



TRI TOOL INC.

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TRI TOOL INC.
TECHNICAL SPECIFICATION
MODEL 236B BEVELMASTER™ SYSTEM
MARCH 31, 2008

MODEL 236B BEVELMASTER™ PORTABLE LATHE SYSTEM

The Model 236B BEVELMASTER™ is a portable I.D. mount machine tool for beveling, facing and/or counterboring 12” through 36” pipe. The tool is configured with an in line feed knob and hydraulic drive motor at a right angle to the lathe head.

The Model 236B System comes complete with:

- Model 236B Sub-Assembly 1 ea.
- Tool Holder Assembly 3 ea.
- Mandrel Assembly 1 ea.
- Mandrel Head Assembly, 5 Jaw 1 ea.
- Jaw Block Assembly Sets 5 ea.
- Lathe Stand Assembly 1 ea.
- Hydraulic Motor Assembly 1 ea.
- Wrench Kit 1 ea.
- Operator’s Manual 1 ea.

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.

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4. The lathe is provided with a stand and hoist ring.

Specifications

1. Reference Envelope Drawing No. 77-1686.
2. Pipe Cutting Capacities
 - A. Basic Pipe Sizes
 - i. 12" Pipe
 - a. Schedule 5 through 60.
 - ii. 14" Pipe
 - a. Schedules 5 through 140.
 - iii. 16" through 36" Pipe
 - a. All Schedules
 - B. Basic Tube Sizes
 - i. Up to 1.312" (33.3 mm) wall tubing with a maximum O.D. of 36.00" (914.4 mm) and a minimum I.D. of 11.43" (290.4 mm) may be beveled with the standard mandrel.
 - C. Wall Thickness Capacity
 - i. Wall thickness of all standard pipe schedules, 1.312" (33.3 mm) maximum, in the range listed. Tubing or pipe with greater wall thickness may be handled provided the I.D. is greater than 11.43" (290.4 mm) and the O.D. is less than 36.00" (914.4 mm). Contact Tri Tool for heavier wall procedures.
3. Counterboring Operations
 - A. The Tool will counterbore pipe and tubing with an I.D. range of 11.43" (290.4 mm) to 35.00" (889.0 mm).
4. 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 the above paragraphs.

- 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.

5. Clearances and Dimensions

A. Maximum Rotating Head DIA

- i. 40.00" (1016.0 mm)

B. Length (parallel to axis of pipe)

- i. 48.16" (1223.3 mm)

C. Available Feed Travel

- i. 5.00 (127.0 mm)

6. Drive System

A. Hydraulic Motor (Single or Dual)

- i. Requires separate hydraulic power supply.
- ii. Ref. 765RVC technical specification.

B. Unit Requirements

- i. 20 GPM (1.3 L/s) at 1250 PSI (8619 kPa)

C. Pneumatic Motor (Dual)

- i. Optional

7. Cutting Head Speeds

A. Maximum Cutting Head Speed

- i. 5 RPM

B. Cutting Head Speed @ Maximum H.P.

- i. 3 RPM

C. Functional Speed Range

- i. 3 to 5 RPM
8. Mounting
- A. Manually actuated draw rod expands mandrel ramps and jaw blocks.
9. Feed
- A. Manual-Feed handle is in line at the back of the machine. Feed rate is .033" (.84 mm) per revolution of the feed handle.
10. Approximate weight
- A. Complete Machine with Mandrel, Drive Motor and Stand
 - i. 1200 lbs. (554 kg)

Accessories

- 1. Single Point Module Kit
- 2. I.D. Tracking Module Kit
- 3. Miter Mandrel Kit
- 4. Jaw Block Extension Kit
- 5. Miter Mandrel Extension Kit

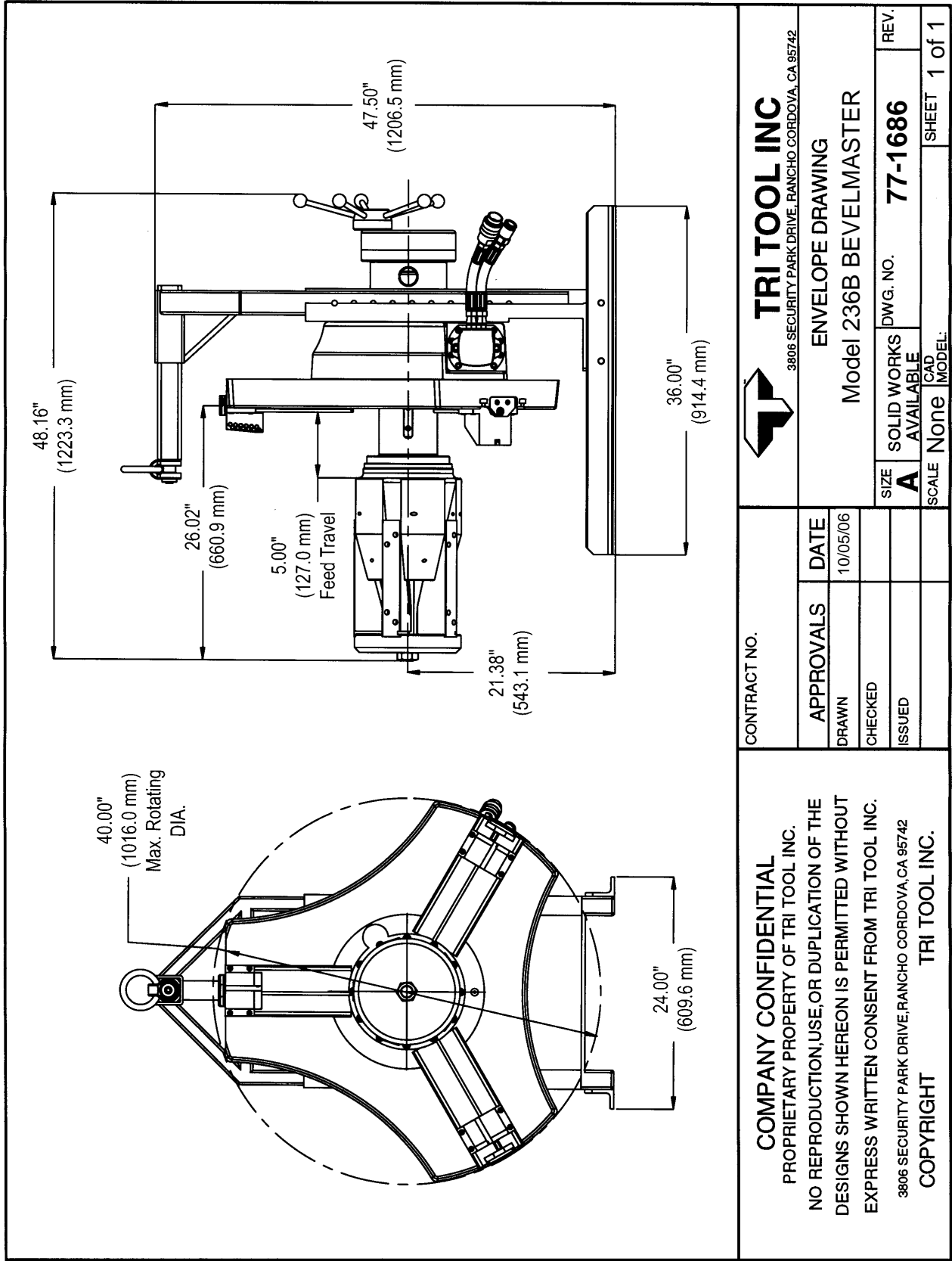
Note To The Customer


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		ENVELOPE DRAWING Model 236B BEVELMASTER		REV.
		SIZE A	DWG. NO. 77-1686	SHEET 1 of 1
CONTRACT NO.		APPROVALS	DATE	SCALE None
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