

TRI TOOL INC.  
TECHNICAL SPECIFICATION  
MODEL 230B BEVELMASTER™ SYSTEM  
NOVEMBER, 1998

MODEL 230B BEVELMASTER™ PORTABLE LATHE SYSTEM

The Model 230B BEVELMASTER™ is a portable I.D. mount machine tool for beveling , facing and/or counterboring 12” through 30” pipe. The tool is configured with an in line feed knob and hydraulic drive motor at a right angle to the lathe head.

The Model 230B BEVELMASTER™ System comes complete with:

A.	Model 230B Subassy	1 ea.
B.	Tool Holder Assy.	3 ea.
C.	Mandrel Assy.	1 ea.
D.	Mandrel Head Assy., 5 jaw	1 ea.
E.	Jaw Block Assy. Sets	5 ea.
F.	Lathe Stand Assy.	1 ea.
G.	Hydraulic Motor Assy.	1 ea.
H	Wrench Kit	1 ea.
I.	Operators manual	1 ea.

Optional Accessories:

Single Point Module Kit  
I.D. Tracking Module Kit  
Miter 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 ( less Tool Bits ) are provided with the system.
4. The lathe is provided with a stand and hoist ring.

Specifications:

1. Reference Envelope drawing No. 77-1614

2. Pipe Cutting Capacities:

- a. Basic pipe sizes:  
12" schedule 5 through schedule 80  
All schedules of 14" through 30" pipe
- b. Basic Tube Sizes:  
Up to 1.312" (33.3mm) wall tubing with a maximum O.D. of 30.00" (762.0mm) and a minimum I.D of 11.38" ( 289.1mm ) may be beveled with the standard mandrel.
- c. Wall Thickness Capacity:  
Wall thickness of all standard pipe schedules [1.312" (33.3mm) maximum] in the range listed. Tubing or pipe with greater wall thickness may be handled provided the I.D. is greater than 11.38" (289.1mm) and the O.D. is less than 30.00" (762.0mm). Contact Tri Tool for heavier wall procedures.
- d. Counterboring Operations:  
The tool will counterbore pipe and tubing with an I.D. range of 11.38" (289.1mm) to 29.50" (749.3mm).

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 in paragraph #2.
- b. Inconel and some other high temperature alloys may require special procedures as a function of wall thickness and type of end preparations. Contact Tri Tool's Engineering Department for details.

4. Clearances and Dimensions:

- a. Maximum Rotating Head Dia. 37.60" (955.0mm)
- b. Length (parallel to axis of pipe) 48.66" (1236.0mm)
- c. Available feed travel 5.00" (127.0mm)

5. Drive System:

- a. Hydraulic Motor: (Single or Dual)  
(Requires separate hydraulic power supply. Ref: 765RVC technical specification)  
Unit requirements 20 GPM (1.3 L/s) at 1250 PSI (8619 kPa)
- b. Pneumatic Motor: (Dual)  
Optional

6. Cutting Head Speeds:

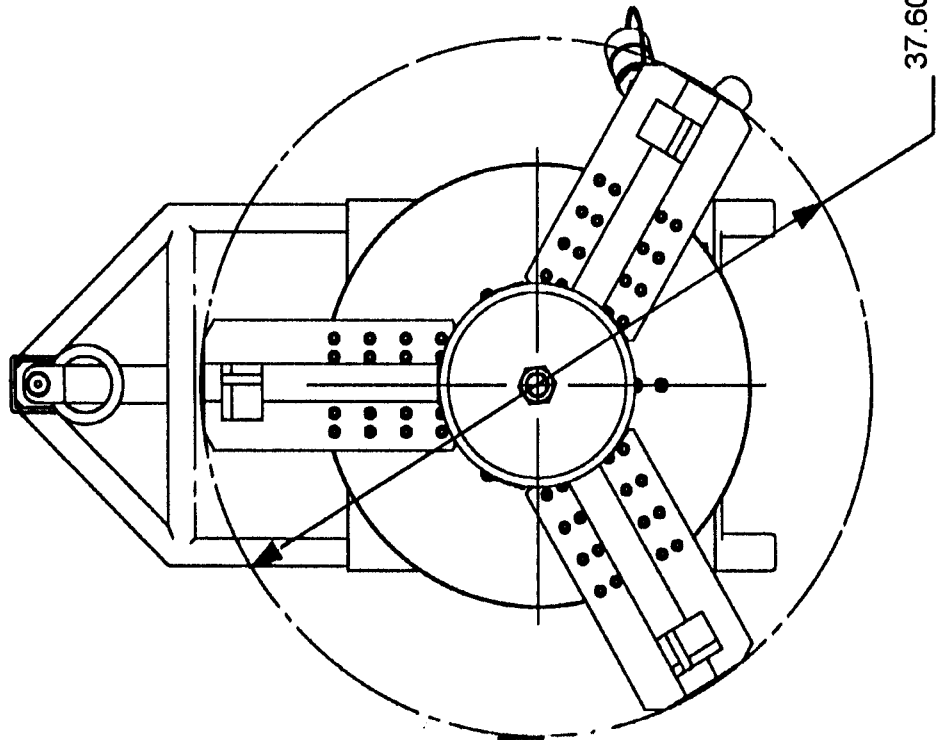
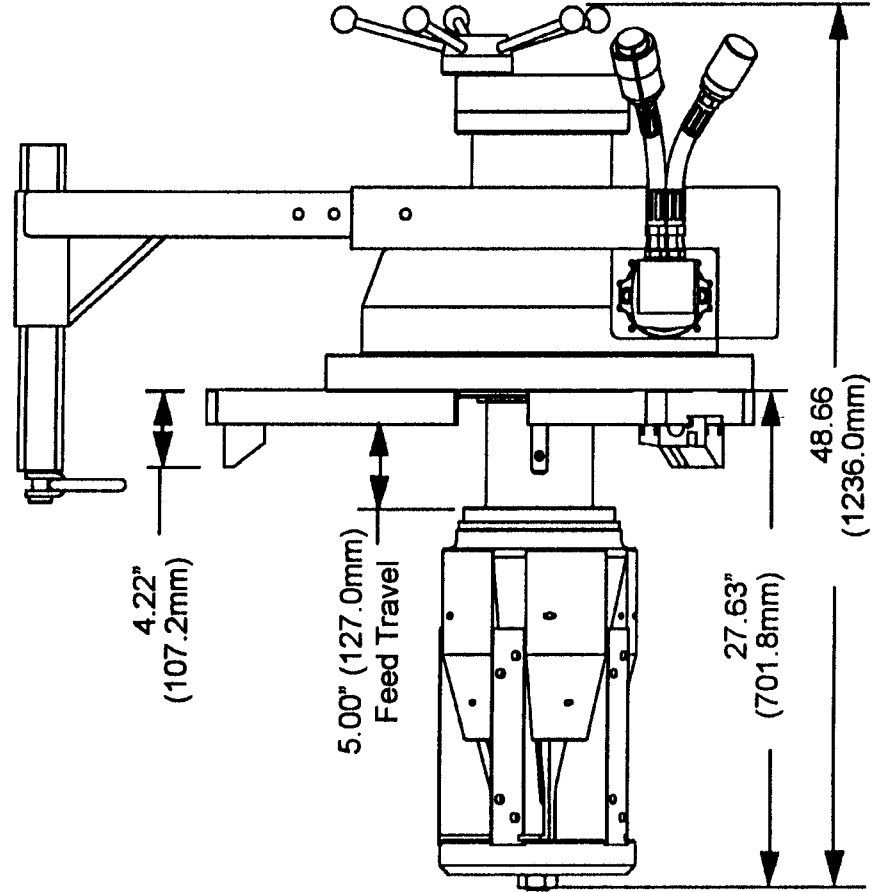
- |    |                                   |            |
|----|-----------------------------------|------------|
| a. | Maximum cutting head speed        | 5 rpm      |
| b. | Cutting head speed @ maximum H.P. | 3 rpm      |
| c. | Functional speed range            | 3 to 5 rpm |
7. Mounting:
- a. Manually actuated draw rod expands mandrel ramps and jaw blocks.
8. Feed:
- a. Manual-Feed handle is in line at the back of the machine. Feed rate is .033” (.84mm) per revolution of the feed handle
9. Approximate weight:
- Complete machine with mandrel, drive motor and stand: 1200 lbs.(554 kg.)

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.

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



**TRI TOOL INC**

3808 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742

ENVELOPE DRAWING

**230B BEVELMASTER™**

CONTRACT NO.		APPROVALS	DATE
		DRAWN J BROWN	11/05/98
		CHECKED	
		ISSUED	

SIZE	SOLID WORKS AVAILABLE	DWG. NO.	REV.
A		77-1614	
SCALE	1 / 1	SHEET 1 of 1	

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