



# TRI TOOL INC.

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TRI TOOL INC.  
TECHNICAL SPECIFICATION  
MODEL 201BA BEVELMASTER™ SYSTEM  
OCTOBER 20, 1997

## MODEL 201BA BEVELMASTER™ PORTABLE LATHE SYSTEM

The Model 201BA BEVELMASTER™ is a portable O.D. mount machine tool for beveling and facing 1/8" through 1 1/2" pipe. The tool is configured with the feed knob at a right angle to the axis of the pipe and the pneumatic motor inline, but offset to the pipe.

The Model 201BA System comes complete with:

- Model 201BA Sub. Assembly 1 ea.
- Air Motor Assembly 1 ea.
- Wrench Kit 1 ea.
- Carrying Case 1 ea.
- Operators Manual 1 ea.

## Design and Operating Features

1. The lathe accepts it's own torque through the saddles.
2. The clamping/fixed saddle mount provides fast, accurate self-centering and alignment.
3. The clamping/adjustable saddles allow centering regardless of actual O.D. dimensions (within the size range).
4. Cutting Heads accept two (2) tool bits simultaneously.
5. All wrenches needed for operation (less tool bits) are provided with the system.
6. The lathe (at less than 15 lbs. [6.80 KG]) is lightweight and easily handled by one operator.

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Specifications

1. Reference Drawing No. 77-1499.
2. Pipe Cutting Capacities
  - A. Basic Pipe Sizes
    - i. All schedules of 1/8" through 1 1/2" pipe.
  - B. Basic Tube Sizes
    - i. Up to .400" (10.2 mm) wall tubing with a maximum O.D. of 2.00" (50.8 mm) may be beveled with standard procedures. No mounting limitations on I.D.
  - C. Wall Thickness Capacity
    - i. Wall thickness of all standard pipe schedules (.400" [10.2 mm]) in the range listed. Contact Tri Tool Inc. for heavier wall procedures.
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 function of wall thickness and type of end preparation.
4. Clearance and Dimensions
  - A. Rotating Head DIA with 2.00" (50.8 mm) DIA Head
    - i. 2.00" (50.8 mm)
  - B. Rotating Head DIA with 1.45" (36.8 mm) DIA Head
    - i. 1.45" (36.8 mm)
  - C. Length Over Motor
    - i. 16.95" (430.5 mm)
  - D. Maximum Width (Basic Machine)
    - i. 1.45" (36.8 mm)

- E. Length (Parallel to Axis of Pipe)
  - i. 18.35" 466.1 mm)
- F. Available Feed Travel
  - i. .75 (19.1 mm)
- 5. Drive System
  - A. Final Drive
    - i. Gear driven
  - B. Pneumatic Motor
    - i. Free Speed
      - a. 260 RPM
    - ii. Max. H.P. Speed
      - a. 130 RPM
- 6. Power Supply
  - A. Pneumatic Motor requires 31 cfm (14 L/s) air supply at 90 PSI (621 kPa) for maximum horsepower delivery.
- 7. Cutting Head Speeds
  - A. Maximum Cutting Head Speed
    - i. 223 RPM
  - B. Cutting Head Speed at Maximum H.P.
    - i. 112 RPM
  - C. Functional Speed Range
    - i. 47-220 RPM
- 8. Speed Control
  - A. 'Trigger' type on/off valve and 'twist' type airflow control valve.

9. Mounting

- A. Manually actuated clamping/adjustable saddle.
- B. Manually actuated clamping/fixed saddle.

10. Feed

- A. Manual feed handle is right angle near the back of the machine. Feed rate is .036 (0.9 mm) per revolution of the feed handle.

Accessories (Optional)

- 1. 1.45" (36.8 mm) DIA Head Kit
- 2. 2.00" (50.8 mm) DIA Head Kit
- 3. Fixed Saddle Adapter Kit
- 4. Fixed Saddles, .250" (6.4 mm) to 2.000" (50.8 mm)
- 5. Adjustable Saddle Kit, Small DIA Range = .250" (6.4 mm) to .600" (15.2 mm)
- 6. Adjustable Saddle Kit, Large DIA Range = .600" (15.2 mm) to 2.000" (50.8 mm)
- 7. Adjustable Saddle Kit, Full Range DIA Range = .250" (6.4 mm) to 2.000" (50.8 mm)
- 8. Air Caddy, FRL

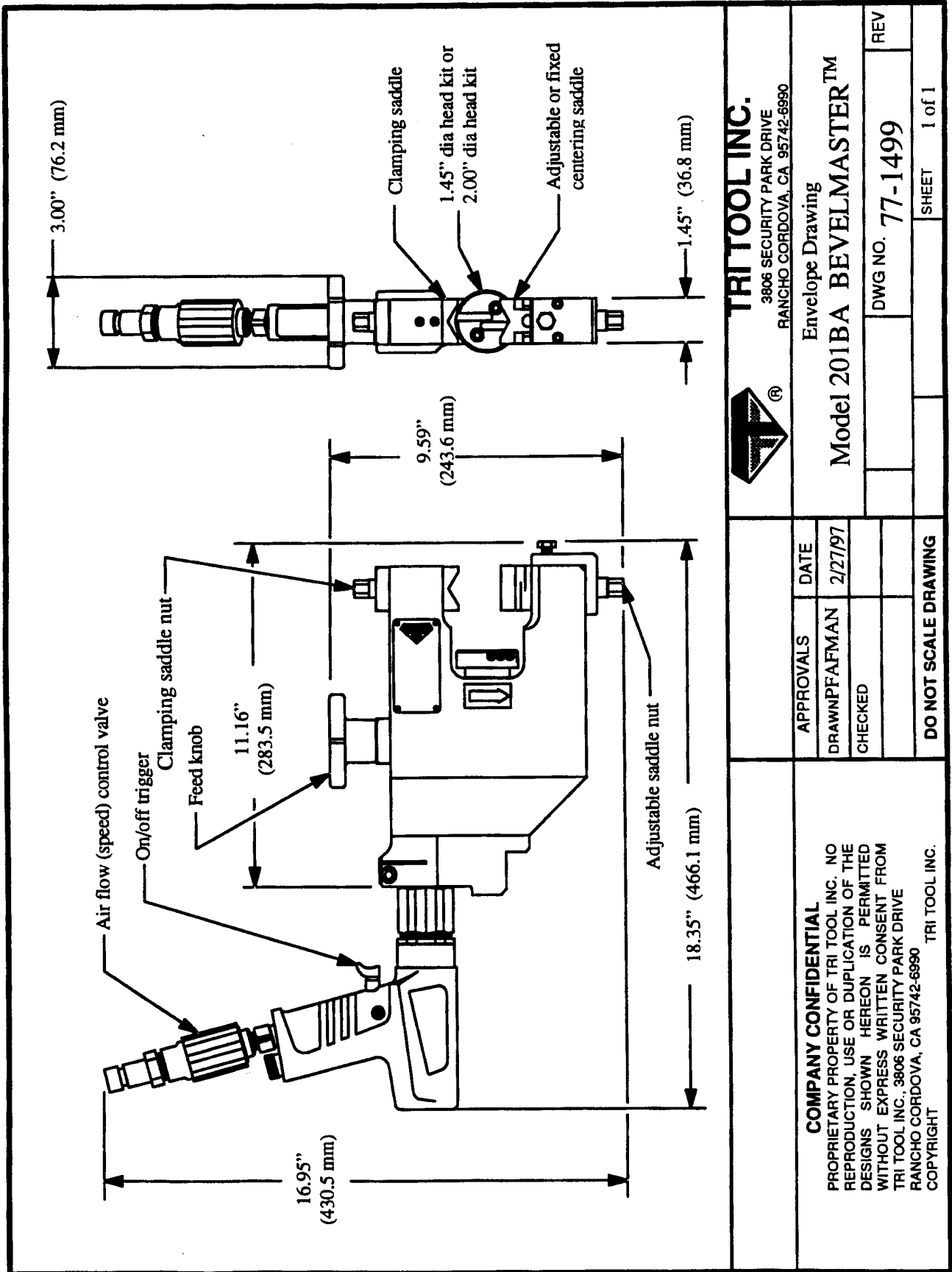
Note To The Customer

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 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.



**TRI TOOL INC.**  
 3806 SECURITY PARK DRIVE  
 RANCHO CORDOVA, CA 95742-6990

Envelope Drawing  
**Model 201BA BEVELMASTER™**

REV	DWG NO. 77-1499
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SHEET 1 of 1

APPROVALS	DATE
DRAWN: PFAFMAN	2/27/97
CHECKED	

DO NOT SCALE DRAWING

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