

# Tube Weasel

# MILLHOG®

Right Angle I.D. Clamping Beveling Tool  
0.750" I.D. to 3.0" O.D.  
19.1 mm I.D. to 76.2 mm O.D.

**Agile, fits between waterwall boiler tubes and ruggedly built**

## Key Features

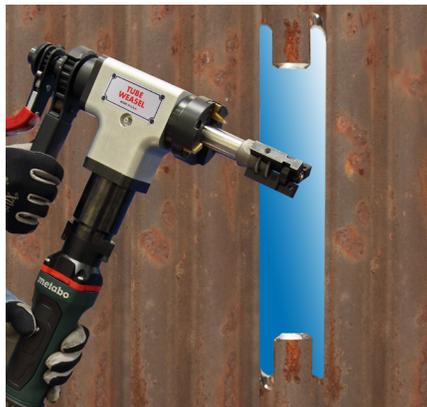
- Fits 2.75" (69.85mm) wide opening for boiler tube Dutchman repair
- Self centering clamping system rigidly mounts tool to tube I.D. and is easy to use
- Pneumatic, electric or battery motors available and are easily interchanged.
- Bevel, face and bore simultaneously
- Sealed construction allow use in any orientation
- EscoLock blade lock system securely holds cutter blades
- Torque-free operation
- Chatter-free tube and pipe bevels enhance quality welds
- Field proven by boilermakers from around the world

## Performs precision bevels on all tube and pipe alloy

The boilermaker proven Tube Weasel MILLHOG® performs precision bevels for accurate weld fit-up and fits a 2.75" wide opening. Extremely durable, it features a right angle gear drive system which incorporates dual opposed tapered roller bearings. This compact tube beveling tool can be powered by pneumatic, electric or battery motors that are easily interchanged and equally powerful.

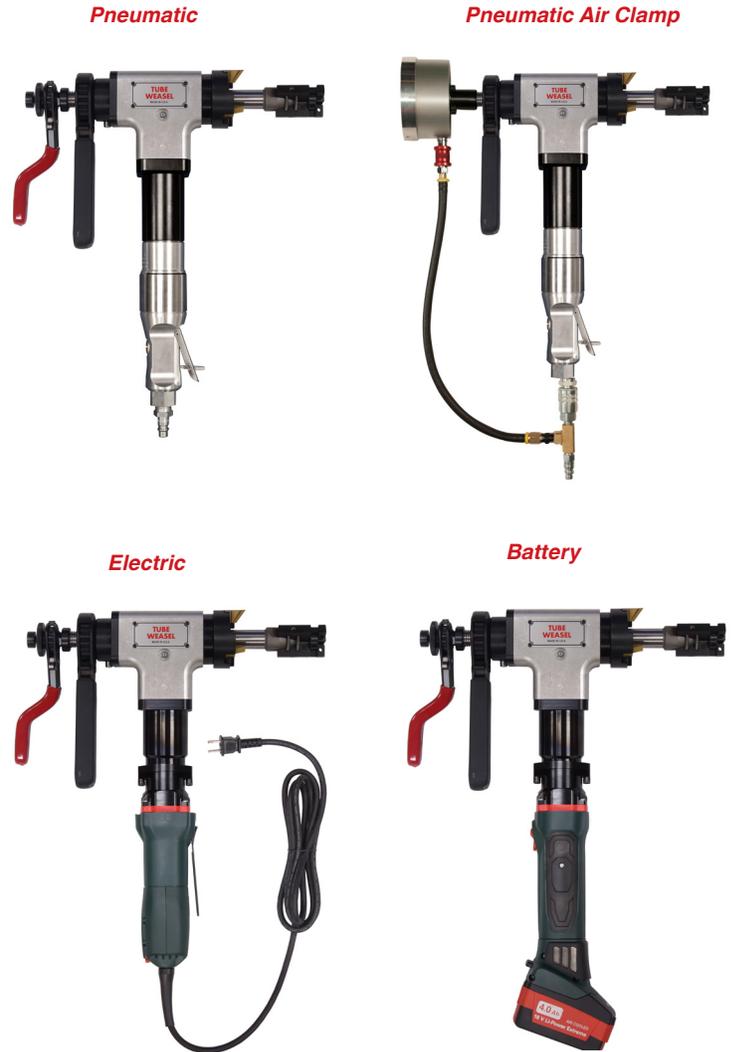
The Tube Weasel MILLHOG® uses the EscoLock cutter blade locking system that securely holds the cutter blade in the cutterhead. Cutter blades have a radical chip breaker that directs the chip away from the tubes surface and minimizes heat build-up.

These innovative design feature are why MILLHOG® Cutter Blades produce precision bevels on tube and pipe without cutting fluids.



The Tube Weasel is 2.75" wide and can bevel a single tube in a boiler tube waterwall for Dutchman repair.

The Air Clamp instantly clamps and releases the tool to the tube and pipe I.D. which saves a time by reducing the cycle time between tube bevels.



Like all MILLHOG® tools, the Tube Weasel Gear Head is built with the finest materials that are precision machined and heat treated for long reliable service. Operational wrenches are attached for fast set-up and the clamping components are designed to not separate and fall into the tube.

The three available motors are interchangeable and can be conveniently switched for working in a variety of venues.

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The 1.25" is the standard mandrel, The 1.0" and 0.75" mandrels can be substituted or ordered as optional equipment. The 0.75" mandrel uses the TW-242 cutterhead.

## Tube Weasel Clamp Rib Selector and corresponding spares Mandrel, Draw Rod, Actuator, Roll Pin, Retention Band and Springs



Clamp Rib Set	I.D. Range		Mandrel		Draw Rod	Actuator	Roll Pin	Retention		
	in	mm	Part #	Size				Band	Spring	
G-03A	.750	.905	19.1	22.9	H-241	.750	H-247	G-17	G-15	G-14F
G-04	.875	1.030	22.3	26.1	H-241	.750	H-247	G-17	G-15	G-14
G-05	1.000	1.155	25.4	29.3	H-241	.750	H-247	G-17	G-15	G-14
G-06	1.125	1.280	28.6	32.5	H-241	.750	H-247	G-17	G-15	G-14
G-07	1.250	1.405	31.8	35.6	H-241	.750	H-247	G-17	G-15	G-14
G-08	1.375	1.530	35.0	38.8	H-241	.750	H-247	G-17	G-15	G-14
G-09	1.500	1.655	38.1	42.0	H-241	.750	H-247	G-17	G-15	G-14
G-10	1.625	1.780	41.3	45.2	H-241	.750	H-247	G-17	G-15	G-14
G-11	1.750	1.905	44.5	48.3	H-241	.750	H-247	G-17	G-15	G-14
G-12	1.875	2.030	47.7	51.5	H-241	.750	H-247	G-17	G-15	G-14
G-13	2.000	2.155	51.0	54.7	H-241	.750	H-247	G-17	G-15	G-14
H-00	1.000	1.300	25.4	33.0	H-220	1.00	H-51	H-12A	H-11	H-14A
H-01	1.250	1.600	31.8	40.6	H-21	1.25	H-51	H-12	H-11	H-14B
H-02	1.525	1.925	28.8	48.9	H-21	1.25	H-51	H-12	H-11	H-14B
H-03	1.850	2.250	47.0	57.2	H-21	1.25	H-51	H-12	H-11	H-14B
H-04	2.175	2.575	55.3	65.4	H-21	1.25	H-51	H-12	H-11	H-14B
H-05	2.500	2.900	63.5	73.7	Attaches to H-02					



0.750" Mandrel, Draw Rod, Actuator and roll pin TW-241, H-247, G-17, G-15.

1.0" Mandrel, 1.25" Mandrel, Draw Rod, Actuators and Roll Pin H-220, H-21, H-51, H12A, H-12, H-11.

Retention Band and Springs G-14F, G-14, G-14A and G14B.



Cutterheads hold 3 Cutter Blades for bevel, face and bore simultaneously

2.75" for use with 0.75" Mandrel

2.75" for use with 1.25" Mandrel

3.0" for use with 1.25" Mandrel

## Tube Weasel Cutterhead Blade Lock and Screws

Cutterhead Part #	Cutterhead Size	Mandrel		Blade Lock		Lock Screw	
		Part #	Size	Part #	Per Head	Part #	Per Lock
TW-242	2.750	H-241	.750	TW-22B	6	TW-23	1
TW-24	2.750	H-220 & H-21	1.00 & 1.25	TW-22A	6	TW-23	1
TW-21	3.000	H-220 & H-21	1.00 & 1.25	TW-22B	6	TW-23	1

Blade Locks and Lock Screw TW-22A, TW-22B and TW-23



All MILLHOG® Cutter Blades are made of T-15 High Speed Tool Steel, the most shock and heat resistant Tool Steel available and produce a Thick Chip without cutting fluids on high alloy pipe and tube.

## Thick Chip Technology Promotes Long Cutter Blade life

MILLHOG® Cutter Blades have a radical chip breaker that directs the chip away from the tube or pipe surface and minimizes heat build-up on the cutting edge. Cutter Blades are offered with two coating choices for ultimate performance.

- Titanium Nitride Coated (TiN) adds lubricity and helps the Cutter Blades prep cooler.
- Hard Lube Coating offers additional heat resistance which extends Cutter Blade life on Super Duplex

## Specifications: Tube Weasel MILLHOG®

Working Range	.750 in (19.1 mm) i.d. to 3 in (76.2 mm) o.d.			
Motor	Pneumatic	Electric	Battery / *Charger	Air Clamp
	1.07 hp (800 W) 90 psi (6.2 bar) 35 cfm (990 lt/min) 117 rpm	120 V 8.5 A 50/60 Hz 950 W, or 220 - 240 V 4.4 A 50/60 Hz 950 W	18V Li-Ion - up to 5.2 Ah *115V / 60 Hz, or *220 - 240 V 50-60 Hz 45 rpm	1.07 hp (800k W) 90 psi 6.2 bar 35 cfm 990 lt/min 117 rpm
Speed		14 rpm - 62 rpm		
Minimum Clearance				
With 3 in (76.2 mm) Cutterhead	3 in (76.2 mm)	3 in (76.2 mm)	3 in (76.2 mm)	4.5 in (114.3 mm)
With 2.75 in (69.85 mm) Cutterhead	2.75 in (69.85 mm)	2.75 in (69.85 mm)	2.75 in (69.85 mm)	4.5 in (114.3 mm)
Head Length	15.25 in (387.4 mm)	15.25 in (387.4 mm)	15.25 in (387.4 mm)	17.5 in (470 mm)
Working Weight	14.8 lbs (6.7 kg)	15.9 lbs (7.21 kg)	16.4 lbs (7.44kg)	17.1 lbs (7.75 kg)
Shipping Weight	32.05 lbs (14.53 kg)	40 lbs (18.14 kg)	40.6 lbs (18.41 kg)	41.95 lbs (19.02 kg)
Shipping Dimensions	20 in x 18 in x 5 in 508 mm x 457 mm x 127 mm	24 in x 20 in x 6 in (610 mm x 508 mm x 152 mm)	24 in x 20 in x 6 in (610 mm x 508 mm x 152 mm)	24 in x 20 in x 7 in (610 mm x 508 mm x 178 mm)