



TRI TOOL INC.

TRI TOOL INTERNATIONAL INC.

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TRI TOOL INC. TECHNICAL SPECIFICATION MODEL 206B BEVELMASTER™ SYSTEM JANUARY, 2001

MODEL 206B BEVELMASTER™ PORTABLE LATHE SYSTEM

The Model 206B BEVELMASTER™ is a portable I.D. mount machine tool for beveling, facing and counterboring 2" through 6" pipe. The tool is configured with an in line feed knob and pneumatic drive motor at a right angle to the lathe head.

Design and Operation Features:

1. The lathe accepts it's own torque through the mandrel.
2. The expanding mandrel provides fast, accurate self-centering and alignment.
2. All wrenches needed for operation (less tool bits) are provided with the system.
3. The lathe, at less than 45lbs. (20.4 Kg.), is lightweight and easily handled by one operator.

The Model 206B BEVELMASTER™ System comes complete with:

- A. Model 206B Subassembly
- B. Tool Holder Assembly
- C. Mandrel Assembly
- D. Air Motor Assembly
- E. Jaw Block Assembly Sets
- F. Shipping Kit
- G. Carrying Case
- H. Operator's Manual

Optional Accessories:

Flange Facer Kit
Elbow Mandrel Kit
Pointer Kit, Elbow Mandrel
Mandrel Assembly, Small Elbow
Elbow Mandrel Squaring Plate Kit
Adjustable Pin Kit, Elbow Mandrel
Dial Indicator Kit
Miter Mandrel Kit
Sleeve Mandrel Kit
I.D. Tracking Module Kit
Air Caddy, FRL

Specifications:

1. Reference Envelope drawing No. 77-0858
2. Pipe Cutting Capacities:
 - a. Basic pipe sizes:
 - 1 1/2" schedules 5 and 10
 - 2" schedule 5 through schedule 160
 - All schedules of 3" through 6" pipe
 - b. Basic Tube Sizes:
 - Up to .875" (22.2mm) wall tubing with a maximum O.D. of 6.63" (168.4mm) and a minimum I.D. of 1.63" (41.4mm) may be beveled with standard mandrel.
 - c. Wall Thickness Capacity:
 - Wall thickness of all standard pipe schedules [.875" (22.2mm) maximum] in the range listed. Tubing with greater wall thickness may be handled provided the I.D. is greater than 1.63" (41.4mm) and the O.D. is less than 6.63" (168.4mm). Contact TRI TOOL Inc. for heavier wall procedures.
 - d. Counterboring Operations:
 - The tool will counterbore pipe and tubing with an I.D. range of 2.00" (50.8mm) to 6.41" (162.8mm).
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 preparation. Contact TRI TOOL Inc's. Engineering Department for details.
4. Clearances and Dimensions:
- | | | |
|----|-----------------------------------|------------------|
| a. | Maximum Rotating Head Dia. | 6.50" (165.1mm) |
| b. | Length over motor | 28.42" (721.9mm) |
| c. | Maximum width | 9.50" (241.3mm) |
| d. | Length (parallel to axis of pipe) | 17.40" (442.0mm) |
5. Drive System:
- | | | |
|----|------------------|-------------|
| a. | Final Drive | Gear Driven |
| b. | Pneumatic Motor: | |
| | Free speed | 310 rpm |
| | Max H.P. speed | 155 rpm |
6. Power Supply:
- a. Pneumatic motor requires 85 cfm (40 L/s) air supply at 90 psi (621 kPa) for maximum horsepower delivery.
- Note: Air supply must have a filter/regulator/lubricator (FRL) system to protect the warranty on the air motor.
7. Cutting Head Speeds:
- | | | |
|----|---------------------------------------|-----------|
| a. | Maximum cutting head speeds | 78 rpm |
| b. | Cutting head speeds @ maximum H.P. | 39 rpm |
| c. | Functional speed range | 10-60 rpm |
| d. | RPM at 300 surface inches per minute: | |
| | 6.63" (168.4mm) | 14 rpm |
| | 1.69" (42.9mm) | 56 rpm |
8. Speed Control:
- a. On/off safety lever valve and twist-type air flow control valve.
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" (2.1mm) per revolution of the feed handle .
 - b. Maximum available feed travel is 2.00" (50.8mm)

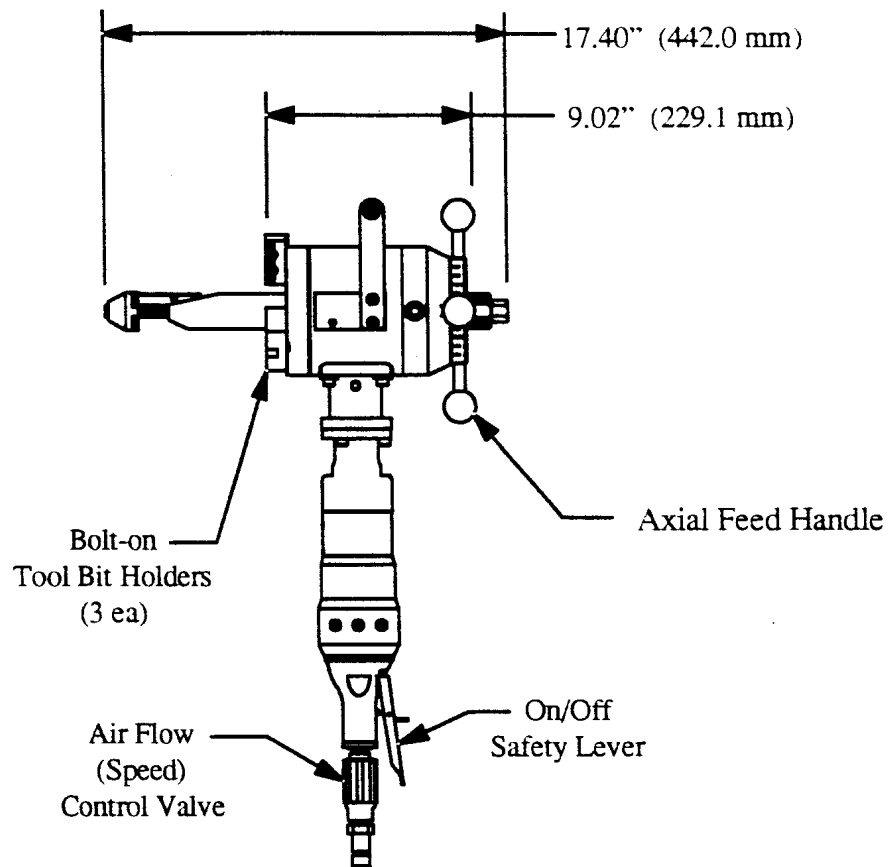
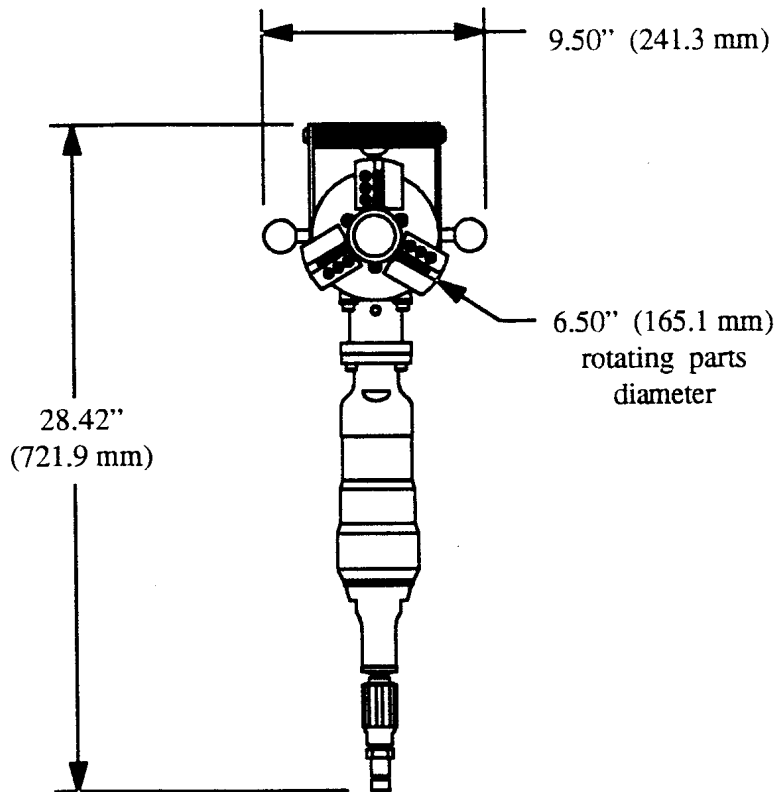
Spare parts and standard tool bits are available from stock.

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/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.



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		<p>DRAWN PFAFMAN</p>			
<p>CHECKED</p>		<p>DO NOT SCALE DRAWING</p>		<p>DWG NO. 77-0858 REV</p>	
				<p>SHEET 1 of 1</p>	