



TRI TOOL INC.

TRI TOOL INTERNATIONAL INC.

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TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL 224B BEVELMASTER™ SYSTEM
SEPTEMBER, 1999

MODEL 224B BEVELMASTER™ PORTABLE LATHE SYSTEM

The Model 224B BEVELMASTER™ is a portable I.D. mount machine tool for beveling , facing and/or counterboring 8” through 24” pipe. The tool is configured with an in line feed knob and pneumatic or hydraulic drive motor at a right angle to the lathe head.

The Model 224B BEVELMASTER™ System comes complete with:

A.	Model 224B Subassy	1 ea.
B.	Tool Holder Assy.	3 ea.
C.	Mandrel Assy.	1 ea.
D.	Mandrel Head Assy., 3 Jaw	1 ea.
E.	Lathe Lifting Frame Assy.	1 ea.
F.	Drive Motor Assy.	1 ea.
G.	Wrench Kit	1 ea.
H.	Operator's Manual	1 ea.

Optional Accessories:

Single Point Module Kit
I.D. Tracking Module Kit
Miter Mandrel Head Kit
Floor Stand

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 an adjustable lifting frame.

Specifications:

1. Reference Envelope drawing No. 77-1621
2. Pipe Cutting Capacities:
 - a. Basic pipe sizes:
All schedules of 8" through 24" pipe
 - b. Basic Tube Sizes:
Up to 2.34" (59.4 mm) wall tubing with a maximum O.D. of 24.00" (609.6mm) and a minimum I.D of 6.813" (173.0 mm) may be beveled with the standard mandrel.
 - c. Wall Thickness Capacity:
Wall thickness of all standard pipe schedules [2.34" (59.4 mm) maximum] in the range listed. Tubing or pipe with greater wall thickness may be handled provided the I.D. is greater than 6.813" (173.0mm) and the O.D. is less than 24.00" (609.6mm). Contact Tri Tool Inc. for heavier wall procedures.
 - d. Counterboring Operations:
The tool will counterbore pipe and tubing with an I.D. range 8.500" (216.0mm) to 24.00" (609.6mm).
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.	27.00" (685.8mm)
b. Length (parallel to axis of pipe)	39.75" (1009.65mm)
c. Available feed travel	5.38" (136.65mm)
5. Drive System:
 - a. Pneumatic Motor: Pneumatic drive air requirement @ 90psi is 95 cfm
 - b. Hydraulic Motor

(Requires separate hydraulic power supply. Ref: 765RVC technical specification) Unit requirements 20 GPM (1.3 L/s) at 1250 PSI (8619 kPa).
6. Cutting Head Speeds:

High Speed Socket:

- | | | |
|----|-----------------------------------|-------------|
| a. | Maximum cutting head speed | 18 rpm |
| b. | Cutting head speed @ maximum H.P. | 9 rpm |
| c. | Functional speed range | 6 to 18 rpm |

Low Speed Socket:

- | | | |
|----|-----------------------------------|------------|
| a. | Maximum cutting head speed | 9 rpm |
| b. | Cutting head speed @ maximum H.P. | 4.5 rpm |
| c. | Functional speed range | 3 to 9 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 .083" (2.1mm) per revolution of the feed handle.

9. Approximate weight:

Complete machine with mandrel, drive motor and lifting frame: 420 lbs. (190kg.)

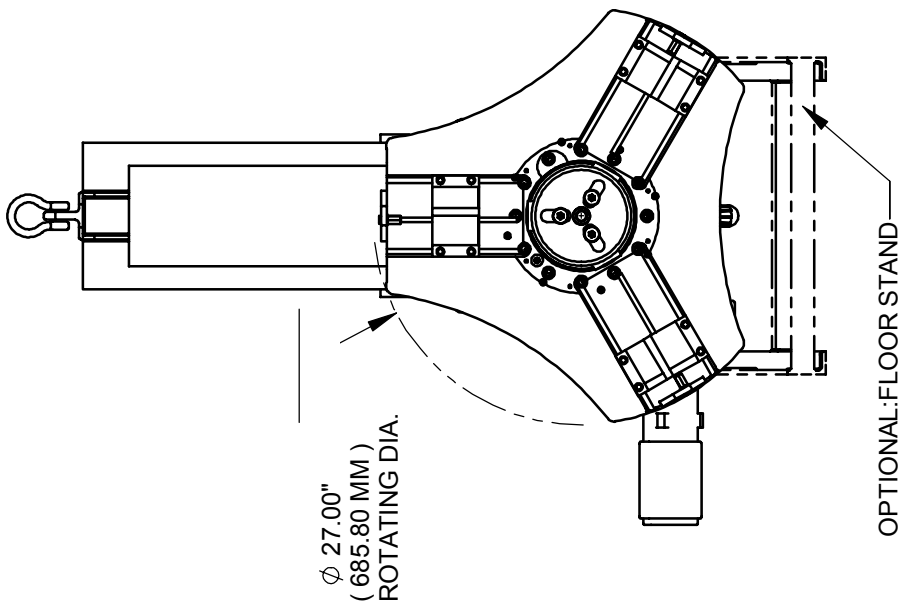
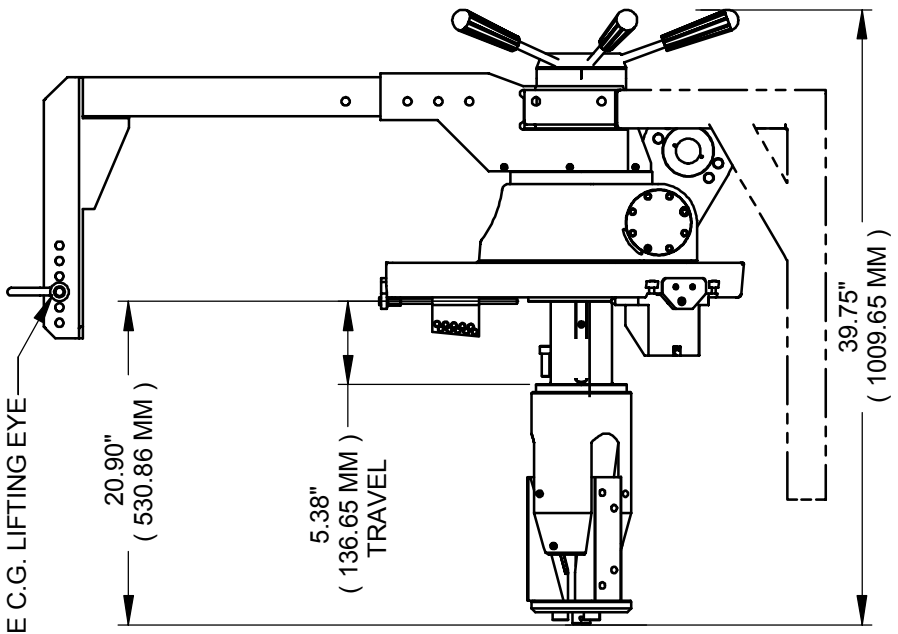
Spare parts and standard tool bits are available from stock.


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 3806 SECURITY PARK DRIVE, RANCHO CORDOVA, CA 95742		ENVELOPE DRAWING 224B BEVELMASTER		SIZE A SOLID WORKS AVAILABLE DWG. NO. 77-1621 REV.	SCALE 1 / 1 CAD MODEL: 224B ENV.SLDPRT SHEET 1 OF 1
CONTRACT NO. ER-8138		APPROVALS TIMBERLAKE DATE 6/23/99		CHECKED ISSUED	
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