

TECHNICAL SPECIFICATION MODEL 216B – BEVELMASTER™ SYSTEM

The Model 216B BEVELMASTER™ is a portable ID (inner diameter) mount lathe machine tool for beveling, facing, and counterboring 6" thru 16" pipe. Single Point facing and beveling up to 32" pipe is achievable with the optional Single Point module accessory. The tool is configured with an inline feed knob and right angle pneumatic or inline hydraulic drive motor. A two-speed gearbox allows for high torque form tool machining and high speed single point machining (Single Point accessory sold separately).

The Model 216B BEVELMASTER™ System comes complete with:

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|---|------|
| • Model 216B Subassembly | 1 ea |
| • Tool Holder Beveling and Facing | 2 ea |
| • Tool Holder Counterboring | 1 ea |
| • Mandrel Assembly | 1 ea |
| • Air Motor or Hydraulic Motor Assembly | 1 ea |
| • Lathe Stand | 1 ea |
| • Wrench Kit | 1 ea |
| • Operator's Manual | 1 ea |

Design and Operation 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 (consumable cutting tool bits sold separately) are provided with the system.
- The lathe is provided with a lifting point and hoist ring.
- No external pinch points for safe pipe machining.

Specifications

Reference Drawings for 77-1829 follow at end of document.

Weight

Machine without mandrel, tool modules, or motor	119 lbs. (54.0 kg)
3-Jaw Mandrel	51 lbs. (23.1 kg)
Tool Modules each	12 lbs. (5.4 kg)
Motor	
Air	17 lbs. (7.7 kg)
Hydraulic	31 lbs. (14.1 kg)

Clearance and Dimensions Base Machine

Maximum rotating head diameter	18.44" (468.5 mm)
Length over motor (Pneumatic)	20.91" (531.1 mm)
Length parallel to axis of pipe (Pneumatic)	29.67" (753.6 mm)

Pipe Cutting Capacities

Basic Pipe Sizes

6"	Schedule 5 through 160
8" through 14"	All Schedules
16"	Schedules 10 through 160

Basic Tube Sizes

Up to 1.50", (38.1 mm) wall tubing with a maximum O.D. of 16.00" (406.4 mm) and a minimum I.D. of 5.18" (131.5 mm) may be beveled with a standard 3-Jaw mandrel.

Wall Thickness Capacities

Wall thickness of all standard pipe schedules 1.50" (38.1 mm) maximum in the range listed. Tubing with greater wall thickness may be handled provided the I.D. is greater than 5.18" (131.5 mm) and the O.D. is less than 16.00" (406.4 mm). Contact Tri Tool Technologies for heavier wall procedures.

Counterboring Capacities

The tool will counterbore pipe and tubing with an ID range of 6.00" (152.4 mm) to 16.00" (406.4 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

Air motor up to 30 rpm

Requires filtered, regulated and lubricated air supply of 90 psi (6.2 bar) @
95 SCFM (2.7 m³/min)

Hydraulic motor up to 55 rpm

Requires Model 765RVC HPU or equivalent. 20 gpm (1.3 l/s) @ 1250 psi (86.2 bar)

Feed

Inline Feed handle is manually operated at the back of the machine

Maximum available feed travel 3.00" (76.2 mm)

Feed Rate

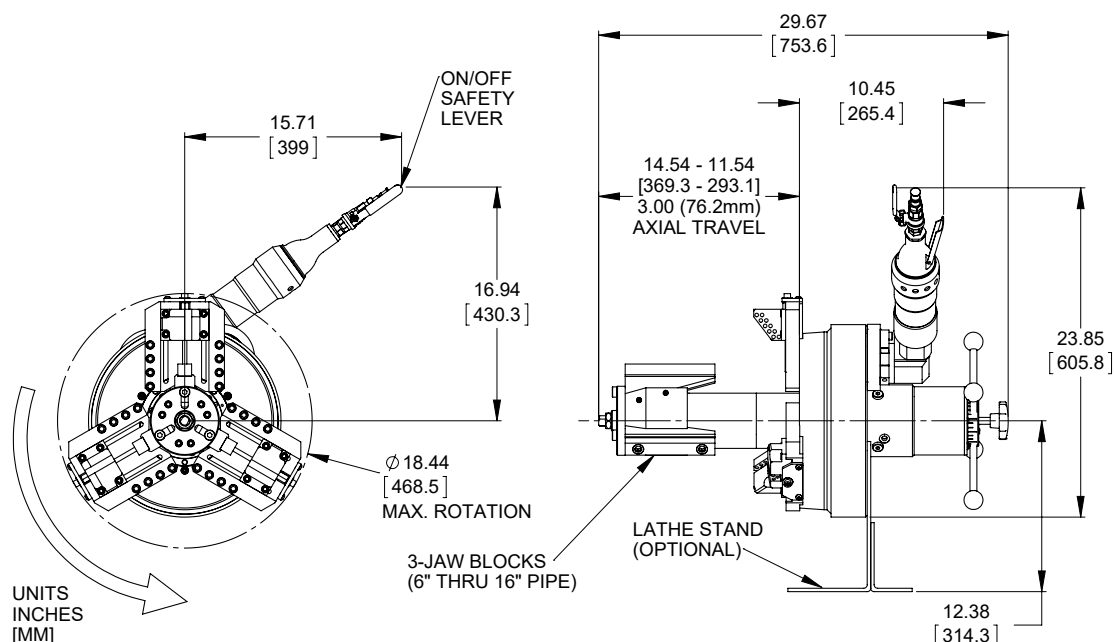
0.83" (2.1 mm) per revolution of the feed handle (manually operated)

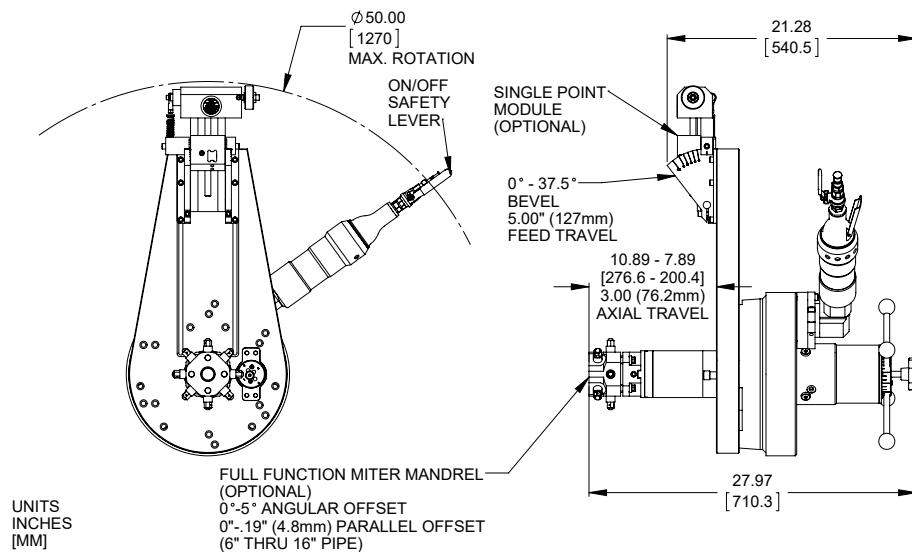
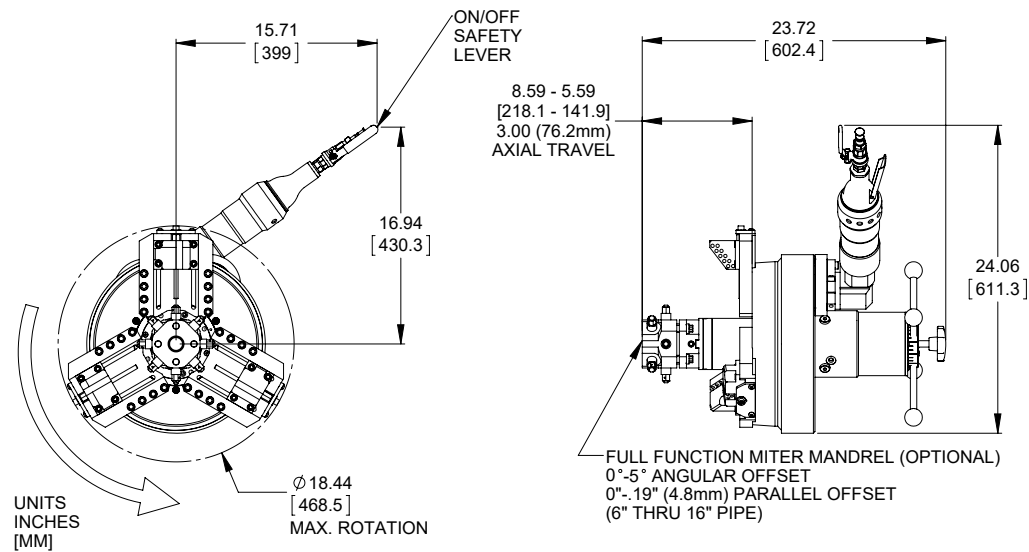
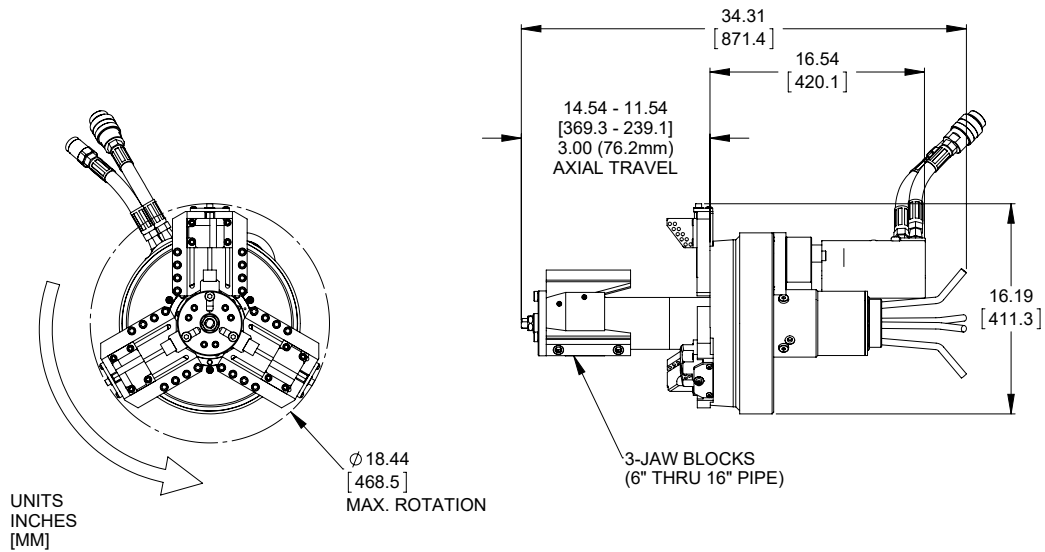
Mounting

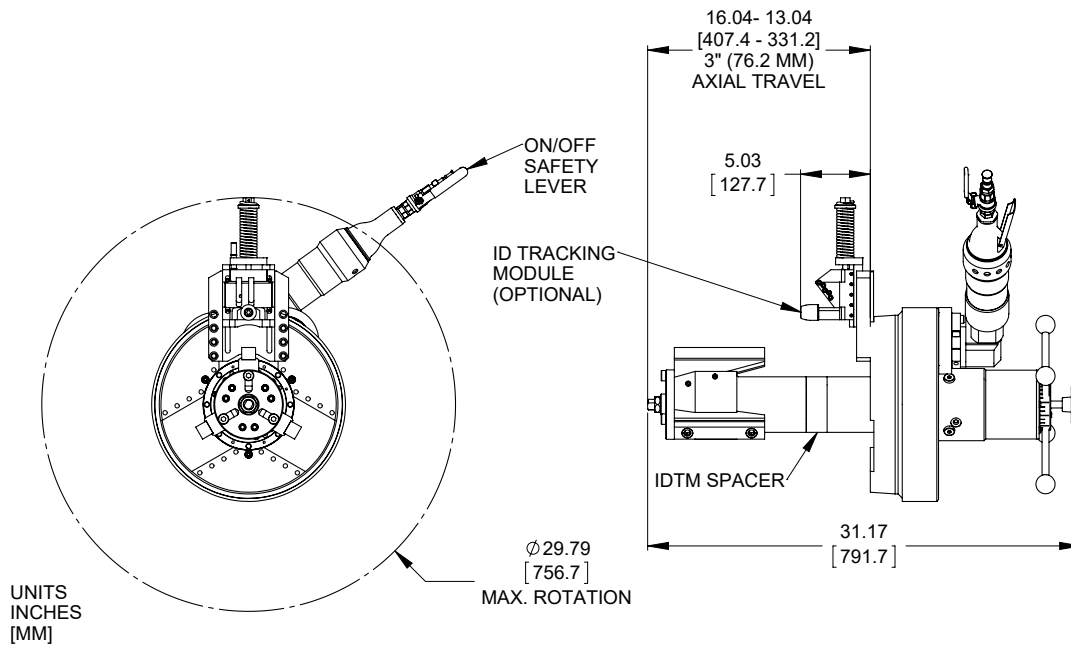
The manually operated draw rod expands the mandrel ramps and the jaw blocks to provide self-centering and alignment of the lathe to the workpiece.

Accessories

- Single Point Module Kit (SP)
- I.D. Tracking Module Kit (IDTM)
- Miter Mandrel Kit (MM)
- 3-Jaw Mandrel Extension Kit (16.97 thru 28.95" I.D.)
- Steel Storage and Shipping box with hinged lockable lid







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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