

Porta-Mill ID Mounted End Prep Machine

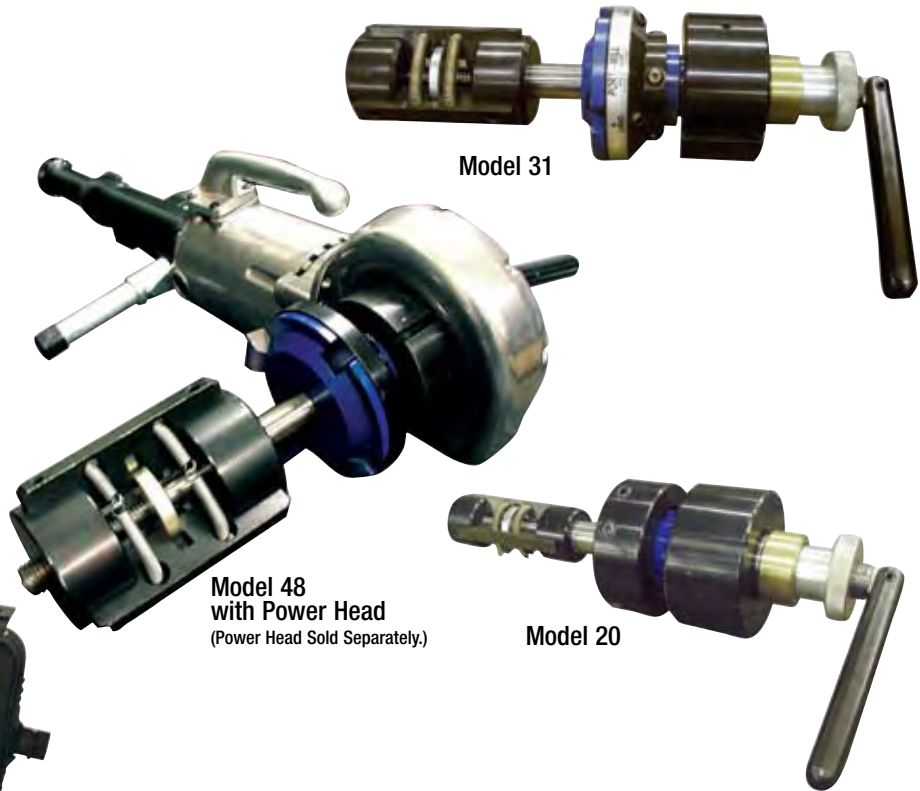
Porta-Mill End Prep Machine includes:

- Base Machine.
- Mandrels for pipe or tubing sizes within its range.
- Face and Beveling Tools for pipe or tubing sizes within its range.
- Torque Bar.
- 3/16" and 1/8" Wrench.
- Molded Polyurethane case.

DOES NOT INCLUDE:

- Power Drive.

Molded Polyurethane Case



Rugged and portable, the Porta-Mill End Prep is used to bevel, face or counterbore pipe ends. The Steel Mandrel Assembly of the Porta-Mill expands against the inside diameter of the pipe providing solid mounting for smoother accurate bevels. Inexperienced welders and pipefitters with little or no training can achieve precise bevels and lands in minutes. Porta-Mill's superior design makes it an exceptional performer having the utmost durability. Models are available for inside diameter from 1.6" / 41mm to 8.125" / 206mm and comes in durable urethane box.

Porta-Mill ID End Prep Machine

Model	Part Number	Pipe Inside Diameter Minimum - Maximum Cutting Range (in / mm)	Estimated Shipping Weight (lbs. / kg)
Model 20	05-2000-000	1.6 / 31 - 2.25 / 57	37 / 17
Model 31	05-3000-000	2.25 / 57 - 4.25 / 128	40 / 18
Model 48	05-4800-000	3.375 / 86 - 8.125 / 206	46 / 21

- **SAVE TIME**—The Porta-Mill precisely machines the pipe end assuring a better and faster fit-up.
- **BEVELS MOST MACHINEABLE MATERIALS**—such as carbon steel, stainless steel, ductile iron, cast iron and most other alloys without spark or flame.
- **FAST AND EASY SET-UP.**
- **VERSATILE**—Can be used with Rigid, Rothenburger, Amigo or Reed Powered Threading Tool Drives.
- An excellent tool for the maintenance department or the small job shop to bevel pipe **WITHOUT SPARK OR FLAME.**
- Completely **ELIMINATES NEED FOR GRINDING.**
- **DESIGNED** to withstand the abuse encountered during fabrication.
- **ECONOMICAL ALTERNATIVE** to the more expensive end prep machine.
- **NO WAITING** for costly cutting inserts as Porta-Mill utilizes standard carbide tipped brazed tool, that can be purchased from most industrial supplies.

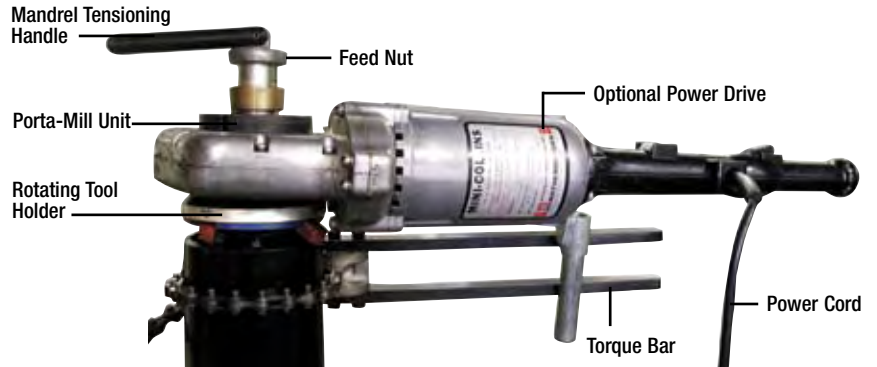
Porta-Mill ID Mounted End Prep Machine

Accessories:

- Beveling Tools for 30° Beveling Tool. (Available upon request.)
- "J" Prep Beveling Tools (Available on request.)
- Counterbore Tools for most configurations. (Available upon request.)

Power Drives:

- 115vac, 230vac and Pneumatic Power Drive Available.



Power Drives and Accessories

Model	Part Number	Estimated Shipping Weight (lbs. / kg)
Power Drive 115vac	05-5000-000	26 / 12
Power Drive 230vac	05-5000-230	26 / 12
Power Drive Pneumatic	05-5000-00A	29 / 13
Carrying Case	05-5000-BOX	8 / 3.6

Ideal for FAST set-up, facing and beveling of stainless steel and other non-ferrous pipes. The Power Drive is available in 115vac, 230vac and Pneumatic Models.

(Weights listed above do not include Power Drive.)


Porta-Mill Selection Chart

Item	(in / mm)	(in / mm)	(in / mm)	(in / mm)	(in / mm)	(in / mm)	(in / mm)	(in / mm)	(in / mm)	(in / mm)	(in / mm)
Nominal Pipe Diameter	1 1/2 / 38	2 / 51	2 1/2 / 26	3 / 76	3 1/2 / 89	4 / 102	4 1/2 / 114	5 / 127	6 / 152.4	7 / 177.8	8 / 203
Actual Pipe Outside Diameter	1.9 / 48	3 3/8 / 85.7	2 7/8 / 73	3 1/2 / 73	4 / 102	4 1/2 / 114.3	5 / 127	5 9/16 / 141.3	6 5/8 / 168.3	7 5/8 / 193.7	8 5/8 / 219
Pipe Schedule	Pipe Inside Diameter (in / mm)										
5	1.770 / 45	2.245 / 57	2.709 / 68.8	3.334 / 84.7	3.834 / 97.4	4.334 / 110.1	----	5.345 / 135.8	----	6.407 / 162.7	8.407 / 213.5
10	1.682 / 2.7	2.157 / 54.8	2.635 / 67	3.260 / 82.8	3.760 / 95.5	4.260 / 108.2	----	5.295 / 134.5	----	6.357 / 161.5	8.329 / 211.6
40	1.610 / 40.9	2.067 / 52.5	2.469 / 62.7	3.068 / 78	3.548 / 90	4.026 / 102.3	----	5.047 / 128.2	----	6.065 / 154.1	7.981 / 202.7
Std.	1.610 / 40.9	2.067 / 52.5	2.469 / 62.7	3.068 / 78	3.548 / 90	4.026 / 102.3 4.506 / 114.5	5.047 / 128.2	7.023 / 178.4	6.065 / 154.1	7.913 / 198.5	
80	1.500 / 38.1	1.939 / 49.3	2.323 / 59	2.900 / 73.7	3.304 / 85.4	3.626 / 97.2	----	4.814 / 122.3	----	5.761 / 146.3	7.025 / 178.4
E.H.	1.500 / 38.1	1.939 / 49.3	2.323 / 59	2.900 / 73.7	3.364 / 85.4	3.826 / 97.2	----	4.813 / 122.3	----	7.625 / 193.7	
120	----	----	----	----	3.624 / 92	----	4.563 / 116	----	5.501 / 139.7	7.187 / 182.5	
160	1.338 / 34	1.687 / 42.8	2.125 / 54	2.624 / 66.6	----	3.438 / 69.3	----	4.313 / 109.6	----	5.187 / 131.7	6.813 / 173
XX	1.1 / 28	1.503 / 38	1.771 / 45	2.3 / 54.8	2.728 / 69.3	3.152 / 80	3.58 / 91	4.063 / 103.2	5.875 / 149.2	4.897 / 124.4	6.875 / 164.6
	Model 20										
	Model 31										
	Model 48										
	Model 31 or 48										

Porta-Mill Accessories


Cutting Tools

Porta-Mill Facing Tool



Model	Pipe Inside Diameter (in / mm)	Part Number	Estimated Shipping Weight (lbs. / kg)
20	1.6" - 2.25" / 41mm - 57mm	03-2000-009	.2 / .09
31	3" / 76mm	03-3100-009	.2 / .09
	4" / 102mm	03-4800-009	.25 / .11
48	4" / 102mm	03-4800-009	.25 / .11
	6" / 152mm	03-4800-011	.3 / .14
	8" / 203mm	03-4800-013	.4 / .18

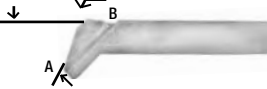
37 1/2° Porta-Mill Beveling Tool



Model	Pipe Inside Diameter (in / mm)	Part Number	Estimated Shipping Weight (lbs. / kg)
20	1.6" - 2.25" / 41mm - 57mm	03-2000-008	.2 / .09
31	3" / 76mm	03-3100-008	.2 / .09
	4" / 102mm	03-4800-008	.25 / .11
48	4" / 102mm	03-4800-008	.25 / .11
	6" / 152mm	03-4800-010	.3 / .14
	8" / 203mm	03-4800-012	.4 / .18

Porta-Mill Counter Bore Tool


Please check the desired Transition Angle and Radius.



Model	Pipe Inside Diameter (in / mm)	Transition Angle (A)	Radius at Transition (B)
20	1.6-2.25 / 41-57	5	0.015
		10	0.20
		15	0.30
31	3 / 76 4 / 102	5	0.015
		10	0.20
		15	0.30
48	4 / 102	5	0.015
	6 / 152	10	0.20
	9 / 203	15	0.30

Porta-Mill "J" Prep Tool

Please check the desired Transition Angle and Radius.



Model	Pipe Inside Diameter (in / mm)	Transition Angle (A)	Radius at Transition (B)
20	1.6-2.25 / 41-57	5	0.015
		10	0.20
		15	0.30
31	3 / 76 4 / 102	5	0.015
		10	0.20
		15	0.30
48	4 / 102	5	0.015
	6 / 152	10	0.20
	9 / 203	15	0.30

ORDERING INFORMATION

J Prep Beveling Blades

1. Length of Land _____
2. Bevel Angle _____
3. Radius at Point Land Meets Beveling Angle _____

Beveling Blades - if other than 30° or 37 1/2°

1. Pipe Outside Diameter _____
2. Pipe Wall Thickness _____
3. Bevel Angle _____
4. 2nd Bevel Angle if Compound Bevel _____
5. Height of Second Bevel _____

Counter Boring Tools

1. Length of Land _____
2. Bevel Angle _____
3. Radius at Point Land Meets Beveling Angle _____