Updated 7/24/2024

TECHNICAL SPECIFICATION
MODEL 236B BEVELMASTER™ SYSTEM

The Model 204BE - 115V BEVELMASTER™ is a portable ID 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 BEVELMASTER™ System comes complete with:

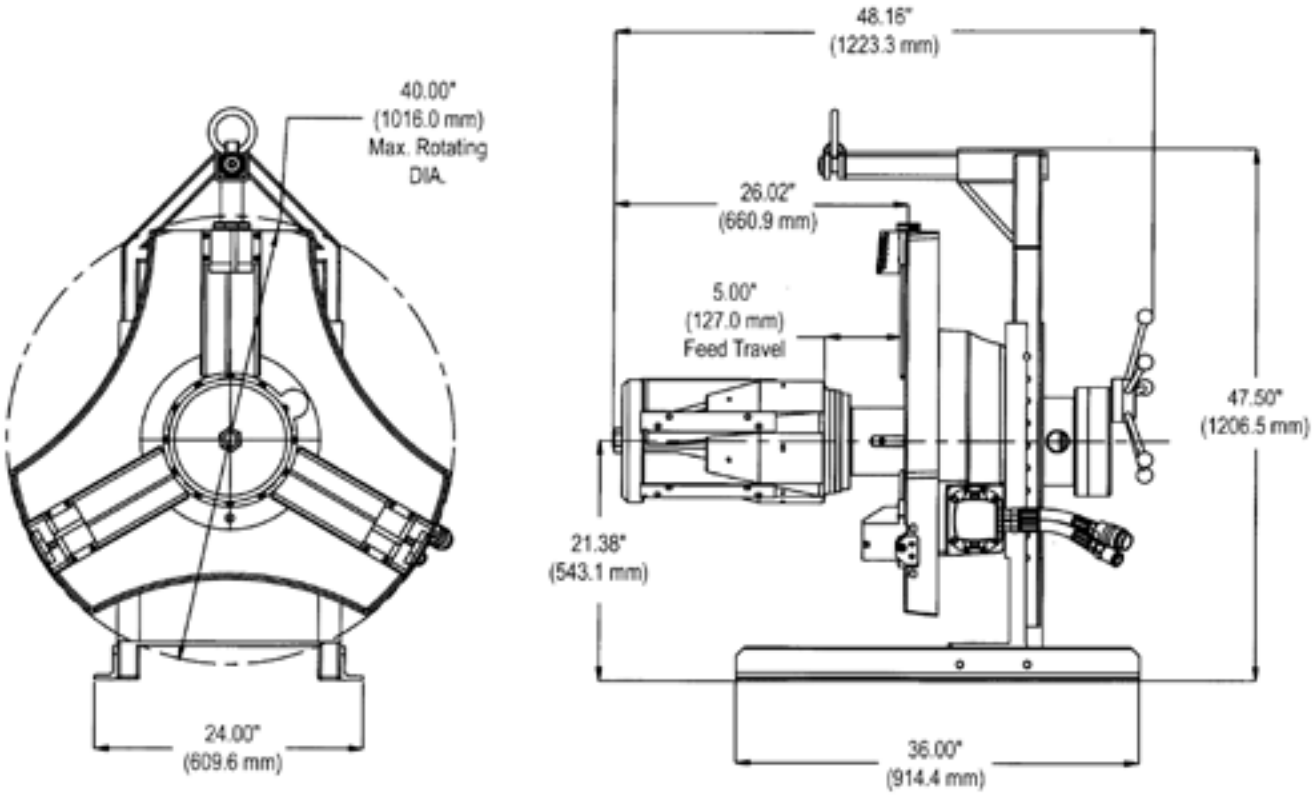
• Model 236B Sub-Assembly	1 ea.
• Tool Holder Assembly	3 ea.
• Mandrel Assembly	1 ea.
• Mandrel Head Assembly, 5 Jaw	1 ea.
• Jaw Block Assembly Sets	5 ea.
• Lathe Stand Assembly	1 ea.
• Hydraulic Motor Assembly	1 ea.
• Wrench Kit	1 ea.
• Operator’s Manual	1 ea.

Design and Operating Features

- 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 is provided with a stand and hoist ring.

Specifications

Reference Envelope Drawing No. 77-1686.



Pipe Cutting Capacities

Basic Pipe Sizes

12” Pipe	Schedule 5 through 60.
14” Pipe	Schedules 5 through 140.
16” through 36” Pipe	All Schedules

Basic Tube Sizes

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.

Wall Thickness Capacity

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 Technologies for heavier wall procedures.

Counterboring Operations

The Tool will counterbore pipe and tubing with an I.D. range of 11.43” (290.4 mm) to 35.00” (889.0 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 the above paragraphs.

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 Technologies' Engineering Department for details.

Clearances and Dimensions

Maximum Rotating Head DIA	40.00" (1016.0 mm)
Length (parallel to axis of pipe)	48.16" (1223.3 mm)
Available Feed Travel	5.00 (127.0 mm)

Drive System

Hydraulic Motor (Single or Dual)

Requires separate hydraulic power supply (Ref. 765RVC technical specification).

Unit Requirements

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

Pneumatic Motor (Dual)

Optional

Cutting Head Speeds

Maximum Cutting Head Speed	5 RPM
Cutting Head Speed @ Maximum H.P.	3 RPM
Functional Speed Range	3 to 5 RPM

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 is .033" (.84 mm) per revolution of the feed handle.

Approximate Weight

Complete Machine with Mandrel, Drive Motor and Stand 1200 lbs. (554 kg)

Accessories

- Single Point Module Kit
- ID Tracking Module Kit
- Miter Mandrel Kit
- Jaw Block Extension Kit
- 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 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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@tritooltechnologies
@tritooltech
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SCAN OR CLICK

3041 Sunrise Blvd
Rancho Cordova, CA 95742
+916-288-6100
+1-800-345-5015
Fax 916-288-6160