

ID CLAMPING TOOLS

IMPORTANT! Read how to properly lock on page 7

MiniMill 200

The MiniMill-200 is a rugged, fast, portable weld end preparation lathe for various tubes including stainless steel and other high chromium alloys. A standard machine comes complete with a 60 mm head, a locking system and includes all jaw sets to cover sizes of 20 to 44 mm (0.787" to 1.732")



Facing, bevelling tubes quickly and safely.

KRAIS Tube Expander



Optional
Lever Feed

Optional
Speed Reducer

Optional Fast
Clamping System

Optional
Ratched Feed

STANDARD WORKING RANGE			MOTOR PARAMETERS		
APPLICATION RANGE	LOCKING RANGE (ID)	FEED STROKE	FREE SPEED	POWER	TORQUE
12,5- 57,0 mm	20,0 - 44,0 mm	20 mm	200 Rpm	1,3 Hp	72 Nm
0,492 - 2,250"	0,787 - 1,732"	0,787"			53 Ft.Lbs

RECOMMENDED FOR: Tube facing ■ Tube bevelling ■ Weld removal

Air use:	55 cfm	1,3 m ³ /min	Body width:	2,32"	59 mm	Body height:	13,1"	335 mm	Body weight:	11,4 Lbs	5,2 kg
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EXAMPLE TOOL APPLICATION



Standard locking system with handle feed makes quick work of trimming back tubes.



Completed strength weld removal.

OPTIONAL SPECIALIZED CUTTER HEADS



OBMH
Outside bevelling of both tubes and pipes. Sized per tube or pipe diameter and angle of required weld bevel.

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SWROTC
Seal weld removal head over tube circumference prior to re-welding the damaged joint without removing the tube.

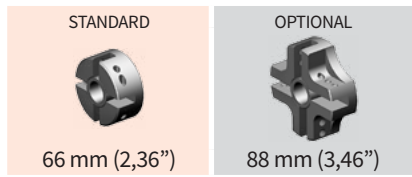
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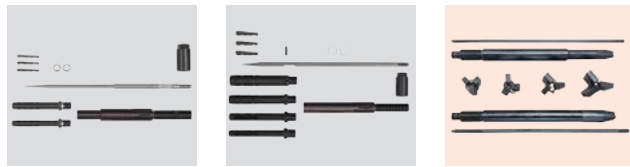
STWRMH
Custom designed head dedicated for strength weld removal. Heads are sized per tube diameter.

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UNIVERSAL CUTTER HEADS



AVAILABLE SHAFTS



MICROSHAFT

A system with interchangeable guide shafts. A complete set covers 9,0 to 15,0 mm inside diameter.

MINISHAFT

A system with interchangeable guide shafts. A complete set covers 12,7 to 25 mm inside diameter.

SHAFTS 20/25

Redesigned heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force. The jaws are self-align.

SAV-500 SPEED ADJUSTMENT VALVE



Perfect solution for all our pneumatic driven bevelling machines for adjusting cutting speed to suit to the machined tube diameter.

LOCKING RANGES WITH STANDARD SHAFT20 JAWS

RANGE [MM]		RANGE [INCH]		JAWS	EXT.	SPRING	
MIN	MAX	MIN	MAX			NUMBER	QTY.
20	24	0,787	0,945	NS-0	-	SP-19	1
24	28	0,945	1,102	NS-1	-	SP-19	1
28	33	1,102	1,299	NS-2	-	SP-19	1
33	38	1,299	1,496	NS-3	-	SP-20	2
38	43	1,496	1,693	NS-4	-	SP-20	2
43	48	1,693	1,890	NS-5	-	SP-20	2

LOCKING RANGES WITH OPTIONAL MICROSHAFT JAWS

RANGE [MM]		RANGE [INCH]		JAWS NR
MIN	MAX	MIN	MAX	
10,00	11,00	0,394	0,433	301 MM#36
11,00	12,00	0,433	0,472	303 MM#36
12,00	13,00	0,472	0,512	305 MM#36
13,00	14,00	0,512	0,551	307 MM#36
14,00	15,00	0,551	0,591	309 MM#36

MICROSHAFTS SHAFTS NUMBERS

SHAFT NUMBER	SIZE [INCH]	SIZE [MM]	SPRING
800 MM#151	0,354	9,00	O-7
801 MM#151	0,394	10,00	DW-8,5
805 MM#151	0,453	11,00	DW-10

LOCKING RANGES WITH OPTIONAL MINISHAFT JAWS

RANGE [MM]		RANGE [INCH]		JAWS NR
MIN	MAX	MIN	MAX	
12,40	14,50	0,488	0,571	201 MM#36
13,90	16,00	0,547	0,630	203 MM#36
15,90	18,00	0,626	0,709	205 MM#36
16,90	19,00	0,665	0,748	207 MM#36
18,90	21,00	0,744	0,827	209 MM#36
19,90	22,00	0,783	0,866	211 MM#36
20,90	23,00	0,823	0,906	213 MM#36
21,90	24,00	0,862	0,944	214 MM#36
23,60	25,60	0,929	1,008	215 MM#36
25,20	27,20	0,992	1,071	217 MM#36
26,80	28,80	1,055	1,134	219 MM#36
28,40	30,40	1,118	1,197	221 MM#36
30,00	32,00	1,181	1,260	223 MM#36
31,60	33,60	1,244	1,323	225 MM#36
33,20	35,20	1,307	1,386	227 MM#36
34,80	36,80	1,370	1,449	229 MM#36
36,40	38,40	1,433	1,512	231 MM#36
38,00	40,00	1,496	1,575	233 MM#36
39,60	41,60	1,559	1,638	235 MM#36
41,20	43,20	1,622	1,701	237 MM#36
42,80	44,80	1,685	1,764	239 MM#36
44,40	46,40	1,748	1,827	241 MM#36
46,00	48,00	1,811	1,890	243 MM#36

MINISHAFTS SHAFTS NUMBERS

TUBE OD	TUBE GAUGE	SHAFT NUMBER	SIZE [INCH]	SIZE [MM]	SPRING
3/4"	11	901 MM#151	12,40	0,492	DW-11
	11	911 MM#151	12,60	0,496	DW-11
	12	912 MM#151	13,20	0,519	DW-11
	13	905 MM#151	13,90	0,547	DW-12,5
	14	914 MM#151	14,50	0,570	DW-12,5
	15	9151 MM#151	15,10	0,594	DW-12,5
	16	916 MM#151	15,50	0,610	DW-12,5
	17	917 MM#151	15,80	0,622	DW-12,5
	18	918 MM#151	16,30	0,641	DW-15,5
	20	909 MM#151	16,80	0,661	DW-15,5
7/8"	10	9151 MM#151	15,10	0,594	DW-12,5
	11	917 MM#151	15,70	0,622	DW-12,5
	12	922 MM#151	16,40	0,645	DW-15,5
	13	923 MM#151	17,10	0,673	DW-15,5
	14	924 MM#151	17,70	0,696	DW-15,5
	15	925 MM#151	18,30	0,700	DW-15,5
7/8"	16	926 MM#151	18,60	0,732	DW-15,5
	18	928 MM#151	19,50	0,767	DW-15,5
1"	8	909 MM#151	16,80	0,661	DW-15,5
	9	938 MM#151	17,50	0,688	DW-15,5
	10	925 MM#151	18,30	0,700	DW-15,5
	11	931 MM#151	19,00	0,748	O-16
	12	932 MM#151	19,60	0,771	O-16
	13	915 MM#151	20,00	0,787	O-17
	14	934 MM#151	20,90	0,822	O-17
	16	936 MM#151	21,80	0,858	O-17
	18	938 MM#151	22,60	0,889	O-7

We do offer non-standard size and non-standard shaped jaws upon receiving a drawing of the tube expansion details. **As standard we deliver 3 shafts, numbers: 901, 905 and 909MM#151.**