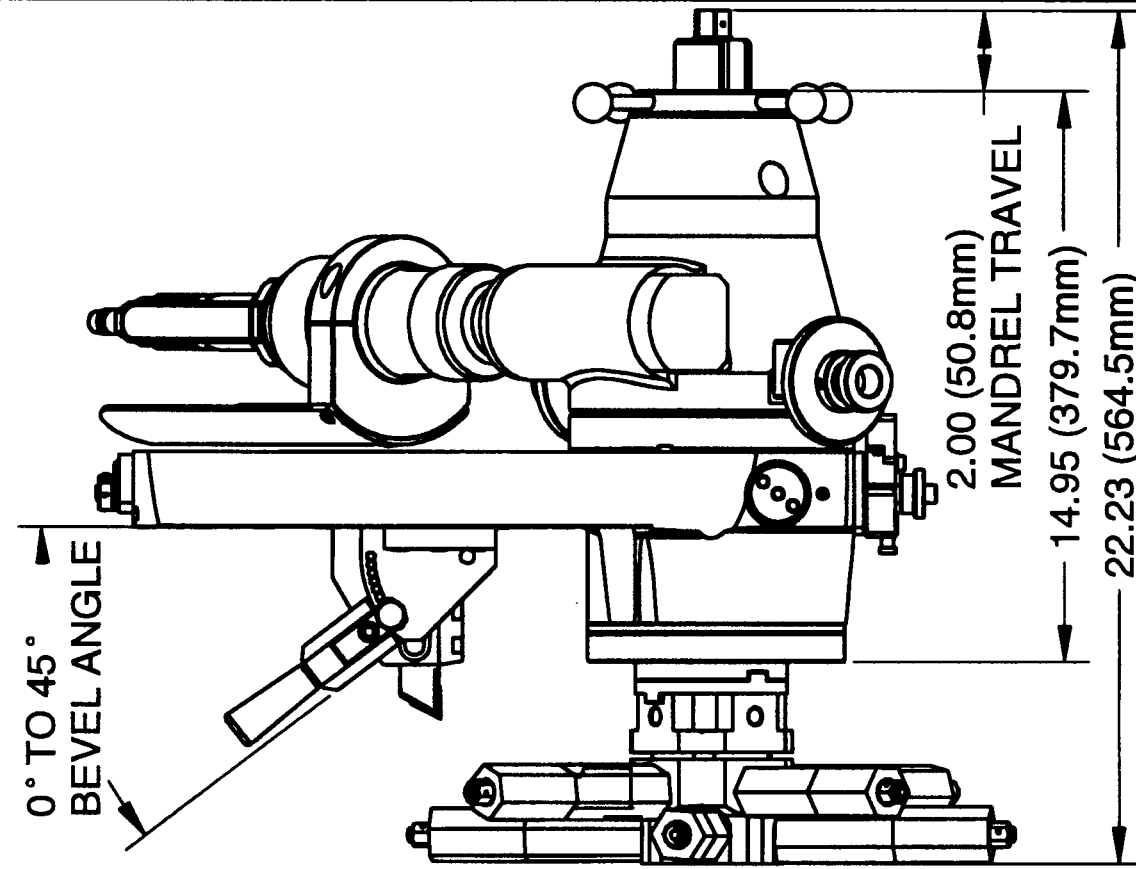
Warranty (limited), parts and/or equipment are warranted against defects in material and workmanship for a period of one year from date of purchase. Full Details supplied on request and/or with tools.
protect warranty on air powered tools.

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

Ø32.11" (815.6mm)
ROTATING DIA



<p>TRI TOOL INC 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742</p>		<p>ENVELOPE DRAWING 212B SINGLE POINT WITH JAW BLOCKS</p>		<p>REV.</p>
<p>CONTRACT NO. ER8071</p>	<p>APPROVALS</p>	<p>DATE</p>	<p>SIZE A</p>	<p>DWG. NO. 77-1590</p>
<p>APPROVED BY R MORGAN</p>	<p>CHECKED</p>	<p>ISSUED</p>	<p>SOLID WORKS AVAILABLE</p>	<p>CAD MODEL 1 / 5</p>
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TRI TOOL INC
3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742

ENVELOPE DRAWING
**212B SINGLE POINT
WITH MITRE MANDREL**

SIZE **A** SOLID WORKS DWG. NO. **77-1591** REV.
AVAILABLE

SCALE 1/5 CAD MODEL 01-1689.SLDASM SHEET 1 OF 1

CONTRACT NO. ER8071	
APPROVALS	DATE
DRAWN R MORGAN	10/6/97
CHECKED	
ISSUED	

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