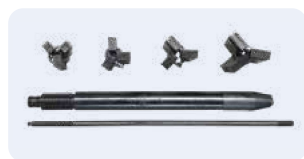


# MiniMill 101

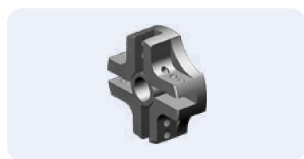
The MiniMill 101 is a rugged, fast, portable weld end preparation lathe designed for various tubes and pipes, including stainless steel and other high chromium materials. Our standard machine can be used for pipe sizes of 20 - 74 mm i.d. (0.787" - 2.913") and comes with a 88 mm cutting head.

## STANDARD SET UP



### SHAFT25

Self-align, heavy duty locking system. Shafts and jaws are longer and wider to ensure maximum clamping force.



### 88 MM (3,46")

The popular, medium cutter head, designed to fasten the wide range of cutting inserts.



Heavy duty locking system



### IMPORTANT!

Read how to properly lock on page 58

| STANDARD WORKING RANGE |        |                         |  | TOTAL WORKING RANGE |        |                |  |
|------------------------|--------|-------------------------|--|---------------------|--------|----------------|--|
| APPLICATION RANGE      |        | LOCKING RANGE           |  | APPLICATION RANGE   |        | LOCKING RANGE  |  |
| 25 – 89 mm             |        | 25 – 77 mm              |  | 10 – 107 mm         |        | 10 – 102 mm    |  |
| 0,984 – 3,504"         |        | 0,984 – 3,031"          |  | 0,394 – 4,213"      |        | 0,394 – 4,016" |  |
| FEED STROKE            |        | POWER                   |  | FREE SPEED          |        | TORQUE         |  |
| 20 mm                  | 0,787" | 1,3 hp                  |  | 100 rpm             | 140 Nm | 105 Ft.lbs     |  |
| 55 cfm                 |        | 1,3 m <sup>3</sup> /min |  | 13,1"               | 335 mm | 11,4 Lbs       |  |
|                        |        | 2,32"                   |  | 59 mm               |        | 5,2 kg         |  |

## MINIMILL 101E

MiniMill 101E is electric version of MiniMill 101. A standard machine cover the same pipe sizes and comes with the same cutting head. The electric motor made by Makita with 3 stage planetary gear box made by KRAIS has variable speed control and produce enormous torque. Is interchangeable with pneumatic drive and can be purchased separately at any time.

Free Speed ..... 115 RPM  
 Power..... 750 W  
 Torque ..... 366 NM (280 Ft.Lbs)  
 Feed Stroke ..... 20 mm (0,787")



## AUTOMINIMILL 101

Auto MiniMill 101P is a fully automatic machine, controlled by a built-in, fully pneumatic control box, with adjustable feed rate and actuated by a hand button (foot switch optional). Ideal for repetitive work cycles on condensers and heat exchangers, as well as for bevelling and facing boiler tubes.

# MiniMill 101

## OPTIONAL HEADS



### 60 MM (2,36")

The smallest cutter head, designed to fasten the wide range of cutting inserts.



### 106 MM (4,56")

The popular, large cutter head, designed to fasten the wide range of cutting inserts.



### OBMH

Head for bevelling tubes without membranes in the boiler water walls.

→ TABLE PAGE 108



### SWROTC

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

→ TABLE PAGE 109



### STWRMH

Head dedicated for strength weld removal. Heads are easy to align and sized per tube diameter.

→ TABLE PAGE 107



### TFMH

Tube facing milling head for tubes made of any type of material. Utilizes 6% cobalt inserts.

→ TABLE PAGE 107

## OPTIONAL SHAFTS



### MICROSHAFT

A system with interchangeable guide shafts. A complete set covers 10,0 to 15,0 mm ID tubes.



### MINISHAFT

A system with interchangeable guide shafts. A complete set covers 12,4 to 48,0 mm ID tubes.

## OTHER OPTIONAL ACCESSORIES



### RATCHET FEED

Feed system allowing to work in narrow and tight locations, eg. in water walls.



### FAST CLAMPING SYSTEM

System offers rapid tube to tube cycle time, increased productivity (up to 4x) with little operator fatigue. Ideal for large amount of end preps.



### SPEED REDUCER

Easy to use gearbox for 3x speed reduction. Increases the torque, enabling the machine to generate a thick chip whilst reducing the cutting time.

## STANDARD MINIMILL 101 LOCKING RANGES

### WITH SHAFT25

| SHAFT   | JAWS | EXT.  | RANGE [MM] |     | RANGE [INCH] |       | SPRING |      |
|---------|------|-------|------------|-----|--------------|-------|--------|------|
|         |      |       | MIN        | MAX | MIN          | MAX   | NO.    | QTY. |
| SHAFT25 | NS-1 | -     | 25         | 30  | 0,984        | 1,181 | SP-24  | 1    |
|         | NS-2 | -     | 30         | 35  | 1,181        | 1,378 | SP-24  | 1    |
|         | NS-3 | -     | 35         | 40  | 1,378        | 1,575 | SP-25  | 2    |
|         | NS-4 | -     | 40         | 45  | 1,575        | 1,772 | SP-25  | 2    |
|         | NS-5 | -     | 45         | 50  | 1,772        | 1,969 | SP-25  | 2    |
|         | NS-6 | -     | 50         | 55  | 1,969        | 2,165 | SP-25  | 2    |
|         | NS-7 | -     | 55         | 60  | 2,165        | 2,362 | SP-25  | 2    |
|         | NS-8 | -     | 60         | 65  | 2,362        | 2,559 | SP-25  | 2    |
|         | NS-5 | NS-10 | 62         | 67  | 2,441        | 2,638 | SP-25  | 2    |
|         | NS-6 | NS-10 | 67         | 72  | 2,638        | 2,835 | SP-25  | 2    |
|         | NS-7 | NS-10 | 72         | 77  | 2,835        | 3,031 | SP-25  | 2    |

### OPTIONAL MINIMILL 101 LOCKING RANGES

### WITH SHAFT25

| SHAFT   | JAWS | EXT.  | RANGE [MM] |     | RANGE [INCH] |       | SPRING |      |
|---------|------|-------|------------|-----|--------------|-------|--------|------|
|         |      |       | MIN        | MAX | MIN          | MAX   | NO.    | QTY. |
| SHAFT25 | NS-8 | NS-10 | 77         | 82  | 3,031        | 3,228 | SP-25  | 2    |
|         | NS-5 | NS-20 | 82         | 87  | 3,228        | 3,425 | SP-25  | 2    |
|         | NS-6 | NS-20 | 87         | 92  | 3,425        | 3,622 | SP-25  | 2    |
|         | NS-7 | NS-20 | 92         | 97  | 3,622        | 3,819 | SP-25  | 2    |
|         | NS-8 | NS-20 | 97         | 102 | 3,819        | 4,016 | SP-25  | 2    |
|         | NS-5 | NS-30 | 102        | 107 | 4,016        | 4,213 | SP-25  | 2    |

### WITH SHAFT20

| SHAFT   | JAWS | EXT. | RANGE [MM] |     | RANGE [INCH] |       | SPRING |      |
|---------|------|------|------------|-----|--------------|-------|--------|------|
|         |      |      | MIN        | MAX | MIN          | MAX   | NO.    | QTY. |
| SHAFT20 | NS-0 | -    | 20         | 24  | 0,787        | 0,945 | SP-19  | 1    |
|         | NS-1 | -    | 24         | 28  | 0,945        | 1,102 | SP-19  | 1    |

### WITH MINISHAFT

| SHAFT     | SIZE   |       | JAWS      | RANGE [MM] |       | RANGE [INCH] |       | SPRING  |
|-----------|--------|-------|-----------|------------|-------|--------------|-------|---------|
|           | [INCH] | [MM]  |           | MIN        | MAX   | MIN          | MAX   |         |
| 901MM#151 | 0,492  | 12,40 | 201MM#36  | 12,40      | 14,50 | 0,488        | 0,571 | DW-11   |
| 905MM#151 | 0,547  | 13,90 | 203 MM#36 | 13,90      | 16,00 | 0,547        | 0,630 | DW-12,5 |
| 909MM#151 | 0,661  | 16,90 | 205 MM#36 | 15,90      | 18,00 | 0,626        | 0,709 | DW-15,5 |
|           |        |       | 207 MM#36 | 16,90      | 19,00 | 0,665        | 0,748 |         |
|           |        |       | 209 MM#36 | 18,90      | 21,00 | 0,744        | 0,827 |         |
|           |        |       | 211 MM#36 | 19,90      | 22,00 | 0,783        | 0,866 |         |
|           |        |       | 213 MM#36 | 20,90      | 23,00 | 0,823        | 0,906 |         |
|           |        |       | 214 MM#36 | 21,90      | 24,00 | 0,862        | 0,944 |         |

### WITH MICROSHAFT

| SHAFT     | SIZE   |       | JAWS     | RANGE [MM] |       | RANGE [INCH] |       | SPRING |
|-----------|--------|-------|----------|------------|-------|--------------|-------|--------|
|           | [INCH] | [MM]  |          | MIN        | MAX   | MIN          | MAX   |        |
| 800MM#151 | 0,354  | 9,00  | 301MM#36 | 10,00      | 11,00 | 0,394        | 0,433 | DW-7,5 |
| 801MM#151 | 0,394  | 10,00 | 303MM#36 | 11,00      | 12,00 | 0,433        | 0,472 | DW-8,5 |
| 805MM#151 | 0,453  | 11,50 | 305MM#36 | 12,00      | 13,00 | 0,472        | 0,512 | DW-10  |
|           |        |       | 307MM#36 | 13,00      | 14,00 | 0,512        | 0,551 |        |
|           |        |       | 309MM#36 | 14,00      | 15,00 | 0,551        | 0,591 |        |