



TRI TOOL INC.

TRI TOOL INTERNATIONAL 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" (87.4mm) to 24.00" (609.6mm) 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:

- A. Flange Facer Assembly, 212B
- B. Tripper Block Assemblies
- C. Tool Bit, Outside, Record Finish
- D. Tool Bit, Outside, Smooth Finish
- E. Carrying Case
- F. Operator's Manual
- G. Wrench Kit

Design and Operation Features:

1. Radial feed can be either .013" (.33mm) with one tripper pin or .026" (.66mm) 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" (84.1mm) to 13.09" (332.5mm) 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" (87.4mm) to 24.00" (609.6mm) diameter
3. Automatic radial feed travel: 9.50" (241.3mm)

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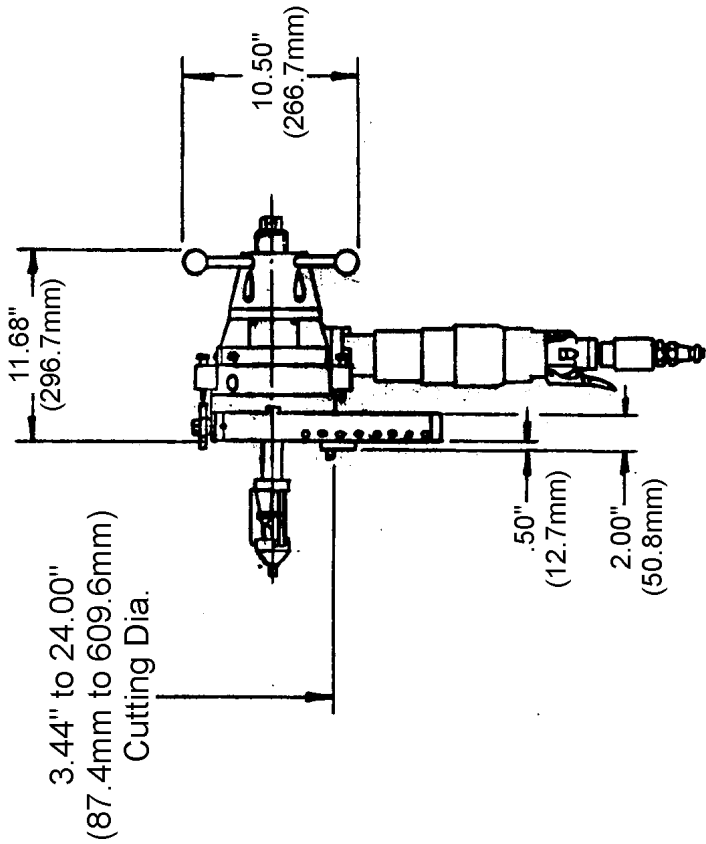
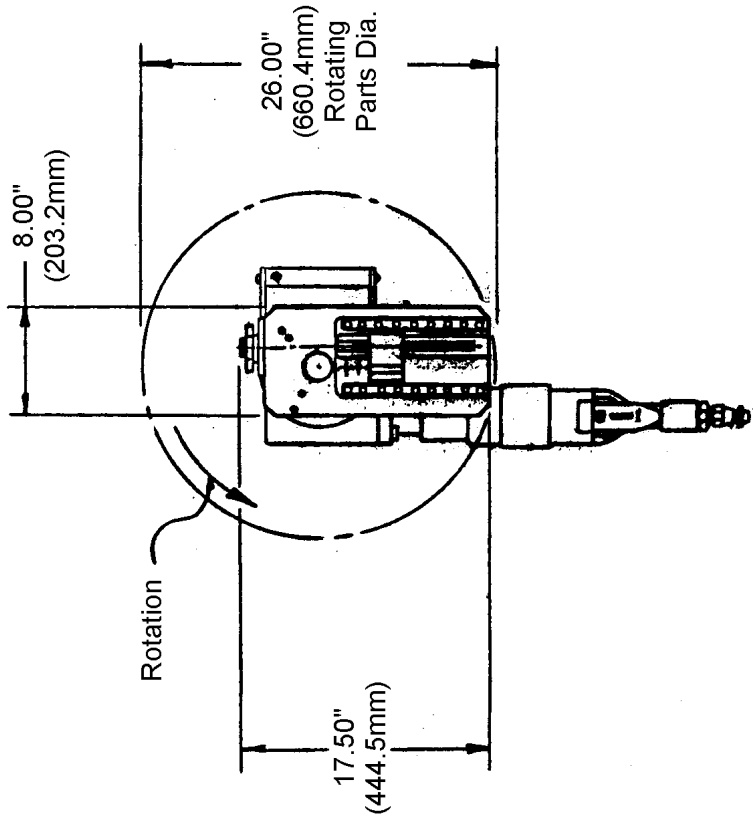
4. Feed rate: 013" (.330mm) or .026" (.66mm) per revolution
5. Maximum chip width: .200" (5.1mm)
6. Materials: Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel alloys and aluminum.

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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**ENVELOPE DRAWING, MODEL 212B
 FLANGE FACER**

DATE: 2/21/51
 APPROVALS: J. RALEY
 SIZE: B
 DWG. NO.: 77-1079
 SCALE: NONE
 SHEET 1 OF 1

CITY	POSS. NO.	PART OR DESCRIPTION NO.	NUMERICALS OR DESCRIPTION	MATERIAL SPECIFICATION
			PARTS LIST	
			MATERIAL	
			USED ON	
			CONTRACT NO.	
			FINISH	
			DO NOT SCALE DRAWING	
			UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES	
			TOLERANCES ARE:	
			DECIMALS FRACTIONS ANGLES	
			.XX ±.00 ± 1/4 0° 30'	
			.XXX ±.010	
			MACHINED SURFACES 128-	
			§ TO BE CONCENTRIC WITH .010 TR	
			FLATNESS TO WITHIN .010 TR	
			BREAK ALL SHARP EDGES .005-.015	
			PILLET RAZOR TO BE .005 MAX	
			CORNER RND HOLS TO MAJ DIA X 80°	