Updated 7/24/2024

TECHNICAL SPECIFICATION
MODEL 224B BEVELMASTER™ SYSTEM

The Model 224B BEVELMASTER™ is a portable ID mount machine tool for beveling, facing and/or counterboring 8” through 24” pipe. The tool is configured with an in-line feed knob and pneumatic or hydraulic drive motor at a right angle to the lathe head.

The Model 224B BEVELMASTER™ System comes complete with:

• Model 224B Sub-Assembly	1 ea
• Tool Holder Assembly	3 ea
• Mandrel Assembly	1 ea
• Mandrel Head Assembly, 3 Jaw	1 ea
• Lathe Lifting Frame Assembly	1 ea
• Drive Motor Assembly	1 ea
• Wrench Kit	1 ea
• Operator’s Manual	1 ea

Optional Accessories

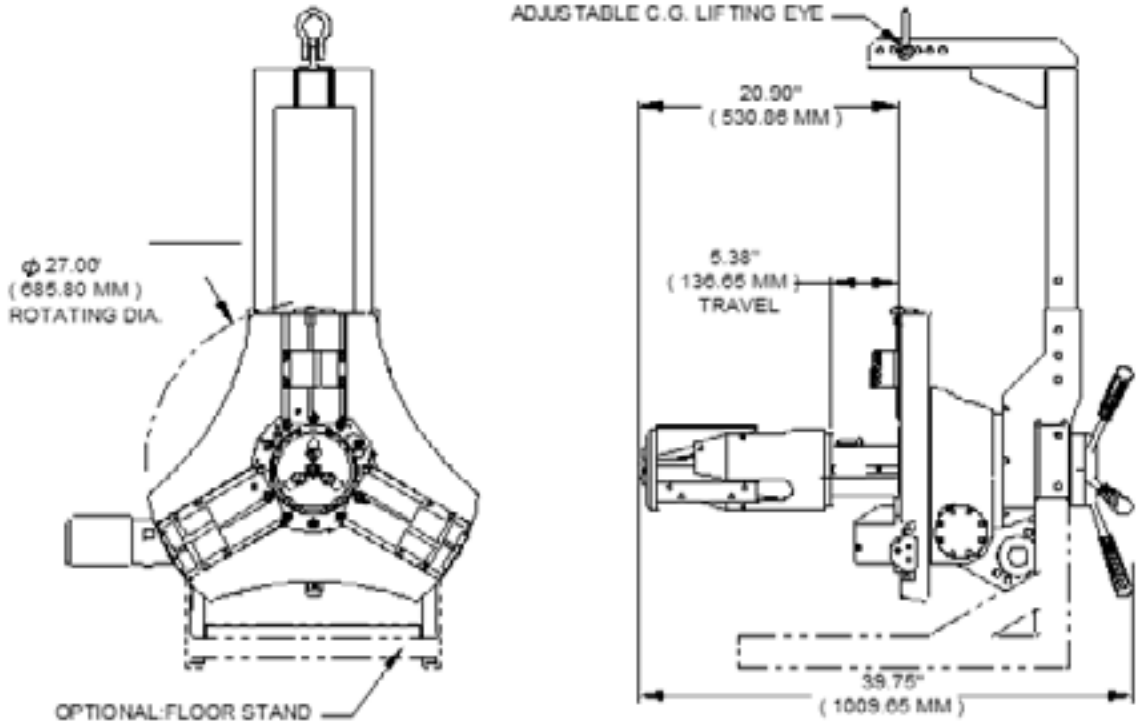
- Single Point Module Kit
- ID Tracking Module Kit
- Miter Mandrel Head Kit
- Floor Stand

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 an adjustable lifting frame.

Specifications

Reference Envelope Drawing No.: 77-1621



Pipe Cutting Capacities

Basic Pipe Sizes — All schedules of 8” through 24” pipe

Basic Tube Sizes

Up to 2.34” (59.4 mm) wall tubing with a maximum O.D. of 24.00” (609.6mm) and a minimum I.D of 6.813” (173.0 mm) may be beveled with the standard mandrel.

Wall Thickness Capacity (Limitations)

Wall thickness of all standard pipe schedules [2.34” (59.4 mm) maximum] in the range listed. Tubing or pipe with greater wall thickness may be handled provided the I.D. is greater than 6.813” (173.0mm) and the O.D. is less than 24.00” (609.6mm). Contact Tri Tool Technologies for heavier wall procedures.

Counterboring Operations

The tool will counterbore pipe and tubing with an I.D. range 8.500” (216.0mm) to 24.00” (609.6mm).

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 paragraph #2.

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.

Weight

Complete machine with mandrel, drive motor and lifting frame: 420 lbs. (190kg.)

Drive System

Pneumatic Motor: Pneumatic drive air requirement @ 90psi is 95 cfm

Hydraulic Motor: Requires separate hydraulic power supply. Ref: 765RVC technical specification) Unit requirements 20 GPM (1.3 L/s) at 1250 PSI (8619 kPa.

Cutting Head Speeds

High Speed Socket:	
Maximum cutting head speed	18 rpm
Cutting head speed @ maximum H.P.	9 rpm
Functional speed range	6 to 18 rpm
Low Speed Socket:	
Maximum cutting head speed	9 rpm
Cutting head speed @ maximum H.P.	4.5 rpm
Functional speed range	3 to 9 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 .083” (2.1mm) per revolution of the feed handle.

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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