

TECHNICAL SPECIFICATION MODEL 208B BEVELMASTER™ AIR

The Model 208B BEVELMASTER™ Air is a portable ID mounting weld end preparation 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:

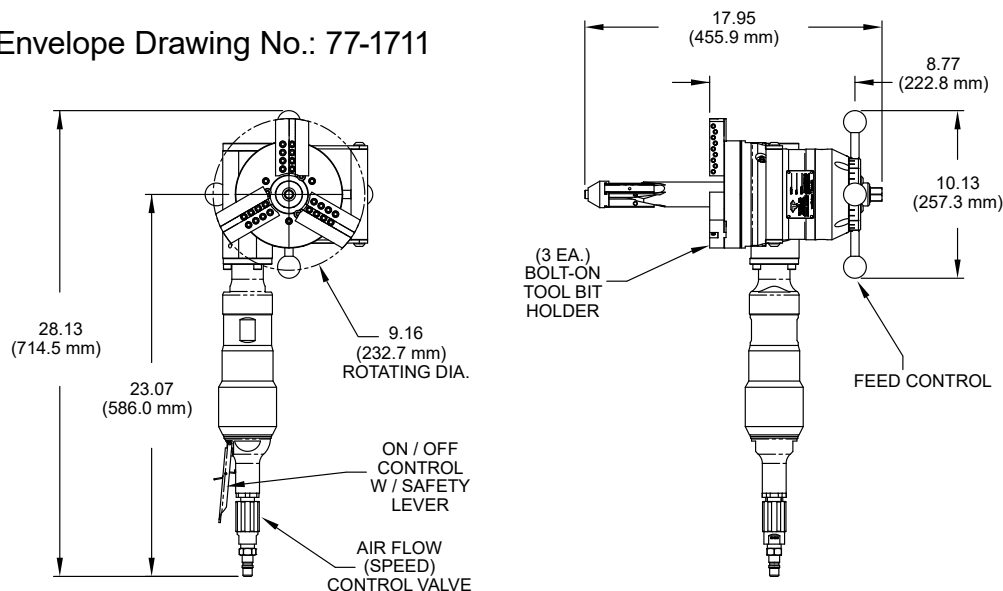
- Model 208B Sub-Assembly
- Tool Holder Assembly
- Mandrel Assembly
- Air Motor Assembly
- Jaw Block Assembly Sets
- Shipping Kit
- Carrying Case
- Operator's Manual

Design and Operating Features

- The lathe accepts its own torque through the mandrel.
- The expanding mandrel provides fast, accurate self-centering and alignment.
- All wrenches needed for operation (less tool bits) are provided with the system.
- The lathe, at 56 lbs. (25.4 kg) approx., is lightweight and easily handled by one operator.

Specifications

Reference Envelope Drawing No.: 77-1711



Weight:

56 lbs. (25.4 kg) approximate

Clearance and Dimensions

Maximum Rotating Head DIA	9.16" (232.7 mm)
Length (parallel to axis of pipe)	17.95" (456.0 mm)
Length Over Motor	28.13" (714.5 mm)
Maximum width	10.13" (257.3 mm)

Cutting Capacities

Basic Pipe Sizes

1 1/2" Pipe	Schedules 5 and 10
2" Pipe	Schedule 5 through Schedule 160
3" through 8" Pipe	All Schedules

Basic Tube Sizes

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.

Wall Thickness Capacity

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 Technologies for heavier wall procedures.

Counterboring Operations

The tool will counterbore pipe and tubing with an ID range of 2.00" (50.8 mm) to 8.33" (211.6 mm).

Material Cutting Capabilities

Mild steels, chrome steels (Rc 35 max.), stainless steel, copper-nickel and aluminum without limitations other than size and wall thickness as specified.

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 Technologies' Engineering Department for details.

Mounting

Manually actuated draw rod expands mandrel ramps and jaw blocks.

Drive System

Final Drive	Gear Driven
Pneumatic Motor	
Free speed	310 RPM
Max H.P. speed	155 RPM

Power Requirements

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.

Cutting Head Speeds

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

Feeds

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.

Maximum available feed travel is 2.00" (50.8 mm)

Speed Control

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

Accessories

- Flange Facer Kit
- Elbow Mandrel Kit
- Pointer Kit, Elbow Mandrel
- Mandrel Assembly, Small Elbow
- Elbow Mandrel Squaring Plate Kit
- Adjustable Pin Kit, Elbow Mandrel
- Dial Indicator Kit
- Miter Mandrel Kit
- Sleeve Mandrel Kit (*recommended torque for Mandrel Feed Nut is 25 ft-lbs*)
- ID Tracking Module Kit
- 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 Technologies 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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