



TRI TOOL INC.

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TRI TOOL INC. TECHNICAL SPECIFICATION MODEL 208B BEVELMASTER® MARCH 2010

Model 208B BEVELMASTER®

The Model 208B BEVELMASTER® is a portable lathe ID mount machine tool for beveling, facing and counterboring 2" through 8" pipe. The tool is configured with an in line feed knob and pneumatic drive motor at a right angle to the lathe head.

The Model 208B BEVELMASTER® System comes complete with:

- Model 208B Subassembly
- Tool Holder Assembly
- Mandrel Assembly
- Air Motor Assembly
- Jaw Block Assembly Sets
- Shipping Kit
- Carrying Case
- Operator's Manual

Design and Operating Features

1. The lathe accepts its 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, at 56 lbs. (25.4 kg) approx., is lightweight and easily handled by one operator.

Specifications

1. Reference Envelope Drawing No.: 77-1711
2. Weight
 - A. 56 lbs. (25.4 kg) (Approx.)
3. Clearance and Dimensions
 - A. Maximum Rotating Head DIA 9.16" (232.7 mm)
 - B. Length (parallel to axis of pipe) 17.95" (456.0 mm)
 - C. Length Over Motor 28.13" (714.5 mm)
 - D. Maximum width 10.13" (257.3 mm)
4. Cutting Capacities
 - A. Basic pipe sizes
 - i. 1 1/2" schedules 5 and 10
 - ii. 2" schedule 5 through schedule 160
 - iii. 3" through 8" all schedules
 - B. Basic Tube Sizes
 - i. Up to .875" (22.2 mm) wall tubing with a maximum OD of 8.63" (219.2 mm) and a minimum ID of 1.63" (41.4 mm) may be beveled with standard mandrel.
 - C. Wall Thickness Capacity
 - i. Wall thickness of all standard pipe schedules [.875" (22.2 mm) maximum] in the range listed. Tubing with greater wall thickness may be handled provided the ID is greater than 1.63" (41.4 mm) and the OD is less than 8.63" (219.2 mm). Contact TRI TOOL Inc. for heavier wall procedures.
 - D. Counterboring Operations
 - i. The tool will counterbore pipe and tubing with an ID range of 2.00" (50.8 mm) to 8.33" (211.6 mm).
5. Material Cutting Capabilities
 - A. Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel and aluminum without limitations other than size and wall thickness as specified.

- 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. Mounting

- A. Manually actuated draw rod expands mandrel ramps and jaw blocks.

7. Drive System

A. Final Drive

- i. Gear Driven

B. Pneumatic Motor

- i. Free speed 310 RPM
- ii. Max H.P. speed 155 RPM

8. Power Requirements

- A. Pneumatic motor requires 85 cfm (40 L/s) air supply at 90 psi (621 kPa) for maximum horsepower delivery.

Note: The Air Supply must have a filter/regulator/lubricator (FRL) system to protect the warranty on the air motor.

9. Cutting Head Speeds

- A. Maximum cutting head speeds 62 RPM
- B. Cutting head speeds @ maximum H.P. 31 RPM
- C. Functional speed range 10-50 RPM
- D. RPM at 300 surface inches per minute
8.63" (219.2 mm)/11 RPM
1.69" (42.9 mm)/56 RPM

10. Feeds

- A. Manual-Feed handle is in line at the back of the machine. Feed rate is .083" (2.1 mm) per revolution of the feed handle.
- B. Maximum available feed travel is 2.88" (73.0 mm)

11. Speed Control

- A. On/off safety lever valve and twist-type air flow control valve.

Accessories (Optional)

1. Flange Facer Kit
2. Elbow Mandrel Kit
3. Pointer Kit, Elbow Mandrel
4. Mandrel Assembly, Small Elbow
5. Elbow Mandrel Squaring Plate Kit
6. Adjustable Pin Kit, Elbow Mandrel
7. Dial Indicator Kit
8. Miter Mandrel Kit
9. Sleeve Mandrel Kit
10. ID Tracking Module Kit
11. Air Caddy, FRL Spare parts and standard tool bits are available from stock.

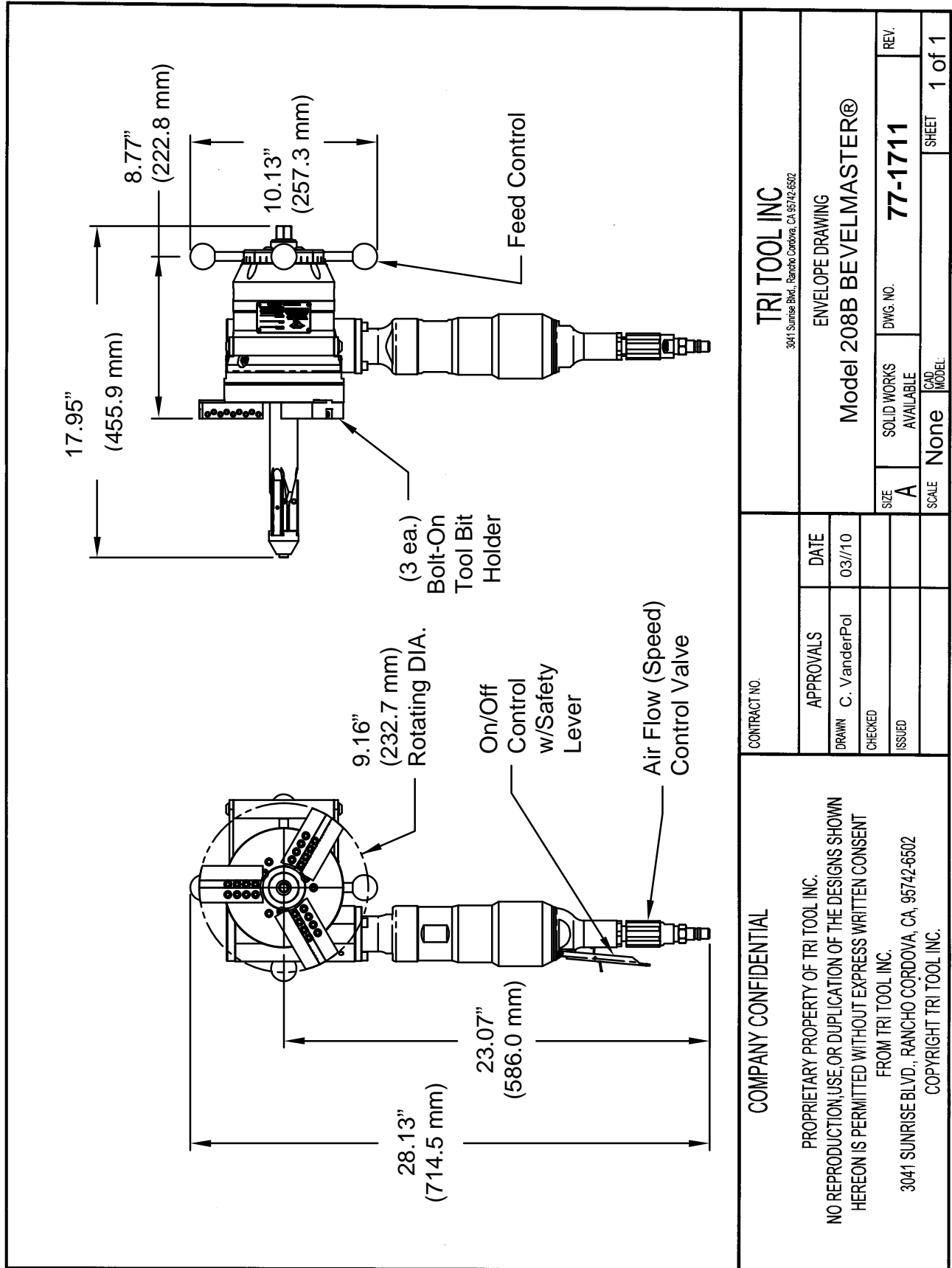
Note To The Customer

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.



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		<p>APPROVALS</p> <p>DRAWN C. VanderPol</p> <p>CHECKED</p> <p>ISSUED</p>	<p>DATE</p> <p>03/10</p>	<p>ENVELOPE DRAWING</p> <p>Model 208B BEVELMASTER®</p>		<p>SIZE</p> <p>A</p>	<p>SOLID WORKS AVAILABLE</p>
				<p>SCALE</p> <p>None</p>	<p>CAD MODEL</p>	<p>SHEET</p> <p>1 of 1</p>	