



TECHNICAL SPECIFICATION MODEL 214B BEVELMASTER®

The Model 214B BEVELMASTER™ is a portable I.D. mount machine tool for beveling, facing and counterboring 4” through 14” 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 214B BEVELMASTER® System comes complete with:

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|-----------------------------------|-------|
| • Model 214B Sub-Assembly | 1 ea. |
| • Tool Holder Assembly (aluminum) | 2 ea. |
| • Tool Holder Assembly (steel) | 1 ea. |
| • Mandrel Assembly | 1 ea. |
| • Air Motor Assembly | 1 ea. |
| • Wrench Kit | 1 ea. |
| • Carrying Case | 1 ea. |
| • Operator’s Manual | 1 ea. |

Accessories (Optional)

- Flange Facer Kit
- Elbow Mandrel Kit
- Elbow Mandrel Pointer Kit
- Dial Indicator Kit
- Miter Mandrel Kit
- Sleeve Mandrel Kit
- I.D. Tracking Module Kit
- Air Caddy, FRL

Design and Operating Features

- The lathe accepts its own torque through the mandrel.
- The expanding mandrel provides fast, accurate self-centering and alignment.
- All tools needed for operation (less tool bits) are provided with the system.
- The lathe, provided with a convenient handle, is lightweight at less than 80 lbs. (36.3 Kg.) and easily handled by one operator.

Specifications

Pipe Cutting Capacities

Basic Pipe Sizes

- 4" Pipe - schedule 5 through 160
- 5" through 14" pipe - All schedules

Basic Tube Sizes

Up to 1.32" (33.4 mm) wall tubing with a maximum O.D. of 14.00" (355.6 mm) and a minimum I.D. of 3.44" (87.4 mm) may be beveled with standard mandrel.

Wall Thickness Capacity (Limitations)

Wall thickness of all standard pipe schedules 1.32" (33.4 mm) maximum in the range listed. Tubing with greater wall thickness may be handled provided the I.D. is greater than 3.44" (87.4 mm) and the O.D. is less than 14.00" (355.6 mm). Contact Tri Tool for heavier wall procedures.

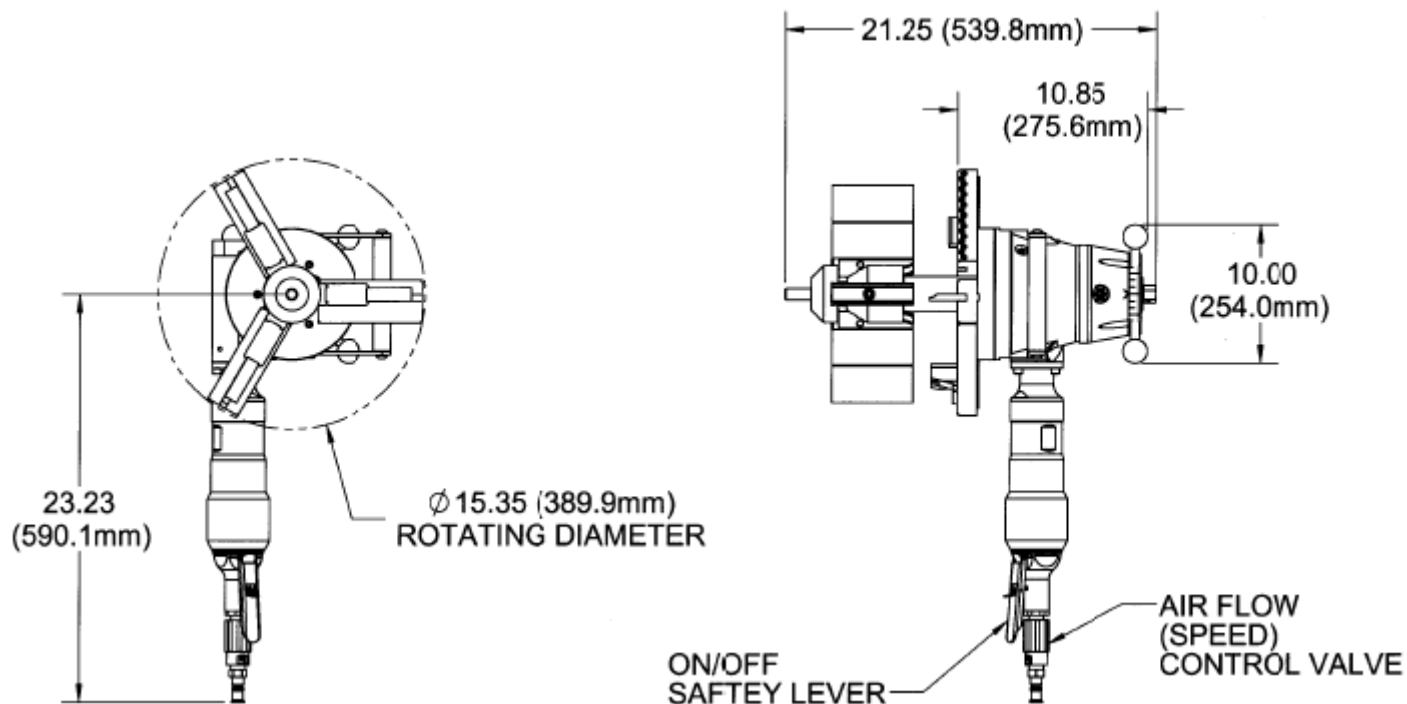
Counterboring Operations

The tool will counterbore pipe and tubing with an I.D. range of 3.44" (87.4 mm) to 13.75" (330.2 mm).

Material Cutting Capabilities

- 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.
- 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.

Clearance and Dimensions
Reference Drawing No. 77-1717



Drive System

Final Drive

Gear Driven

Pneumatic Motor

Free Speed 310 RPM

Maximum H.P. Speed 155 RPM

110V and 220V Electric Drive and Hydraulic Motor Drive are also available.

Power Supply

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

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

Cutting Head Speeds

Maximum cutting head speed 20 RPM

Cutting head speed @ maximum H.P. 10 RPM

Functional speed range 5 -22 RPM

RPM at 200 surface inches per minute

14.00" (355.6 mm) diameter

5 RPM

4.00" (101.6 mm) diameter

16 RPM

Speed Control

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

Mounting

Manually actuated draw rod expands mandrel ramps and jaw blocks.

Feed

Manual-Feed handle is in-line at the back of the machine.

Feed rate .083" (2.1 mm) per revolution of the feed handle.

Maximum available feed travel 2.00" (50.8 mm).

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.



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