

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. The machine is offered in two options:

- **MiniMill 101SM**, for general use, can be used for pipe sizes of 20 - 74 mm i.d. (0.787" - 2.913") and comes with an 88 mm cutting head.
- **MiniMill 101SMSS** version is specialized for machining tubes in heat exchanger applications.

STANDARD SET UP



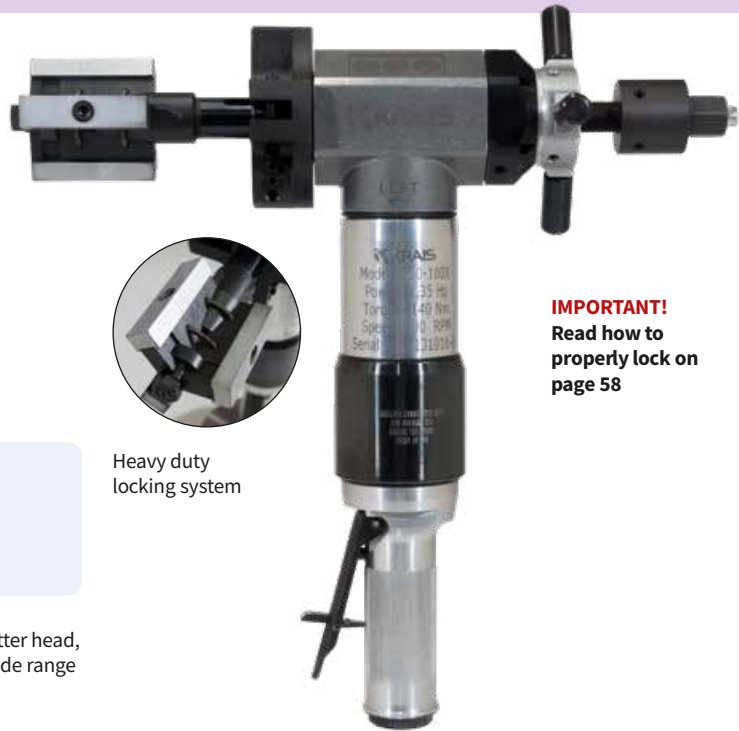
SHAFT25

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.



IMPORTANT!
Read how to properly lock on page 58

Heavy duty locking system

MINIMILL 101SM				MINIMILL 101SMSS			
WORKING RANGE		TOTAL WORKING RANGE		WORKING RANGE		TOTAL WORKING RANGE SS	
APPLICATION	LOCKING	APPLICATION	LOCKING	APPLICATION	LOCKING	APPLICATION	LOCKING
25 – 89 mm	25 – 77 mm	10 – 107 mm	10 – 102 mm	12,4 – 38,0 mm	12,4 – 24,0 mm	10 – 51 mm	10 – 48 mm
0,984 – 3,504"	0,984 – 3,031"	0,394 – 4,213"	0,394 – 4,016"	0,488 – 1,496"	0,488 – 0,945"	0,394 – 2,008"	0,394 – 1,890"
FEED STROKE		POWER		FREE SPEED		TORQUE	
20 mm	0,787"	1,3 hp		100 rpm		140 Nm	105 Ft.lbs
AIR USE		BODY WIDTH		BODY HEIGHT		BODY WEIGHT	
55 cfm	1,3 m ³ /min	2,32"	59 mm	13,1"	335 mm	11,4 Lbs	5,2 kg

STANDARD MINIMILL 101 LOCKING RANGES

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 JAWS

We deliver machines with selected shaft and set of jaws (below). For more locking options please refer to page 86

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.

MiniMill 101

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 116



SWROTC

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

→ TABLE PAGE 117



STWRMH

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

→ TABLE PAGE 115



TFMH

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

→ TABLE PAGE 115

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.

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.

Model ED-230-MM
Free Speed 115 RPM
Power 750 W
Torque 366 NM (280 Ft.Lbs)
Feed Stroke 20 mm (0,787")



AUTOMINIMILL 101P

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.