



TRI TOOL INC.

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TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL 214B BEVELMASTER® SP (SINGLE POINT) KIT
OCTOBER 2010

Model 214B BEVELMASTER® SP (Single Point) Kit

The Model 214B BEVELMASTER® SP is supplied as a kit to provide a Model 214B BEVELMASTER® with flange facing and beveling capabilities over a cutting range of 8.20" (208.3 mm) to 24.00" (609.6 mm) diameter beveling angles between 0° and 45°. The kit allows quick, easy field conversion of the 214B from beveling configuration to a single point configuration and back again as required.

The Model 214B BEVELMASTER® SP Kit comes complete with:

▪ Single Point Assembly	1 ea.
▪ Tripper Block Assembly	2 ea.
▪ Inset Tool Holder	1 ea.
▪ Counterbore Tool Bit Holder	1 ea.
▪ Mandrel Assembly	1 ea.
▪ Safety Guard	1 ea.
▪ Operator's Manual	1 ea.
▪ Wrench Kit	1 set

Design and Operating Features

1. Radial feed can be set from 0 to .013" (0.33 mm), with one (1) tripper, or 0 to .026" (0.66 mm) with two (2) trippers, per revolution.
2. Axial position adjustment is provide with the 214B 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" (83.8 mm), when single point is set at 0°.
5. The 214B Single Point mandrel jaw block kit and Miter mandrel head kit provide mounting from 6.10" (154.9 mm) to 23.50" (596.9 mm) inside diameter range.

Specifications

1. Reference Envelope Drawing No.: 77- 1720 and 77-1721
2. Weight
 - A. 56 lbs (25.4 kg)Xx
3. Clearance and Dimensions
 - A. Reference envelope drawings.
4. Cutting Capacity
 - A. Range
 - i. 8.20" (208.3 mm) to 24.00" (609.6 mm) dia.
 - B. Wall Thickness (Max.)
 - i. 1.50" (38.1 mm) at 37.5°
 - ii. 2.34" (59.4mm) at 37.5°/10° compound bevel
 - C. Chip Width
 - i. .200" (5.1 mm), depending on material
 - D. Bevel Angle
 - i. 0° to 45°.
5. Material
 - 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.
6. Alignment (When used with Miter Mandrel Kit)
 - A. Angular $\pm 5^\circ$
 - B. Offset $\pm .190"$ (4.8 mm)

7. Feed Rate

- A. 0" to .026" (0.66 mm) per revolution

Accessories (Optional)

1. 3-Jaw Block Mounting Kit [.610" (154.9 mm) to 23.50" (596.9 mm)]
2. Miter Mandrel Head Kit [.610" (154.9 mm) to 23.50" (596.9 mm)]

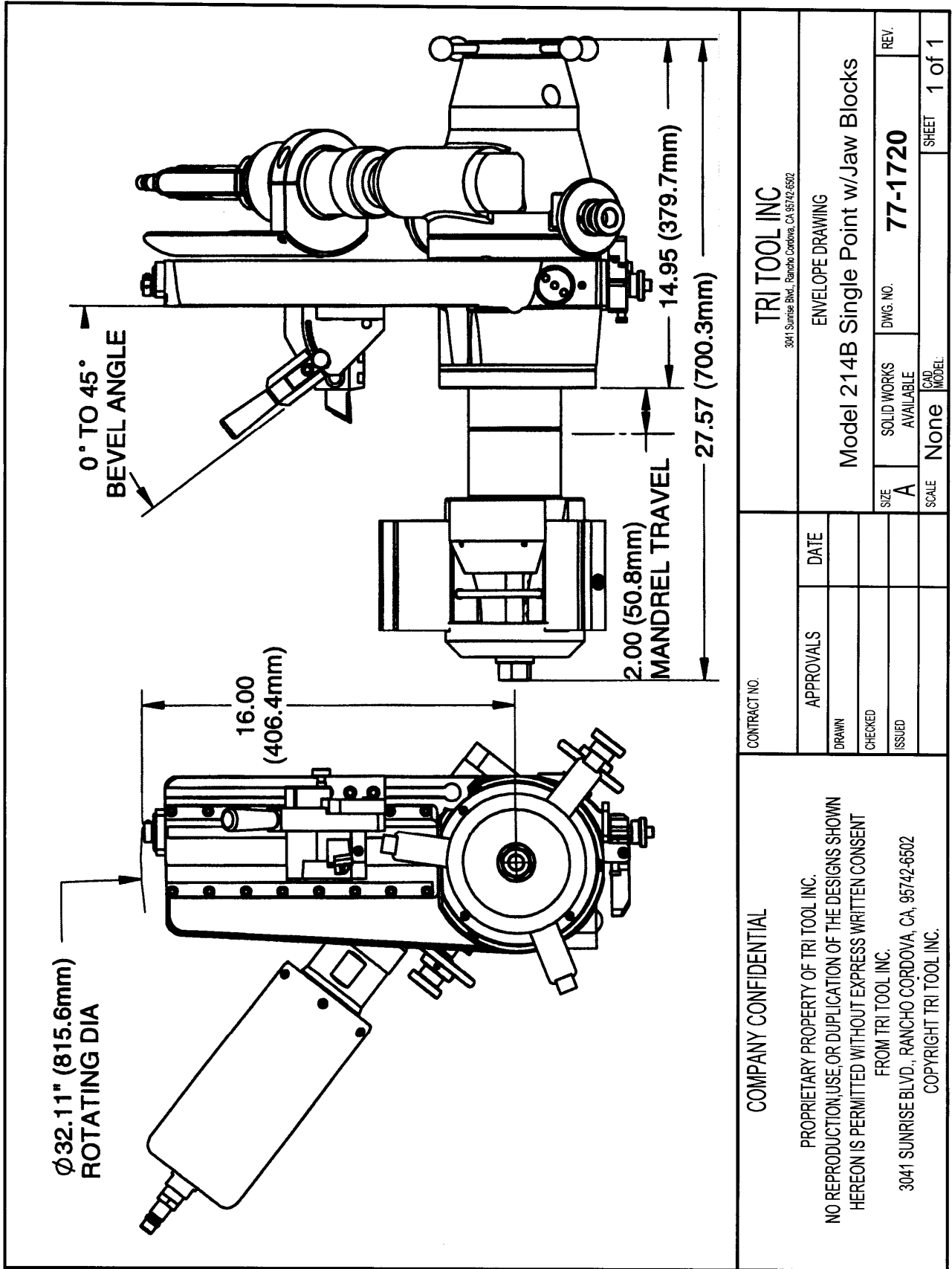
Note To The Customer

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.

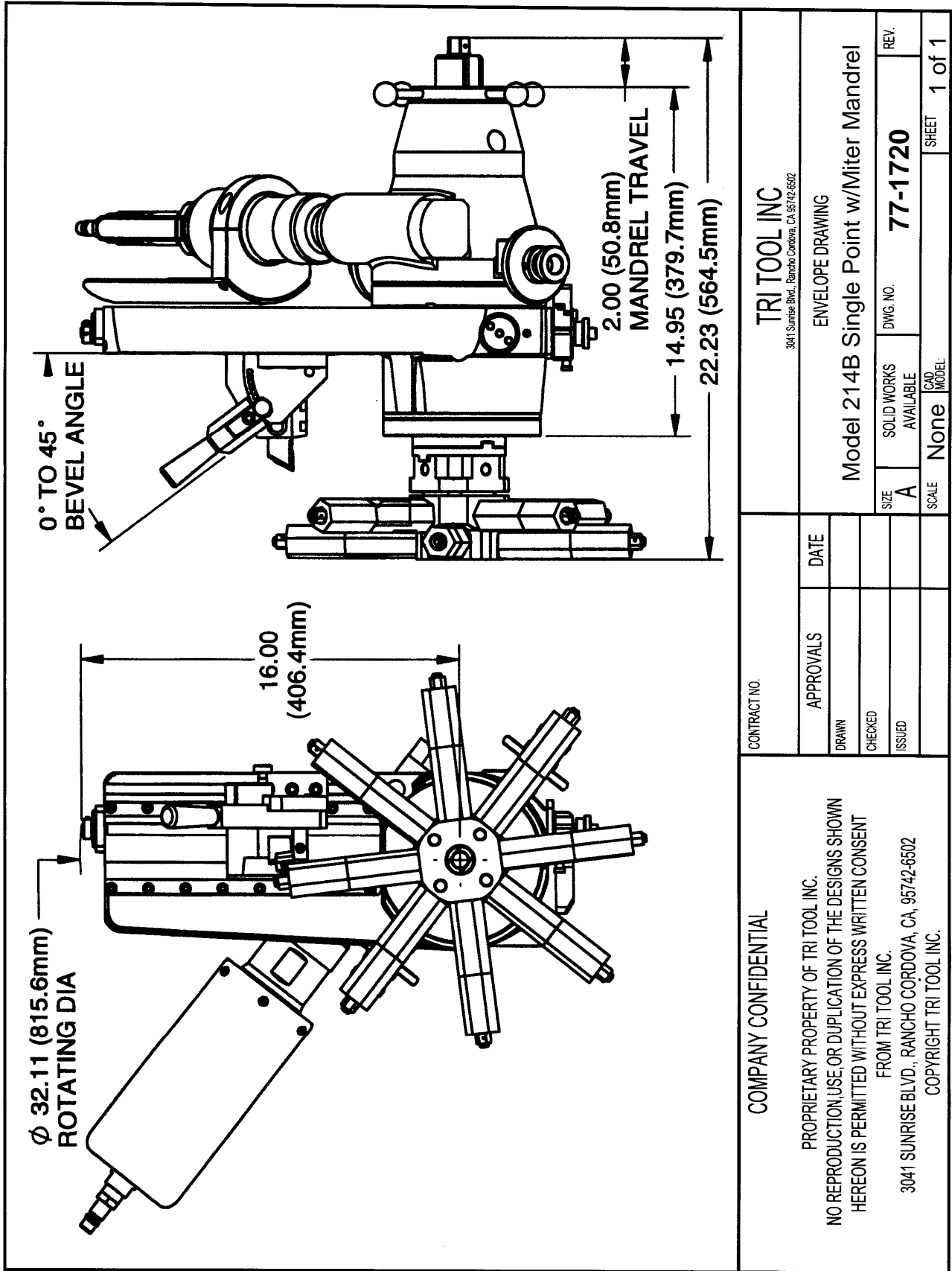
Filter, regulator and lubricator are required to protect the warranty on air powered tools.



CONTRACT NO.		TRI TOOL INC 3041 Sunrise Blvd., Rancho Cordova, CA 95742-6502	
APPROVALS	DATE	ENVELOPE DRAWING	
DRAWN		Model 214B Single Point w/Jaw Blocks	
CHECKED		SIZE	SOLID WORKS AVAILABLE
ISSUED		A	
		SCALE	CAD MODEL
		None	None
		DWG. NO.	REV.
		77-1720	1 of 1

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<p>TRI TOOL INC 3041 Sunrise Blvd., Rancho Cordova, CA 95742-6502</p>		<p>ENVELOPE DRAWING</p>	
<p>Model 214B Single Point w/Miter Mandrel</p>		<p>SIZE A</p>	<p>REV. 77-1720</p>
<p>CONTRACT NO.</p>		<p>SOLID WORKS AVAILABLE</p>	<p>DWG. NO. 77-1720</p>
<p>APPROVALS</p>	<p>DATE</p>	<p>SCALE None</p>	<p>SHEET 1 of 1</p>
<p>DRAWN</p>		<p>CAD MODEL</p>	
<p>CHECKED</p>			
<p>ISSUED</p>			
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