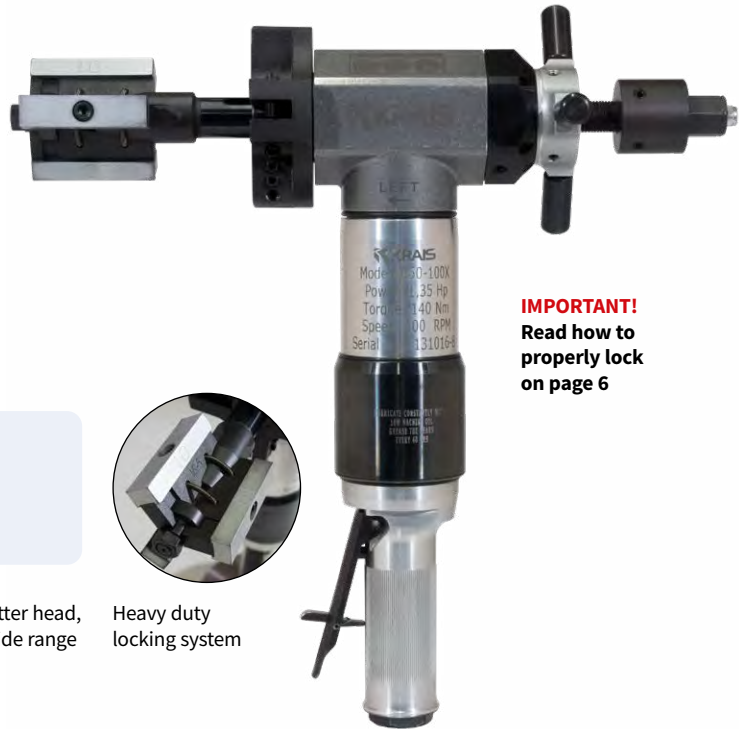


## MiniMill 101

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.

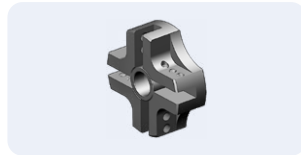


**IMPORTANT!**  
Read how to properly lock on page 6

### 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

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	2,32"	59 mm	13,1"	335 mm	11,4 Lbs	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.

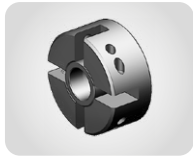
Free Speed ..... 115 RPM  
Power..... 750 W  
Torque ..... 366 NM (280 Ft.Lbs)  
Feed Stroke ..... 20 mm (0,787")



### 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.

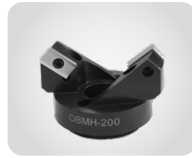
**OPTIONAL HEADS**



**60 MM (2,36")**  
The smallest cutter head, designed to fasten the wide range of cutting inserts.



**106 MM (4,16")**  
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 84



**SWOTC**  
Seal weld removal head over tube circumference prior to re-welding the damaged joint without removing the tube.  
→ TABLE PAGE 85



**STWRMH**  
Head dedicated for strength weld removal. Heads are easy to align and sized per tube diameter.  
→ TABLE PAGE 83



**TFMH**  
Tube facing milling head for tubes made of any type of material. Utilizes 6% cobalt inserts.  
→ TABLE PAGE 83

**OPTIONAL SHAFTS**



**MICRSHAFT**  
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
			205 MM#36	15,90	18,00	0,626	0,709	DW-15,5
909MM#151	0,661	16,90	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 MICRSHAFT**

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
			305MM#36	12,00	13,00	0,472	0,512	DW-10
805MM#151	0,453	11,50	307MM#36	13,00	14,00	0,512	0,551	
			309MM#36	14,00	15,00	0,551	0,591	