



Updated 5/12/2025

TECHNICAL SPECIFICATION MODEL 214B (AIR) BEVELMASTER™

The Model 214B BEVELMASTER™ is a portable ID mount machine tool for beveling, facing and counterboring 4" through 14" pipe. The tool is configured with an inline feed knob and pneumatic drive motor at a right angle to the lathe head.

The Model 214B (Air) SEVERMASTER™ comes complete with:

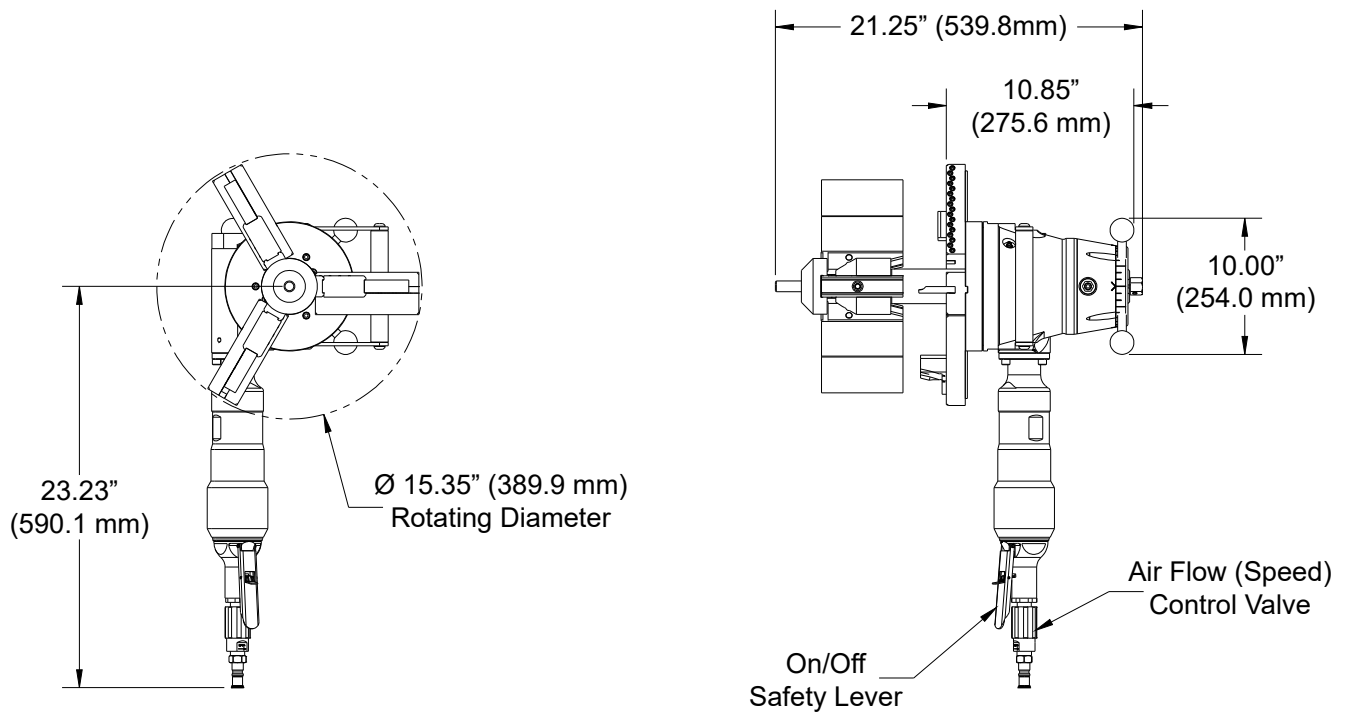
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|-----------------------------------|---|
| • Model 214B Sub-Assembly | 1 |
| • Tool Holder Assembly (aluminum) | 2 |
| • Tool Holder Assembly (steel) | 1 |
| • Mandrel Assembly | 1 |
| • Air Motor Assembly | 1 |
| • Wrench Kit | 1 |
| • Carrying Case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

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

Reference Envelope Drawing No. 77-1717



Clearance and Dimensions

Weight

80 lbs. (36.3 kg)

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 ID 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 ID is greater than 3.44" (87.4 mm) and the OD is less than 14.00" (355.6 mm). Contact Tri Tool Technologies for heavier wall procedures.

Counterboring Operations

The tool will counterbore pipe and tubing with an ID 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.

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 for more information.

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

Drive System

Final Drive	Gear Driven
Pneumatic Motor	
Free Speed	310 RPM
Maximum H.P. Speed	155 RPM

115V and 230V 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.

Speed Control

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

Feed

Manual Feed handle is inline 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).

Mounting

Manually actuated draw rod expands mandrel ramps and jaw blocks.

Accessories

- Flange Facer Kit
- Elbow Mandrel Kit
- Elbow Mandrel Pointer Kit
- 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

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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