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 with:

- 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
- 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 Envelope Drawing No. 77-1829 is after the specifications

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 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 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
.083" (2.1 mm) per revolution of the feed handle (manually operated)

Mounting
The manually operated draw rod expands the mandrel ramps and 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)
- Lathe Stand
- Steel Storage and Shipping box with hinged lockable lid

Note to the Customer:
Spare Parts and Standard Tool Bits are available from Tri Tool Inc. Engineering design services for custom tool bits and special function modifications are available. All Tri Tool Inc. 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 are supplied on request and with the tools.
TRI TOOL INC.

ON/OFF SAFETY LEVER

SINGLE POINT MODULE (OPTIONAL)

0° - 37.5° BEVEL
5.00" (127mm) FEED TRAVEL

FULL FUNCTION MITER MANDREL (OPTIONAL)
0°-5° ANGULAR OFFSET
0°-.19" (4.8mm) PARALLEL OFFSET
(6" THRU 16" PIPE)

UNITs
INCHES [MM]

21.28 [540.5]
10.89 - 7.89 [276.6 - 200.4]
3.00 (76.2mm) AXIAL TRAVEL
27.97 [710.3]

ENVELOPE DRAWING

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DRAWN
J.GEISZLER 4/20/16

DRAWING NUMBER
77-1829

216B MITER MANDREL
SINGLE POINT AIR MOTOR

TRI TOOL INC.
3041 SUNRISE BLVD, RANCHO CORDOVA, CA 95742
WWW.TRITOOL.COM (888) TRITOOL